

APPLICATION SPECIFICATION

RETAINING CLIP TERM. FOR SINGLE RUBBER SEAL

SCOPE

This specification covers the requirements for application of **RETAINING CLIP TERM.** P/N 282270-1 for single **RUBBER SEAL** P.N. 828905-1

GENERAL

**THESE RETAINING CLIPS** are suitable for **EXTERNAL DIA 25mm AND INTERNAL DIA 1,5mm TUBE, WITH SINGLE RUBBER SEAL**

Each **TUBE** is inserted into a discrete **RUBBER SEAL** before being crimped into the **RETAINING CLIP TERM.**

The insulation barrel is crimped so that the **RUBBER SEAL** is gripped in order to avoid any movement of the seal.

**THE RETAINING CLIPS** are suitable for single **TUBE** only.

1. CRIMPING

The following information contains nomenclature, crimping conditions, crimp data for mini-applicators, insertion of **RUBBER SEALS ON TUBES** mending or replacement of parts and checks.

THIS INFORMATION IS CONFIDENTIAL AND IS DISCLOSED TO YOU ON CONDITION THAT NO FURTHER DISCLOSURE IS MADE BY YOU TO OTHER THAN AMP PERSONNEL WITHOUT WRITTEN AUTHORIZATION FROM AMP ITALIA S.p.A.

TEC 034 2.83

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		APP. S. SERRA 09.03.92		LOC I	NO 114-20054
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DIST.	A	REVISED PER E.C.N.I. 23-3-92	SHEET 1 OF 6	NAME APPLICATION SPECIFICATION FOR RETAINING CLIP WITH RUBBER SEAL	
REV LTR		REVISION RECORD	DR E.C.N.I.	DATE	

## 1.1 NOMENCLATURE

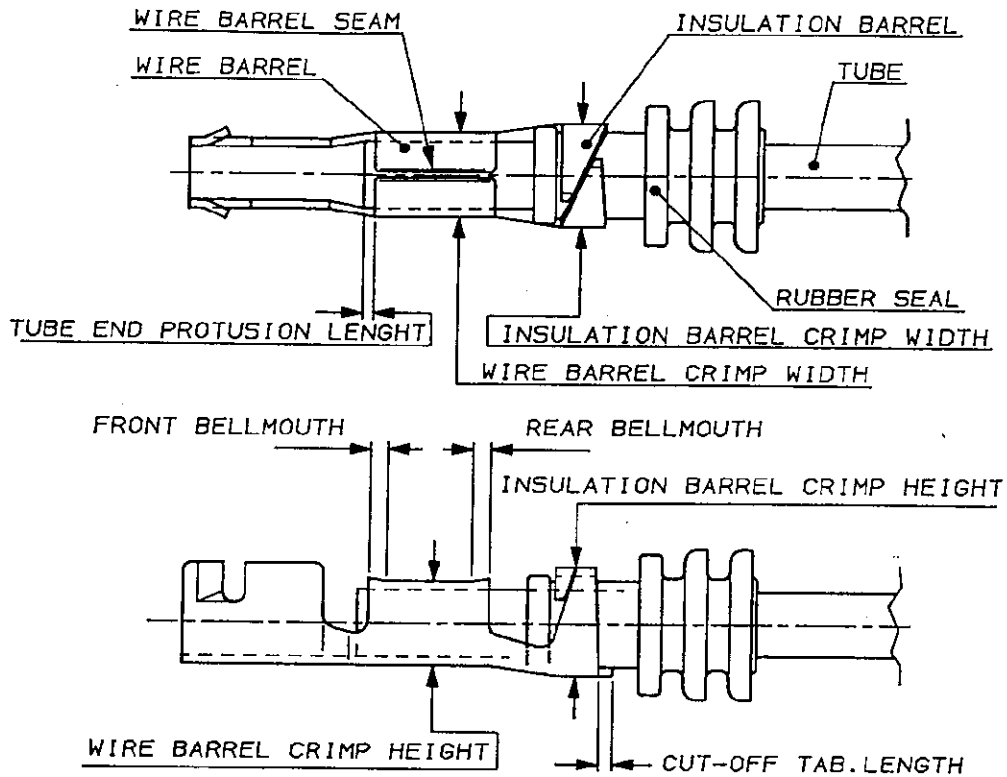


FIG. 1

## 2. CRIMPING CONDITIONS

Refer to nomenclature (Par. 1.1) see Fig. 1  
Fig. 2 and Fig. 3.

