

114-5015

NUMBER

Customer Release
AMP SECURITY CLASSIFICATION

114-5015

Application Specification

Crimping Mini-Spring Receptacle Contacts

1. Scope:

This specification covers crimping of mini-spring receptacle contacts used on L-JETRONIC Connector.

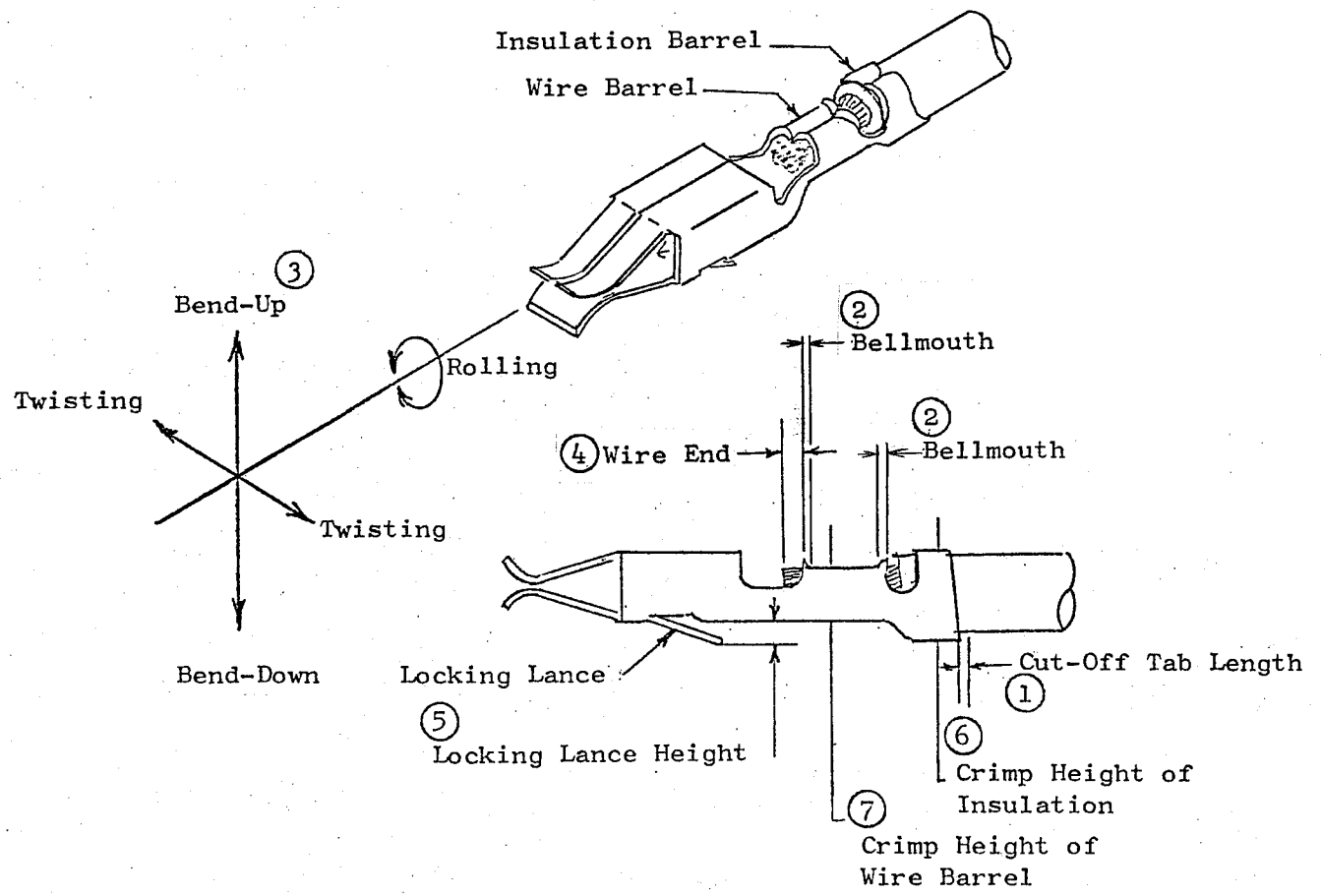
2. Applicable Contacts:

Contacts of the following part numbers shall be governed under this specification.

- 170209 Mini-Spring Receptacle Contact (Strip Form)
- 170210 " " " " (Loose Piece Form)
- 170439-1/-2 " " " " (Strip Form)

3. Nomenclature:

For the purpose of this specification, the following nomenclature shall apply.



