

Application Specification

114-5105

Termination of AMPMODU Mass Termination Connector

1. Scope:

This specification covers the requirements for terminating AMPMODU Mass Termination Connector.

2. Applicable Connector:

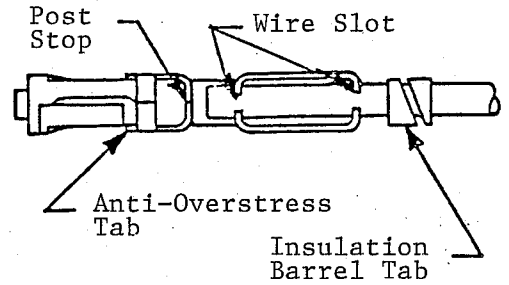
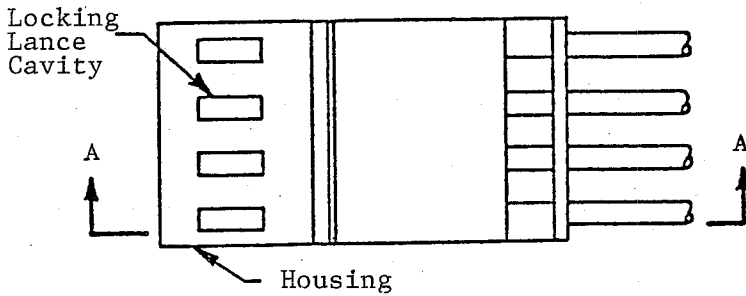
Description	Product Part No.	Applicable Wire	Insulation Diameter	Core Wire Composition
Receptacle Assembly	□-173246-□	AWG #26 ~ #22 (0.3 ~ 0.12mm)	0.8 ~ 1.27	Tin-coated stranded wires, solid wires, 7-stranded wires
Receptacle Assembly	□-173247-□	AWG #30 ~ #26 (0.05 ~ 0.15mm)	0.8 ~ 1.27	

Note: Compatibility of each wire shall be assessed at time of use.

3. Nomenclature:

Typical Connector Assembly

Contact

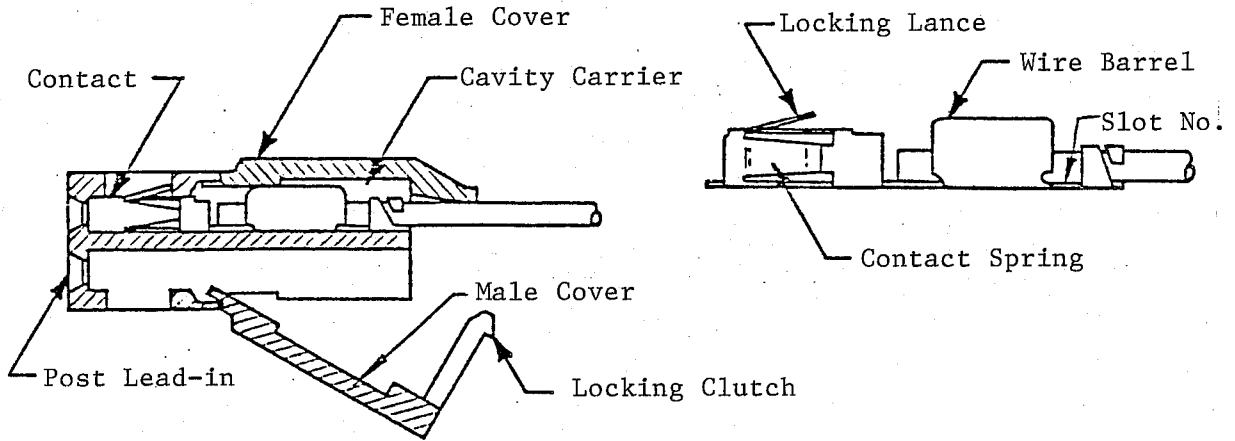


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				DR <i>[Signature]</i> I. ENOMOTO 5-23-'88.	<b>AMP</b>		AMP (Japan), Ltd. TOKYO, JAPAN	
				APP <i>[Signature]</i> 5-20-'88	LOC J	NO A	114-5105	REV 01
01	Revised RFA-1814	<i>[Signature]</i>	5-20	SHEET 1 OF 5				
0	Released RFA-1166	<i>[Signature]</i>	5-23	Application Specification Termination of AMPMODU Mass Termination Connector				
LTR	REVISION RECORD	DR	CHK	DATE				

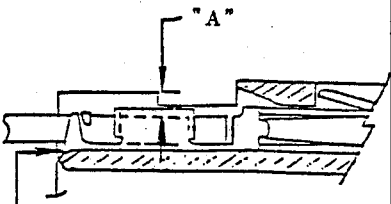
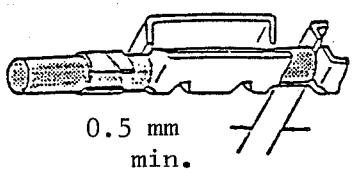
NUMBER 114-5105  
 AMP SECURITY CLASSIFICATION  
 Customer Release




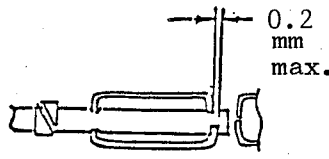

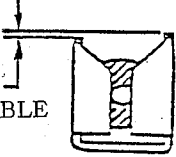

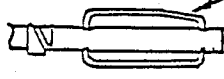
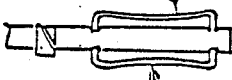
Section A-A