- |   |                    |
|---|--------------------|
| 1. Cut-off tab length                           | 0,3 mm max         |
| 2. Front bellmouth                              | 0,25 mm x 45° min. |
| Rear bellmouth                                  | 0,35 mm x 60° min. |
| 3. Bend up                                      | 5° max             |
| Bend down                                       | 5° max             |
| Bend right                                      | 5° max             |
| Bend left                                       | 5° max             |
| Rolling   | 5° max             |
| 4. <b>TUBE</b> end protrusion<br>(brush length) | 1,2 to 1,5 mm      |
| 5. Wire barrel seam must be neatly closed.      |                    |

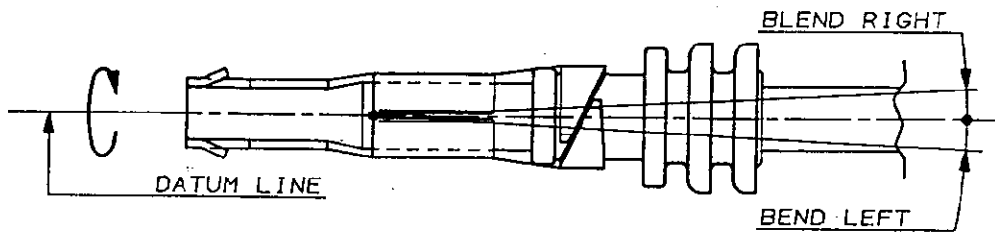


Fig. 2

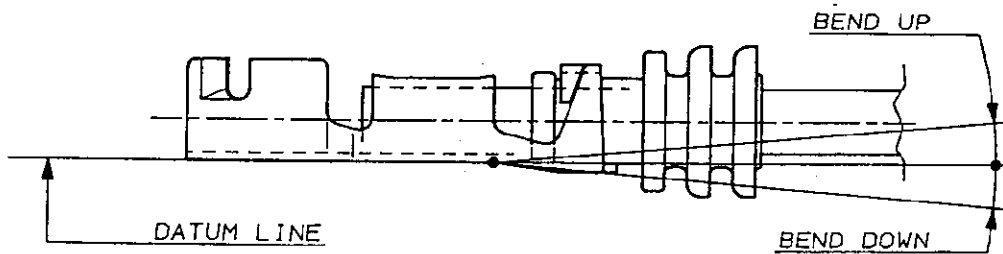


Fig. 3

3. CRIMP DATA

3.1 For applicator crimping see Fig. 7.

4. INSERTION OF RUBBER SEAL ON THE TUBE

When the rubber seal is installed on **TUBE**, the end of the **TUBE** shall be positioned from the edge of the rubber seal, as shown in Fig. 4. This length is usually regardless of cable size.

NOTE: Seals are supplied lubricated. This lubrication must not be removed.

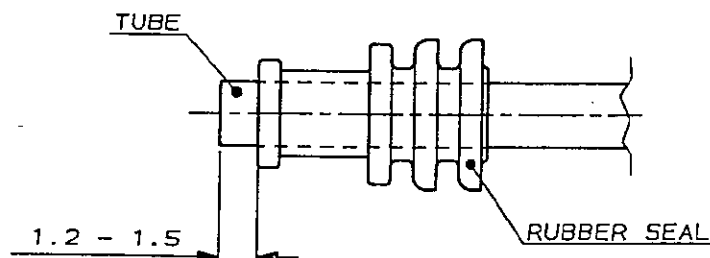


FIG. 4

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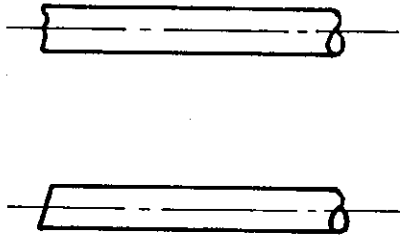
3 OF 6

