

114-5065

Application Specification

Crimping of Pulse Lock Connector Receptacle Contact

1. Scope:

This specification covers crimping requirements of pulse lock connector receptacle contact.

2. Applicable Contact Number:

The receptacle contacts of the following part numbers shall be governed under this specification.

170352, 170353 (Strip Form)  
172771, 172772 (Loose Piece)

3. Nomenclature:

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

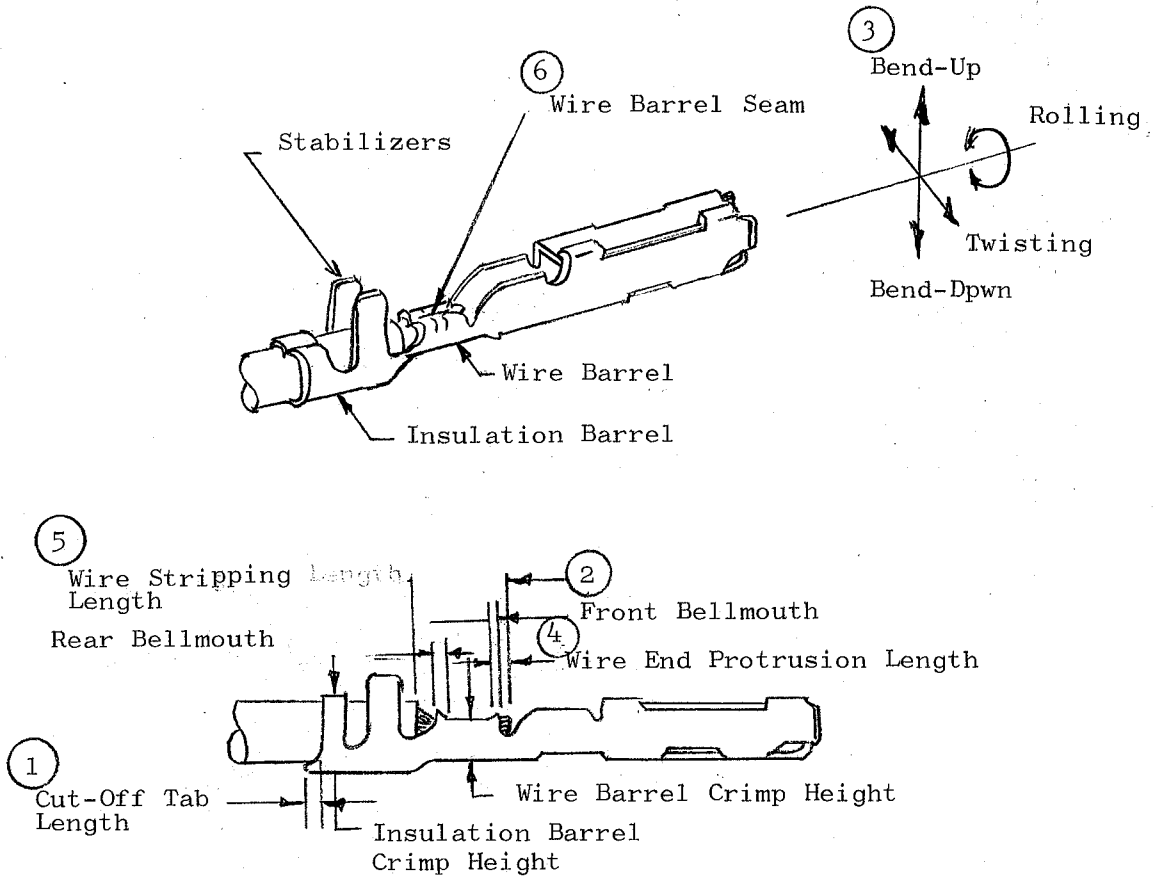


Fig. 1

				DR <i>[Signature]</i> 11-18-81	<b>AMP</b>		AMP (Japan), Ltd. TOKYO, JAPAN	
				CHK <i>[Signature]</i> 11-18-81			LOC <b>J A</b>	NO 114-5065
A1	Revised RFA-1814	<i>[Signature]</i> 8-20		APP <i>[Signature]</i> 11-18-81	NAME Application Specification			
A	Revised			SHEET 1 OF 3				
O	Released	<i>[Signature]</i> 11-18-81		Crimping of Pulse Lock Connector Receptacle Contact				
LTR	REVISION RECORD	DR	CHK	DATE				