Fig.1

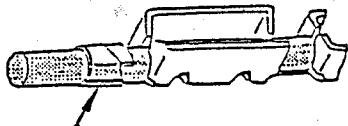
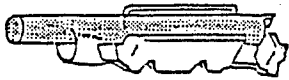

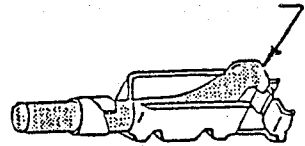

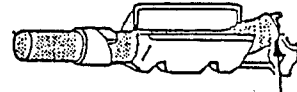
4. Terminating Condition and Inspection Criteria:

No.	Item	Terminating Condition	Inspection Criteria						
1	Depth of Wire Insertion	After wire termination, depth of wire insertion shall be as follows when measured from upper end of the housing to upper end of the wire insulation. <table border="1" style="margin: 10px auto;"> <thead> <tr> <th>Insulation Diameter</th> <th>Depth of Insertion "A"</th> </tr> </thead> <tbody> <tr> <td>0.8 ~ 1.1</td> <td>1.05<sup>+</sup>0.15mm</td> </tr> <tr> <td>1.0 ~ 1.27</td> <td>0.85<sup>±</sup>0.15mm</td> </tr> </tbody> </table>	Insulation Diameter	Depth of Insertion "A"	0.8 ~ 1.1	1.05 <sup>+</sup> 0.15mm	1.0 ~ 1.27	0.85 <sup>±</sup> 0.15mm	 <p>Bottom of the contact shall be placed on the housing. Measurement shall be done 30 minutes after the termination.</p>
Insulation Diameter	Depth of Insertion "A"								
0.8 ~ 1.1	1.05 <sup>+</sup> 0.15mm								
1.0 ~ 1.27	0.85 <sup>±</sup> 0.15mm								
2	Length of Wire End Protrusion	Wire end protrusion from front slot shall be greater than 0.5 mm.	 <p>0.5 mm min.</p>						

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No.	Item	Terminating Condition	Inspection Criteria
3	Symmetrical Forming of Slot Beams:	Contact slot beams shall appear flush at the formed edge plane, within 0.2mm max. (dimension "B" which is equal to the thickness of the stock of contact.	 <p>0.2 mm max.</p>
4	Height of Formed Beams and Damage:	Contact slot beams shall appear flush in height, when inspected visually after termination, and no damage is allowed on the terminated beams.	<p>Damaged Beam: REJECTABLE</p>  <p>Stepped Height: REJECTABLE</p> 
5	Deformation of Contact	There shall be no deformation of contact caused by tool as explained in the right sketch. Arched bend between the slot is acceptable.	<p>Damage: REJECTABLE</p>  <p>Deformation: REJECTABLE</p>  <p>ACCEPTABLE</p>  <p>Arched Bend ACCEPTABLE</p>

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No.	Item	Terminating Condition	Inspection Criteria
6	Penetration of Insulation Barrel Tab	Penetration of tab into insulation jacket or the breakage without exposure of core wire is acceptable. Penetration into core wire is not acceptable.	 <p>Penetration into Insulation: ACCEPTABLE</p>  <p>Penetration into Conductor: REJECTABLE</p>
7	Damage of Insulation Barrel Tab	It is acceptable that damage of insulation barrel tab exposes the base metal. However, it shall completely wrap the wire.	<p>Damaged Insulation Tabs: ACCEPTABLE</p> 
8	Condition of Wire End	Condition of wire end as those shown in the right sketch shall be rejected.	<p>Bend of Inserted Wire after Termination: REJECTABLE</p>  <p>Wire End Not Reaching Other Side of Slot: REJECTABLE</p>  <p>Wire End Not Fully Inserted on the Other Side of Contact: REJECTABLE</p> 

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LOC

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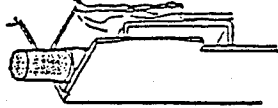

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No.	Item	Terminating Condition	Inspection Criteria
9	Damage on housing	There shall be no evidence of damage on the housing surface.	Damage on Housing: REJECTABLE 
10	Others	Any contacts once used for termination shall not be reused.	


5. Wire Retention Force (All of the actual measurement shall conform to the requirements.)

Contact Axial Direction Wire Retention Force

Product Part No.	Slot No.	Wire Size AWG	Tensile Strength kg. (min.)
□-173247-□	1	#30	0.9
		#28	1.4
		#26	1.6
□-173246-□	2	#26	1.1
		#24	2.2
		#22	2.7

6. Termination Tool:

Receptacle Part No.	Description of Tool	Tool Part No.	Applicable Tool for Each Wire Size		No. of Wire per Cycle	Depth of Insertion (mm)
			Core Wire Size	Insulation Diameter (mm)		
□-173247-□	Pistol Grip Tool	58074-1	AWG	0.8 ~ 1.1	1	1.05±0.15
		58062-1	#30 - #22	1.0 ~ 1.27		0.85±0.15
□-173246-□	Mini-Press (Manual Type)	756319-4	AWG	0.8 ~ 1.1	22 wires max per row	1.05±0.15
		756319-5	#30 - #22	1.0 ~ 1.27		0.85±0.15
□-173246-□	Mini-Press (Air Type)	756782-4	AWG	0.8 ~ 1.1	22 wires max per row	1.05±0.15
		756782-5	#30 - #22	1.0 ~ 1.27		0.85±0.15

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