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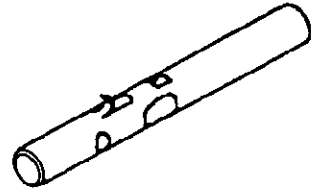
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5. CORRECTION OR REPLACEMENT OF PARTS

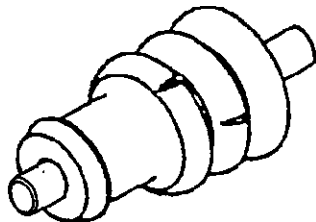
When defects and/or improper applications are found on parts to be installed, as shown in Fig. 5, rework to set up properly, or replace with new part.



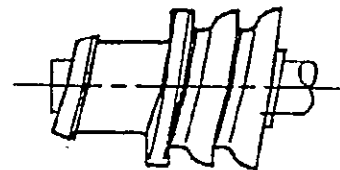
The end of the cut **TUBE** shall appear neat



The **TUBE** must have smooth surface in a round form without damage, groove or recessed surface.



The flanges of the rubber seal shall be free from cut and damage.  
Any seal having such defects shall be discarded, and replaced with new part.



Insertion of rubber seal shall be done straighty and evenly. If flanges are in tilt condition, the plug must be corrected so that flanges are perpendicular to contact center line.

Fig. 5

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4 of 6

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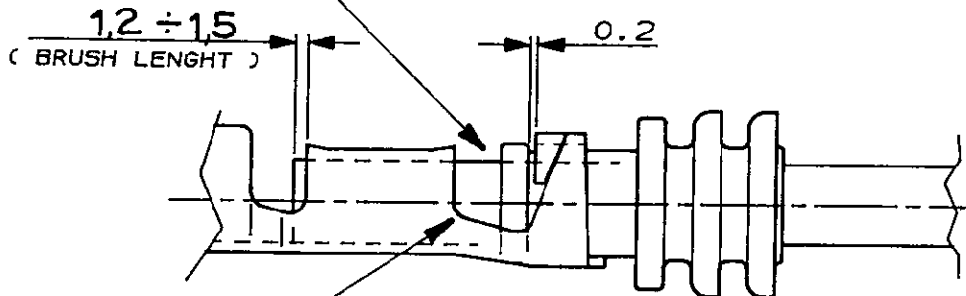
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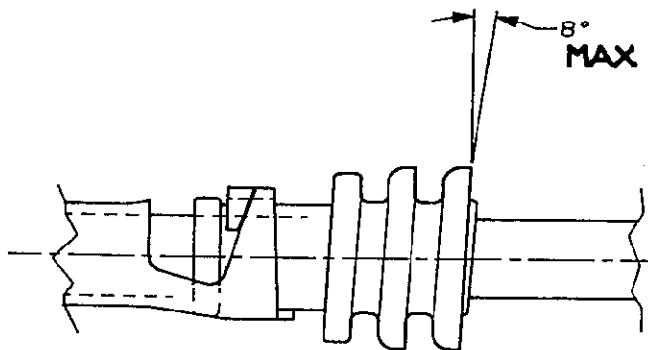
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5.1 After crimping, the part of the **TUBE** that is inside the seal shall be in good condition and within the requirements shown in Figure 5.

After crimping, the rubber seal must protrude from the insulation crimp without any damage



After crimping no parts of rubber **SEAL** in the wire crimp is allowed



Tilt shape of rubber **SEAL** is not allowed

Fig. 6

5.2 Crimped contacts should appear as illustrated in Par. 1.1 (Nomenclature).

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5 OF 6

NO

114-20054

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(Dimensions are in mm)

PART.No.	MAX. TUBE OUTSIDE DIA.	RUBBER SEAL	WIRE BARREL CRIMP			INS. BARREL CRIMP	
			HEIGHT ±0,03	WIDTH (REF.)	TYPE	WIDTH (REF.)	TYPE
282270 -1	2,5mm RILSAN	828905-1	2,46	2,79 <sup>+0,15</sup> <sub>-0</sub>	"0"	3,81 <sup>+0,30</sup> <sub>-0</sub>	"0"

Fig. 7

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6 OF 6

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