

AMP

TITLE

E-SPRING CONTACT*

1. SCOPE

This specification covers the requirements for application of 6.35 SRS E-SPRING CONTACTS*. These requirements are applicable to hand or automatic machine crimping tools. For specific wire and insulation ranges relative to the product covered in this specification refer to the appropriate Tyco Electronics AMP Customer Drawing.

2. PRODUCT FEATURES

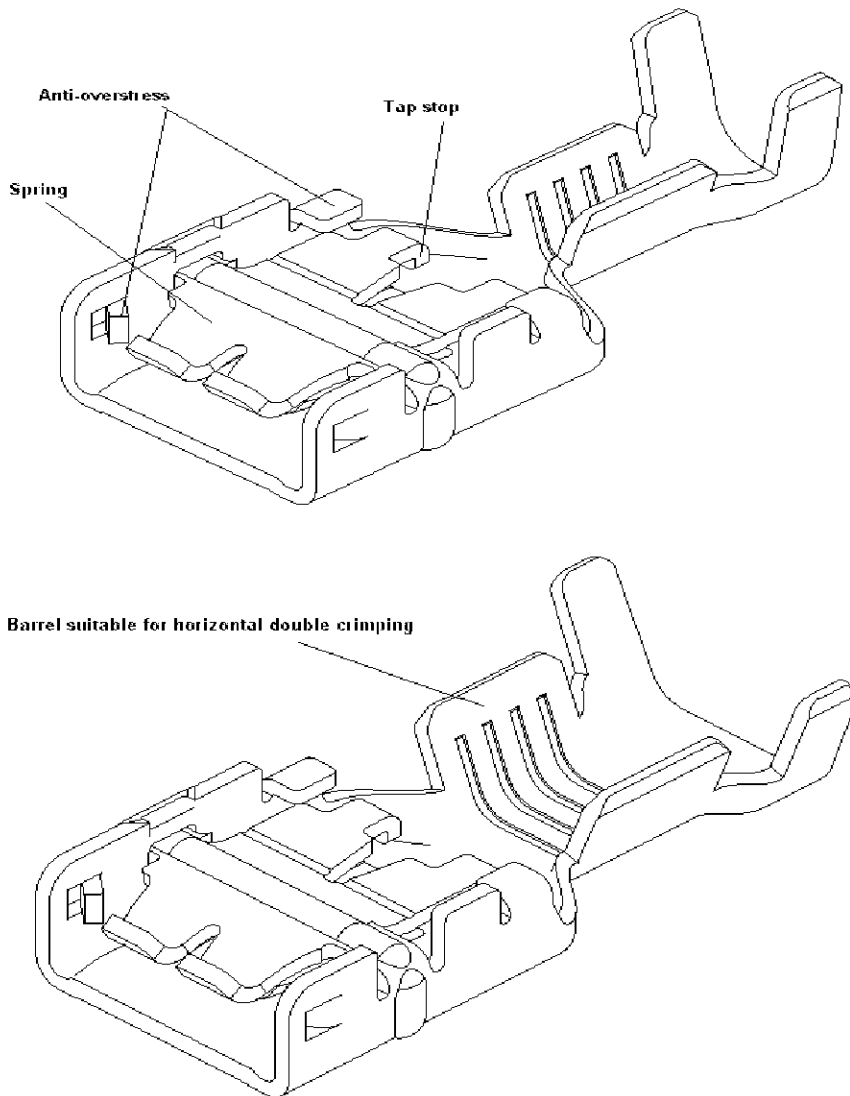


Fig.1

APVD	DATE	DR	DATE
J. Saló **	11/Feb/2005	L. Batlló **	11/Feb/2005

Rev. J (See EC ES00-0030-05)

Tyco Electronics AMP España, S.A.
Barcelona, Spain

Esta especificación es un documento controlado. Esta información es confidencial y propiedad de Tyco Electronics Corporation y de sus subsidiarias y filiales en todo el mundo. No debe ser mostrada a nadie que no sea el personal de Tyco Electronics sin la autorización escrita de Tyco Electronics Corporation, Harrisburg, Pennsylvania, EE.UU.

This specification is a controlled document. This information is confidential and proprietary to Tyco Electronics Corporation and its worldwide subsidiaries and affiliates. It may not be disclosed to anyone, other than Tyco Electronics personnel, without written authorization from Tyco Electronics Corporation, Harrisburg, Pennsylvania, USA.

