

114-5007

Application Specification

Crimping of "375" Series FASTIN-FASTON Receptacle Contacts

1. Scope:

This specification covers the crimping requirements for the "375" Series FASTIN-FASTON Receptacle Contacts.

2. Applicable Contacts:

Description	Parts Number	
Receptacle Contacts	170268-1, -2	170269-1, -2
Tab Contact	280074-1, -2	280075-1, -2

3. Nomenclature:

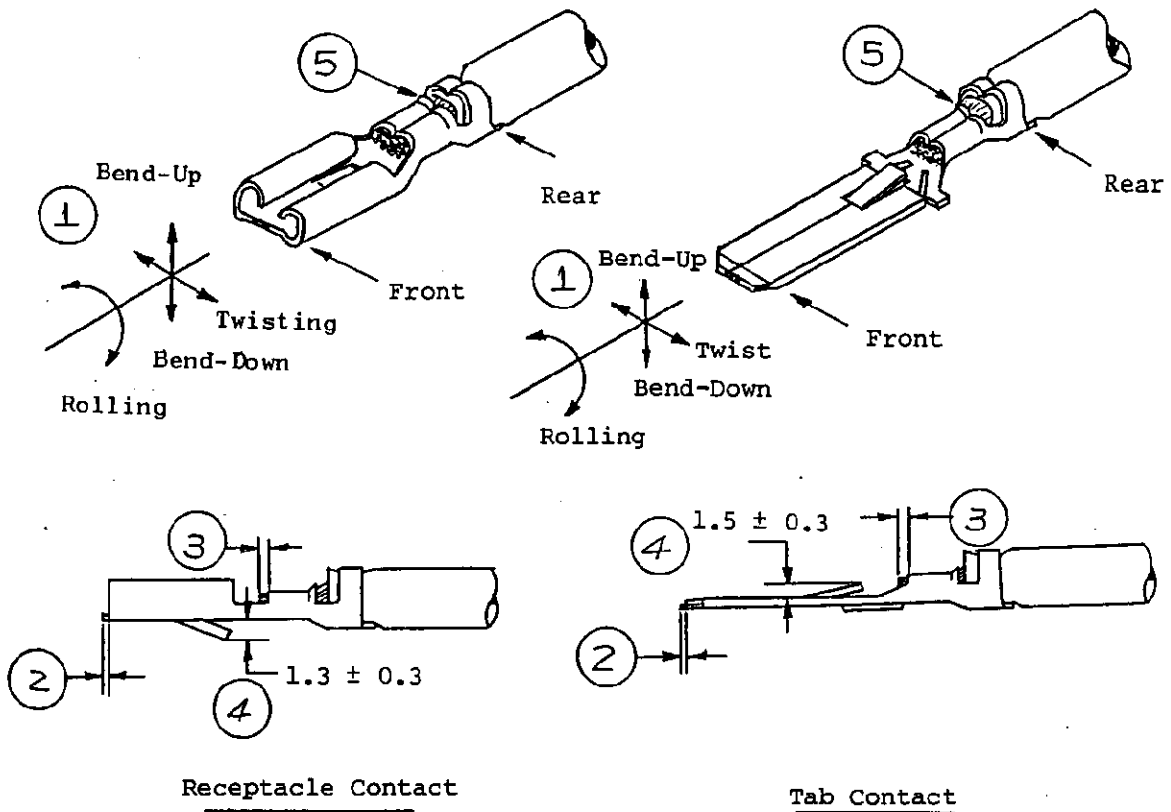


Fig. 1

AMP SECURITY CLASSIFICATION  
 Customer Release  
 NUMBER 114-5007

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	CHK	<i>[Signature]</i> 10-18-88		TOKYO, JAPAN			
	APP	<i>[Signature]</i> 10/18/88	LOC	JA	NO	114-5007	
E	Revised RFA-470	<i>[Signature]</i> 10/18/88	SHEET				NAME
LTR	REVISION RECORD	DR	CHK	DATE	1 OF 2		Application Specification
							Crimping of "375" Series FASTIN-FASTON Receptacle Contacts

- 3.1 Allowable limits of bend-up, bend-down and twisting deformations for the crimped contacts must not exceed 5 degrees. Those of rolling deformation must not exceed 10 degrees. Those of rolling deformation must not exceed 10 degrees. (Fig. 1- 1 )
- 3.2 Cut-off tab length must not exceed 0.5 mm. (Fig. 1- 2 )
- 3.3 Wire end protrusion length from the front edge of the wire barrel must not exceed 0.5 mm. (Fig. 1- 3 )
- 3.4 Locking lance widths of the receptacle and tab contacts must be as specified in Fig. 1. (Fig. 1- 4 )
- 3.5 Length of the rear bellmouth of the wire barrel must be with in 0.2 and 0.7 mm. (Fig.1-5)
- 3.6 Crimping of the contacts shall be carried out in accordance with the specified crimp data shown below. Tolerances of crimp heights must be within  $\pm 0.1$  mm. (Note that the JIS C3406 "Low Voltage Cables for Automobiles" shall be used.


(mm)

Contact Part No.	Wire size	Wire climp		Insulation climp		Crimp tensile strength (kg)
		Width	Height	Width	Height	
280075-1,-2	3 mm <sup>2</sup> (AWG#12)	4.83 (.190) "F"	2.45	6.35 (.250) "F"	6.8 max.	30 min.
170269-1,-2	5 mm <sup>2</sup> (AWG#10)		2.8			40 min.
280074-1,-2	8 mm <sup>2</sup> (AWG#8)	5.59 (.220) "F"	3.2	7.62 (.300) "F"	6.8 max.	50 min.
170268-1,-2	5 mm <sup>2</sup> (AWG#10)					2.67

- 3.7 The contact part numbers correspond to the applicator numbers as follows:

Contact Part Number	Applicator Part Number
280075-1, -2	721388
280077-1, -2	721387
280074-1, -2	721390
280076-1, -2	721389

- 3.8 Samples to be applied to this specification shall be crimped by the specified applicator.

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