

114-5025
Application Specification
Crimping of SHUR* Plug Short Contact

1. Scope:

This specification covers crimping of SHUR* Plug Short Contacts.

2. Applicable Contact:

Part No.	Description
170229-1, -2	SHUR*Plug Short Contact

3. Nomenclature:

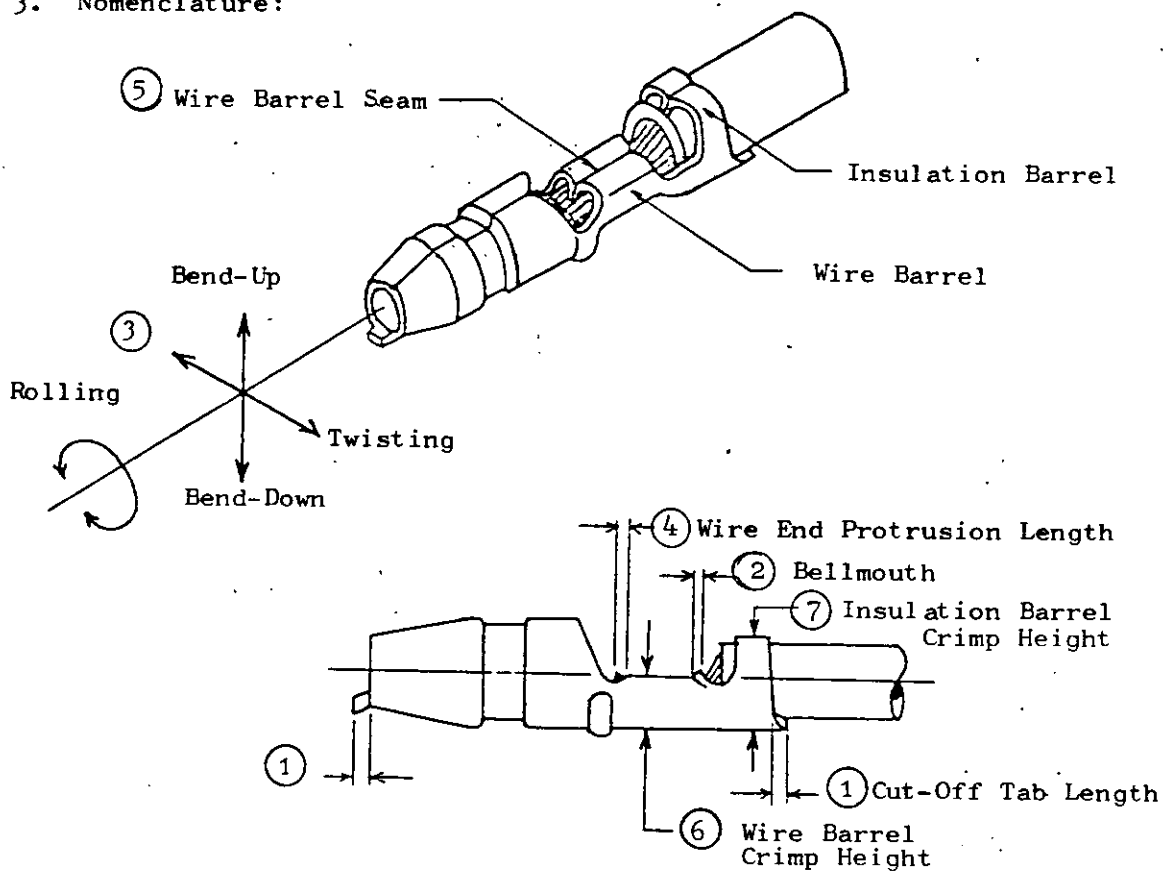


Fig. 1

NUMBER: 114 - 5025

Customer Release

SECURITY CLASSIFICATION:

				DR. <i>[Signature]</i> 7-28-94	SHEET 1 OF 2	AMP AMP (Japan), Ltd. Kawasaki, Japan		
				CHK. 7-28-94		LOC J A	NO. 114 - 5025	REV. 0
				APP. <i>[Signature]</i> 7-28-94	NAME Application Specification Crimping of SHUR* Plug Short Contact			
PRINT	0	Released	<i>[Signature]</i> 7/28/94					
LTR	REVISION RECORD		DR	CHK	DATE			

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4. Crimping Requirements and Crimp Data:
 4.1 Crimpin Requirements:

No.	Check Items	Crimping Requirements	Remarks	
1	Cut-Off Tab Length	0.5mm max.	Fig. 1 (1)	
2	Bellmouth (Rear Bell-mouth Only)	0.2 - 0.7mm	Fig. 1 (2)	
3	Deformation after Crimping	Bend-Up Down	6° max.	Fig. 1 (3)
		Twisting	6° max.	Fig. 1 (3)
		Rolling	12° max.	Fig. 1 (3)
4	Wire End Protrusion Length	0 - 1.5mm	Fig. 1 (4)	
5	Wire Barrel Seam	No conductors shall be loosed off outside the wire barrel.	Fig. 1 (5)	
6	Insulation Stripping Length	3.5 - 4.5mm	//	

4.2 Crimp Data:

Contact Part Number	Wire Size (Nominal (mm ²))	Applicator Number	Wire Barrel Crimp			Insulation Barrel Crimp		Crimp Tensile Strength (kg) (min)
			Width	Height Note 1 Fig. 1 (6)	Note (3)	Width	Height Fig. 1 (7)	
170229-1 -2	0.5f	722748-1 -2	2.79 "F"	1.57	C	4.57 "F"	3.9 max.	9.0
	0.5			1.57	C			9.0
	0.75f			1.67	B			13.0
	0.85			1.67	B			13.0
	1.25f			1.79	A			15.0
	1.25			1.79	A			15.0

Note: (1) Tolerance of wire barrel crimp height to be within ± 0.05 .
 (2) Unless otherwise noted, all the values are in millimeter.
 (3) Position of disc pad.

5. Applicable Wires:

Wire Size (nominal) (mm ²)	Number of Conductors	Diameter of a Conductor (mm)	Calculated Cross-Sectional Area (mm ²)	Finished Insulation Diameter (mm)	Applicable Wire Specification
0.5f	20	0.18	0.51	2.2	JIS C 3406 Low voltage cables for automobiles
0.5	7	0.32	0.56	2.2	
0.75	30	0.18	0.76	2.4	
0.85	11	0.89	0.89	2.4	
1.25f	50	1.27	1.27	2.7	
1.25	16	1.28	1.28	2.7	

NAME
 Crimping SHUR* Plug Short Contact

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