* Trademark
** Signatures on File
| Indicates change

3. NOMENCLATURE

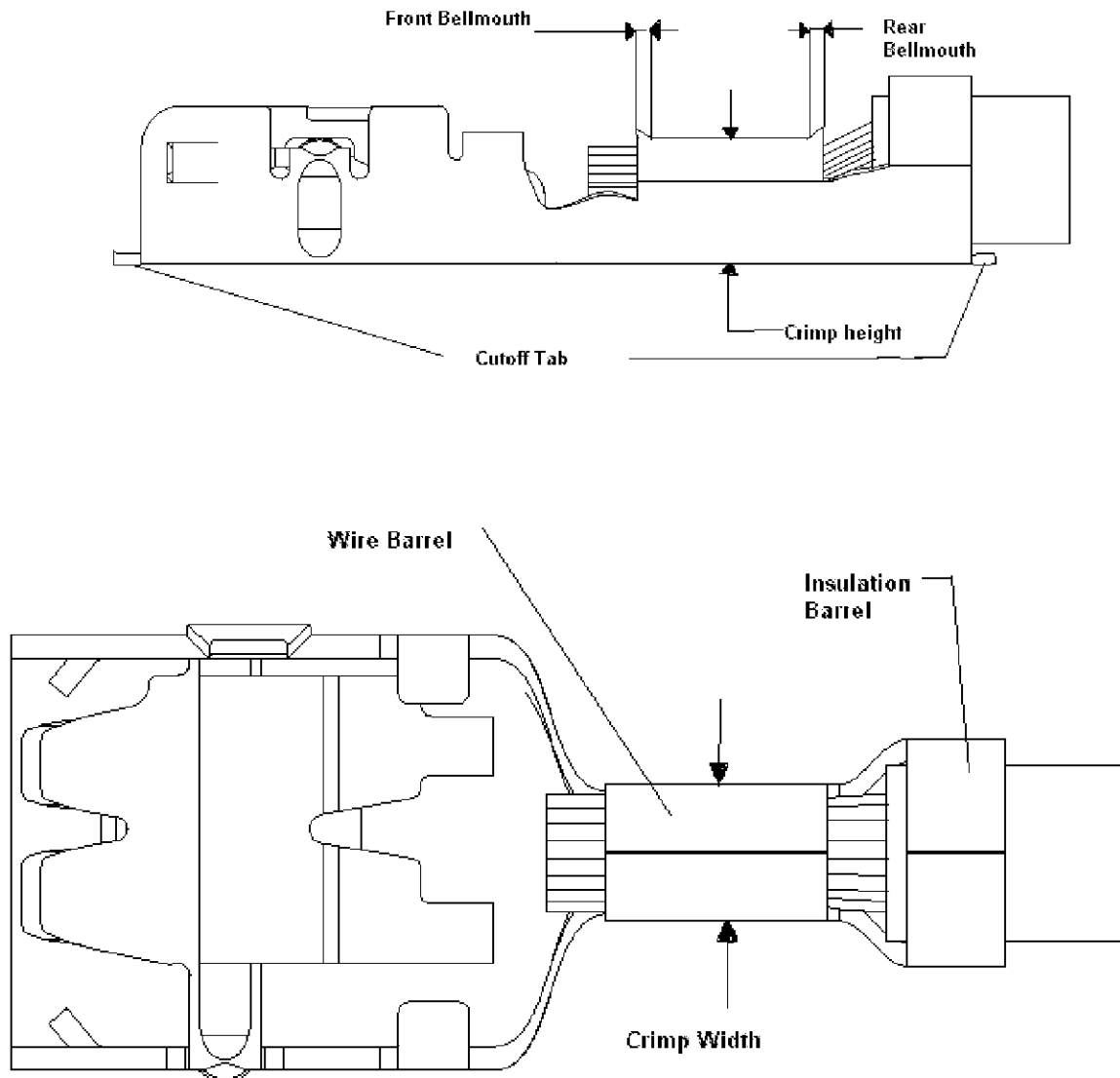


Fig.2

4. PRODUCT SELECTION

PART NUMBER	WIRE SIZE mm²	Barrel Configuration	WIRE COMBINATIONS mm²	INS. RANGE φ mm	TAB DIM'S mm
336074	0.32 - 0.75	Single Crimping	0.32, 0.35 ; 0.50 ; 0.75	2.0 - 3.0	6.35 x 0.8
336075	0.5 - 1.5	Single Crimping	0.5 ; 0.75 ; 1.0 ; 1.5	2.0 - 3.0	6.35 x 0.8
		Double Crimping Vertical (8)	0.5 + 0.5	2x2,1 max.	
336076	>1.0 - 2.5	Single Crimping	1.5 ; 2.5	3.0 - 3.6	6.35 x 0.8
		Double Crimping	0.5 + 0.75		
		Horizontal (∞)	0.5 + 1.0		
			0.5 + 1.5		
			0.75 + 0.75		
			0.75 + 1.0		
1.0 + 1.0					
1644008	>1 - 2,5	Single Crimping	1,5	3.0 - 4.3	6.35 x 0.8
		Double Crimping	0,75+0,75		
		Vertical (8)	0,75+1		
			1,0+1,0		

