NUMBER 114-5096

AMP SECURITY CLASSIFICATION Customer Release

Application Specification

114-5096

Crimping Requirements of 5 Serration AMP LIVAR Splice

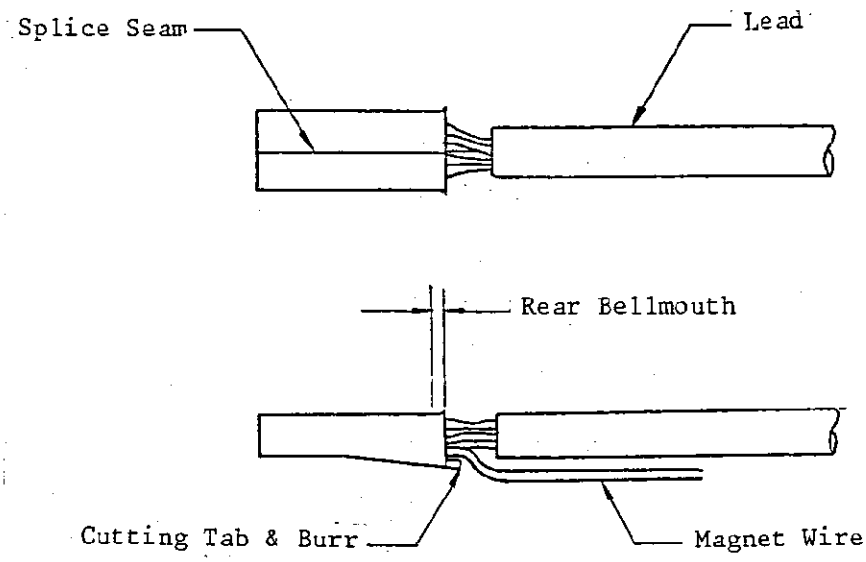
for Pig-tail Termination

1. Scope

This specification covers the crimping requirements of the 5 serration AMP LIVAR*splice for pig-tail termination. These requirements apply to the splices crimped by an automatic crimping machine.

Please refer to Fig. 4 for the applicable wire sizes (CMA) for each product covered in this specification.

2. Part Name



* AMP registered trade mark

Fig. 1

PRINT DIST

LTR	REVISION RECORD	DR	CHK	DATE
0	Released			5-25-87

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LOC	NO	REV
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SHEET 1 OF 4

NAME Crimping Requirements of 5 Serration AMP LIVAR Splice for Pig-tail Termination

3. Crimping and Dimensional Requirements

3.1 Wire Cutting and Stripping

A. Magnet Wire

No pre-treatment is required.

B. Lead

(1) The wire stripping length shall be as shown in Fig. 4.

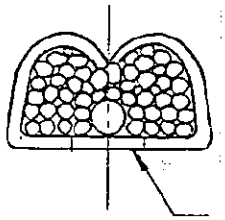
(2) Special care shall be taken to prevent damage, scratch and breaking stranded or solid wires in stripping.

3.2 Cut-Off Tab Length and Burrs of Carrier Strip:

A. Cut-Off Tab Length:

(1) The cutting tab length shall be not exceeding 0,4mm.

(2) The center line of the cutting tab shall be in the range shown in Fig. 2 in respect to the center line of the splice.



The center line of the cutting tab shall be held within 0.38 mm (indicator reading) of the center line of the splice.

Fig. 2

B. Burrs:

The burrs on cut-off tab shall be not exceeding 0.2mm.

3.3 Crimping of Splice

A. Dimensions

(1) The width shall be that shown in Fig. 4.

(2) The crimp height shall conform to the requirements of AMP engineering division. The crimp height prescribed by the AMP engineering division is measured at the position shown in Fig. 3. The tolerance shall be ±0.05 mm, unless otherwise specified.

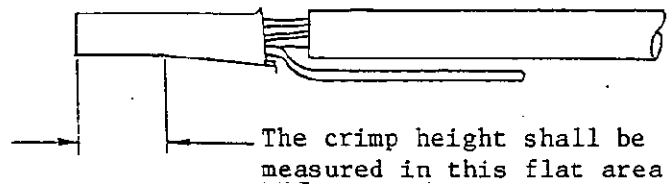


Fig. 3

B. Crimp Tensile Strength

The crimp tensile strength shall be not less than 70% of the wire inherent strength.

C. Splice Seam

The splice seam shall be solidly closed. There shall be no loosening of element wire and no strand wire shall be seen in the splice seam.

D. Bellmouth

No rear bellmouth is tolerated.

E. Positioning of Conductor

(1) Before crimping, place the wire so as to be crimped along the overall length of the splice.

(2) After crimping, cut to a proper length the wires protruded from the front end of the splice.

(3) The conductor shall be so crimped as to be visible a point between the lead insulation and the rear part of the splice.

(4) Place the magnet wire to touch the serrated area on the bottom of the splice.

Splice No.	Wire Size mm² (CMA)	Lead Stripping Length mm	Splice Crimp Part	
			Width mm	Crimp Type
170152 42076 42192	0.30～1.52 (600～3000)	7.9±0.8	2.79	F
41765 42119 41899	0.76～2.53 (1500～5000)		2.79	F
41766 60667 41900	1.52～3.55 (3000～7000)		3.56	F
41770 41904	3.55～6.58 (7000～13000)		4.57	F

Fig. 4