4. Crimping Requirements and Crimp Data:

4.1 Crimping Requirements:


No.	Check Points	Contact Number	Allowable Limits of Deviation		Remarks
			170352	170353	
1.	Cut-Off Tab Length		0.5mm max.		Fig. 1 (1)
2.	Bellmouth	Front	0.3mm max. (It must be visually checked.)		Fig. 1 (2)
		Rear	0.15-0.65mm (Crimp by hand tool must be visually checked.)		
3.	Allowable Limits of Deviation	Bend-Up	4° max.		Fig. 1 (3)
		Bend-Down	4° max.		
		Twisting	4° max.		
		Rolling	7° max.		
4.	Wire End Protrusion Length		0 - 2 mm		Fig. 1 (4)
5.	Insulation Stripping Length (Reference)		4.5 - 6.0 mm	4.5 - 6.0 mm	Fig. 1 (5)
	Wire Barrel Seam Closure		Wire barrel seam must be neatly closed. A slight gap in the seam may be allowed if the mis-gripped wire strand is not present.		Fig. 1 (6)

4.2 Crimp Data:

4.2.1 Crimp by Applicator:

Contact Catalog Number (Strip Form)	Applicator Number	Wire Size (Nominal)		Wire Barrel Crimp			Insulation Barrel Crimp			Crimp Tensile Strength (kg) (max.)
		mm <sup>2</sup>	(AWG)	Width (mm)	Height (mm) See Note 1 & Fig. 1 5	Disc Ltr.	Width (mm)	Height See Fig. 1 6	Disc Ltr. (Fig.)	
170353	724973-2	0.5	(#20)	2.29 "F"	1.22	C	3.3 "F"	3.7 max.	4	9.0
		0.85	(#18)		1.35	B			4	13.0
		1.25	(#16)		1.50	A			4	18.0
170352	724972-2	0.3	(#22)	1.78 "F"	1.08	B	2.3 "0"	3.0 max.	4	5.0
		0.5	(#20)		1.17	A			4	9.0

Note 1: Tolerance of wire barrel crimp height to be within  $\pm 0.05$ mm.

SHEET				AMP (Japan), Ltd.	
2 OF 3				TOKYO, JAPAN	
LOG	J	A	NO	114-5065	REV
					A1
NAME Application Specification					
Crimping of Pulse Lock Connector					
Receptacle Contact					


NUMBER 114-5065  
 AMP SECURITY CLASSIFICATION  
 Customer Release

4.2.2 Crimp by Hand Tools:

Contact Part No. Loose Piece	Hand Tool Part No.	Wire Size (Nominal) (mm <sup>2</sup> )	Wire Barrel		Crimp Crimp Symbols	Insulation Diameter (mm)	Insulation Crimp (Height) (Type)	Crimp Tensile Strength (kg)	
			Width (mm)	Height Fig. 1 7					
172771	752916-1	0.3	1.78	0.89 - 1.09	22	1.6 - 2.2	2.29 "O"	5.0	
		0.5		"F"	0.99 - 1.22	20		1.8 - 2.4	9.0
172772	752917-1	0.5	2.29	1.19 - 1.37	20-18	2.0 - 2.6	3.3 "F"	9.0	
		0.85		"F"					13.0
		1.25		"F"	1.39 - 1.65	16		2.2 - 2.9	18.0

5. Applicable Wire:

Wire Size mm <sup>2</sup>	Wire Size (AWG)	Strand Composition Number of Strands / Diameter of a Strand	Calculated Cross-Sectional Area (mm <sup>2</sup> )	Insulation Diameter (mm)	Applicable Specification
0.3	(#22)	12 / 0.18 mm	0.31	1.5 Standard	JIS C 246 Vinyl-insulated wire for communication equipment
0.3	(#22)	7 / 0.26 mm	0.37	1.6 Standard or 1.8	(Low Voltage Cables for Automobiles)
0.5	(#20)	7 / 0.32 mm	0.56	2.2 Standard	JIS C 3406 Low Voltage Cables for Automobiles
0.85	(#18)	11 / 0.32 mm	0.88	2.4 Standard	
1.25	(#16)	16 / 0.32 mm	1.29	2.7 Standard	

SHEET				AMP (Japan), Ltd. TOKYO, JAPAN	
3	OF 3			LOG	NO
		J	A	114-5065	A1
NAME Application Specification Crimping of Pulse Lock Connector Receptacle Contact					