5. CRIMP AND DIMENSIONAL REQUIREMENTS

5.1 Wire preparation

a) Strip Length

- Insulation shall be stripped as indicated in Figure 2 and its length shall be of 4,8 mm.

b) Workmanship

- Reasonable care shall be taken not to nick, scrape or cut any strands or the solid wire during the stripping operation.

5.2 Carrier Cutoff Tab

- Cut-off tab shall not exceed .020

5.3 Wire Barrel Crimpa) Crimp dimensions and type

Crimp height, width and type shall be as shown in Table 1 or as shown in the appropriate Applicator Log Sheet for machine applications or the Instruction Sheet for handtool applications.

b) Wire Barrel Flash

- Wire Barrel flash shall not exceed .005

c) 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.

d) Bellmouth

- Rear the bellmouth length shall be .015 - .025
- Front bellmouth length shall not exceed .025

e) Conductor Location

- End of the wire shall be flush with the front end of the wire barrel or extend .015 max. After crimping.
- Both insulation and conductor shall be visible between the insul. And wire barrel. Care shall be taken not to allow insulation to be crimped in the wire barrel.

5.4 Wire and Insulation Barrel Crimp

Reasonable care shall be taken not to cut or break the insulation during the crimping operation.

Crimp height, width and type shall be as shown in Table 1 or as shown in the appropriate Applicator Log Sheet for machine applications or the Instruction Sheet for handtool applications.

Table 1

Part Number	Wire Size (mm ²)	Wire Barrel Crimp			Insulation Barrel		Log
		Height ^(*) (mm)	Widht (mm)	Crimp Type	Widht (mm)	Crimp Type	
336074	0,32	1,20	2,29	"F"	3,3	"F"	1339522
	0,35	1,20					
	0,5	1,32					
	0,75	1,40					
336075	0,5	1,39	2,29	"F"	3,3	"F"	1339523 1529024 ⁽¹⁾
	0,75	1,48					
	0,5+0,5	1,57					
	1,0						
	1,5	1,75					
336076	0,5+0,75	1,53	3,3	"F"	5,08	"F"	1339524 1529027 ⁽¹⁾
	1,5						
	0,75+0,75	1,53					
	0,5+1,0						
	0,75+1,0	1,59					
	1,0+1,0	1,65					
	0,5+1,5						
2,50	1,77						
1644008	1,5	1,59	3,05	"F"	4,57	"O"	1582951
	0,75+0,75						
	0,75+1,0	1,65					
	1,0+1,0	1,72					

(*) If the real wire section is 10% less than the nominal, contact with TE AMP Spain to determine the appropriate crimp height.

(1) Crimp height fine adjust head applicator

5.5 Alignment

a) Straightness

- The contact, including the cut-off tab and burr shall not be bent above or below the datum line more than the amount shown in figure 2.