DR	<i>Makamura</i>	7-2-79	AMP	AMP (Japan), Ltd. TOKYO, JAPAN
D	Revised RFA-1884	AN DA	10/1/81	LOC NO 114-5015
C	Revised RFA-491	<i>[Signature]</i>	7-2-79	REV D
B	Revised RFA-448	<i>[Signature]</i>	6-26-79	
A	Revised per RFA-302	<i>[Signature]</i>	7-3-79	
LTR	REVISION RECORD	DR	CHK	DATE
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4. Crimping Conditions and Crimp Data:

4.1 Crimping Conditions:

Wire-crimped contacts shall be conforming to the following conditions.

Item No.	Checking Items After Crimping	Wire-crimped Conditions of Contacts			Remarks
		Applicator Crimp		Crimped by Hand Tool	
		170439	170209		
1.	Cut-Off Tab Length	0.5mm (Max.)			Fig. 1 (1)
2.	Bellmouth	Front	0.3 max.	Formed bellmouth must be visually confirmed.	Fig. 1 (2)
		Rear	0.15 - 0.65 mm		
3.	Deformation after Crimping	Bend-Up Bend-Down	4° (Max.)		Fig. 1 (3)
		Twisting	5° (Max.)		
		Rolling	10° max.	5° max.	
4.	Wire-End Extrusion Length	0 - 1.2 mm			Fig. 1 (4)
5.	Locking Lance Height	0.6 - 1.0 mm			Fig. 1 (5)
6.	Insulation Stripping Length (REF.)	3.5 - 4.5 mm			—#—

4.2 Crimp Data:

Wire-crimping application tooling shall be appropriately adjusted to be capable to crimp contacts in accordance with the following tables.

4.2.1 Applicator:

Contact Part No. (Strip)	Wire Size mm ² (Nominal)	Applicator Number	Wire Barrel Crimp			Insulation Barrel Crimp			Tensile Strength (min.)						
			Width (mm)	Height (mm) Fig. 1 (7)	Disc Ltr.	Width (mm)	Height (mm) Fig. 1 (6)	Disc Ltr.	N	kgf					
170209	0.5	722705-1	2.3	1.30	D	3.56	3.7	4	4	88.2	9.0				
	0.85			C	127.4					13.0					
	1.25	722705-2		"F"	1.50					B	"F"	(Max.)	4	176.4	18.0
	2.0			A	1.78					5	245.0	25.0			
170439	0.3	724993-1	1.6	1.14	B	2.82	2 ⁺⁰ _{-0.3}	7	See Note 3	49.0	5.0				
	0.5	724993-2	"F"	1.24	A	"O"	2.4 ⁺⁰ _{-0.3}	4	88.2	9.0					

- Notes: (1) Tolerance of wire barrel crimp height shall be within ± 0.05 mm.
 (2) Unless otherwise specified, the unit of the value to be in mm.
 (3) Wire barrel tensile strength shall be 8.0 kg minimum, using 0.3mm² wire in the following conditions.
 (a) Wires: AVS 0.3mm², with insulation diameter of 1.8mm
 (b) Test Method: Test by applying an axial load after crimping contact with its insulation crimp performed.

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4.2.2 Hand Tool:

Contact Part No. (L.P.)	Wire Size mm ² (Nominal)	Hand Tool Catalog Number	Insulation Diameter (mm)	Crimp Symbols	Wire Barrel Crimp Height (mm)		Crimp Tensile Strength (kg)(Min.)
					Hand Tool Dimension	GO-NOGO Gage Part Number	
170210	0.5	722627-1	2.1 - 3.4	A	1.27	289901-262	7.0
	0.85						11.0
	1.25			B	1.65	289901-261	16.0
	2.0						23.0

5. Applicable Wire Size:

Wire Size mm ² (Nominal)	Number of Strands	Diameter of A Strand (mm)	Calculated Cross-sectional Area (mm ²)	Finished Insulation Diameter (mm)	Applicable Specification for the Wire
0.5	7	0.32	0.56	2.2 Standard	JIS C 3406 Low Voltage Wire for Automobiles
0.85	11	0.32	0.88	2.4 Standard	
1.25	16	0.32	1.29	2.7 Standard	
2.0	26	2.09	2.09	3.1 Standard	
0.3	12	0.18	0.31	1.5 Standard	JCS 246 Vinyl Wire for Communication
0.3	7	0.26	0.37	1.8 Standard	Low Voltage Cables for Automobiles

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