

APPLICATION SPECIFICATION

1. SCOPE

This specification covers the requirements for application of the AMP* carbon brush contacts. These requirements are applicable to automatic machine crimping tools. For specific wire ranges relative to the products covered in this specification see Figure 2.

2. NOMENCLATURE

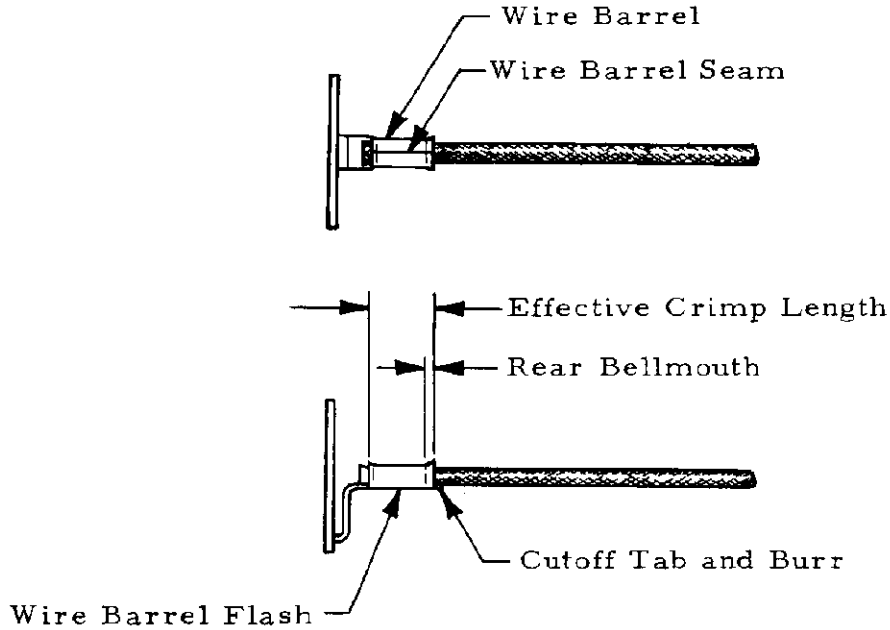


Figure 1

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1. Carrier Cutoff Tab and Burr

A. Cutoff Tab

Cutoff tab shall not exceed .015.

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				DR <i>Thomas L. Christner</i> 12-11-84	AMP AMP INCORPORATED Harrisburg, Pa. 17105				
				CHK <i>P. J. ...</i> 12/10/84					
				APP <i>W. H. ...</i> 12/11/84		LOC B	NO 114-2093	REV 0	
C				SHEET	TITLE				
02				1 OF 3	CONTACT, CARBON BRUSH				
LTR	REVISION RECORD	APP	DATE						

B. Burr

Burr on cutoff shall not exceed .008.

3.2. Wire Barrel Crimp

A. Crimp Dimensions and Type

Crimp height, width and type shall be as shown in Figure 2.

B. Tensile Strength

Crimp tensile strength shall be 70% of wire tensile strength.

C. Effective Crimp Length

Effective crimp length shall be 75% of wire barrel length minimum, and is defined as that portion of the barrel, excluding bellmouth, fully formed by the crimping tool.

D. Wire Barrel Flash

Wire barrel flash shall not exceed .005.

E. Wire Barrel Seam

Wire barrel seam shall be completely closed and there shall be no evidence of loose wire strands or wire strands visible in the seam.

F. Bellmouth

Rear bellmouth length shall be .015 maximum.

G. Conductor Location

End of the wire shall be flush with the front end of the wire barrel or extend .045 maximum after crimping.

3.3. Alignment

There shall be no twist or roll in crimped portion that will impair usage of the contact.

AMP

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Harrisburg, Pa. 17105

LOC
B

SHEET
2 OF 3

NO

114-2093

REV
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Part No	Wire		Wire Barrel Crimp			
	Qty	Size	Width	Height ±.002	Type	
					Crimper	Anvil
62807 63327	1	30	.055	.028	F	C
	1	28				
	1	26				
61933	1	24	.070	.048	F	C
	1	22		.051		
	1	20		.055		
61975 62302 62564 63020	1	24	.070	.044	F	C
	1	22		.048		
	1	20		.051		

Figure 2

Automatic Machine Wire Crimp Dimensions

AMP AMP INCORPORATED Harrisburg, Pa. 17105	LOC	SHEET	NO	REV
	B	3 OF 3	114-2093	0