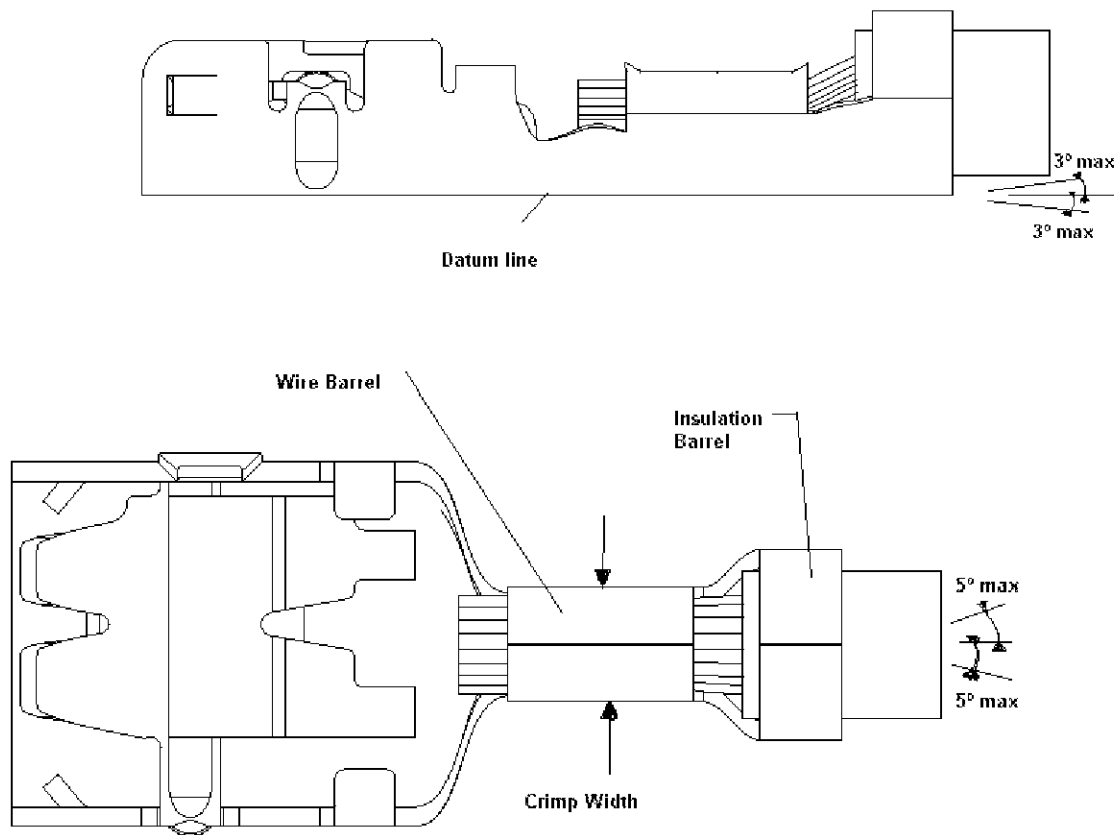


Fig. 3

- The side to side bending of the contact shall not exceed the limits specified in figure 3

- b) Twist or Roll
- c) Crimped terminal requirements
 - No damaging of mating area.
 - Cut -off tab 0.5mm max.

Twist or roll of the crimped contact shall not exceed the limits specified in Figure 4.

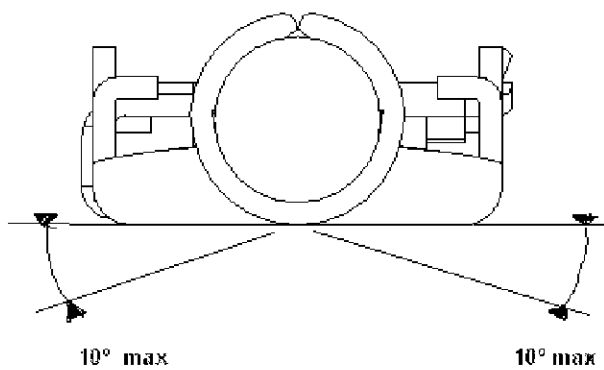


Fig. 4

6. MATING AND UNMATING THE TAB

During insertion tab counterpart (6.35x0.8) and E-SPRING CONTACT* Receptacle must be aligned as much as possible, see figure 5.

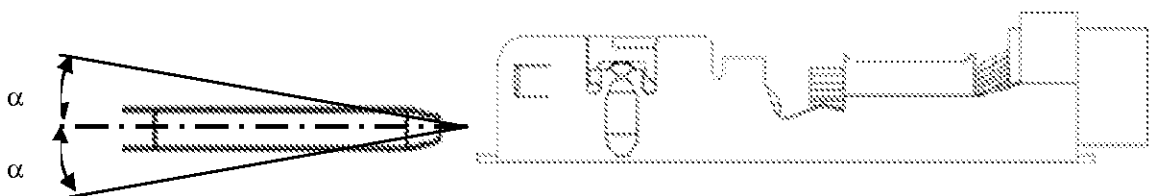


Fig. 5

During connection operation, tendency to certain misalignment is usual.

Keep tab and receptacle as much aligned as possible (keep α as smaller as possible).

NOTE For more details see Instruction Sheet 411-22025.

While inserting the tab counterpart (6.35x0.8) into the E-SPRING CONTACT* Receptacle, it must be inserted until the tab stop position. The tab stops should not be overstressed.

To know about the application with a sleeve, refer to the product specification of such Sleeve.

7. STORAGE AND CHEMICAL EXPOSURE LIMITATIONS

- The chemicals listed below can cause stress corrosion cracking in brass receptacles.
- Alkalines, Amines, Ammonia, Carbonates, Citrates, Nitrites, Phosphates, Sulphides, Sulphur Compounds and Tartrates.
- Where the above environmental conditions exist, phosp. Bronze receptacles are recommended instead of brass.