

114-5149

Application Specification

Crimping .040 Series, Receptacle Contacts  
For 120-Pos. Sealed PAIR MATE\* Connector

1. Scope:

This specification covers the requirements for crimping of .040 Series, Receptacle Contacts for 120-Position, Sealed PAIR MATE Connector.

2. Applicable Contact:

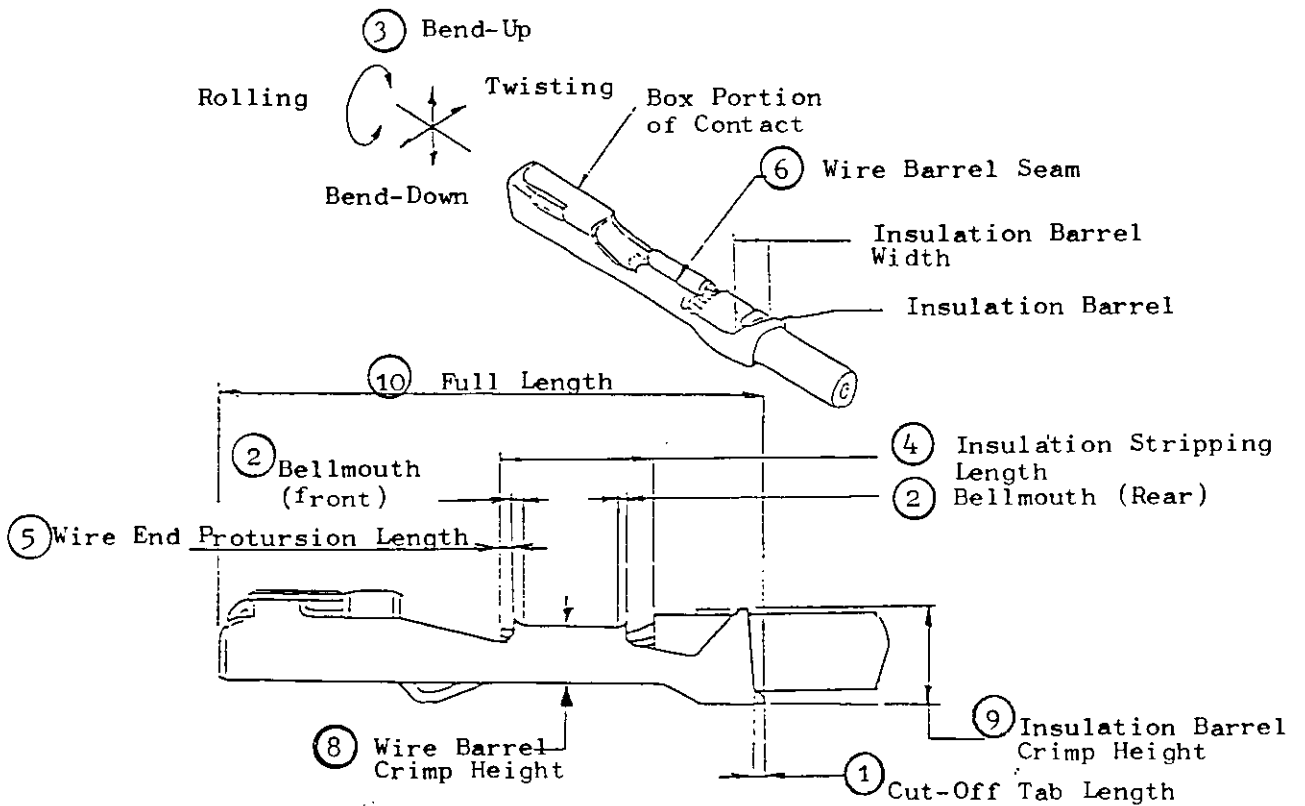
Part Numbers:

175197 Receptacle Contact (Strip Form)

179422 Receptacle Contact (Loose Piece)

3. Nomenclature:

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



DR. *[Signature]*  
CHK. 7/8 '94  
*J. Kohno*

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**AMP**  
AMP (Japan), Ltd.  
Kawasaki, Japan

LOC	NO.	REV.
J A	114 - 5149	C

APP. *[Signature]* 12/94

NAME  
Crimping .040 Series, Receptacle  
Contacts for 120-Pos. Sealed  
PAIR MATE\* Connector

NUMBER: 114 - 5149  
 SECURITY CLASSIFICATION: Customer Release

PRINT	DIST.	DR	CHK	DATE
C	FJ00-0329-94	<i>[Signature]</i>	<i>[Signature]</i>	7/16/94
B	FJ00-0849-93	<i>[Signature]</i>	<i>[Signature]</i>	7/8/94
LTR	REVISION RECORD			

114 - 5149

NUMBER:

Customer Release

SECURITY CLASSIFICATION:

## 4. Crimping Conditions:

No.	Check Items	Crimping Conditions	Remarks
1	Cut-Off Tab Length	0.3mm Max.	Fig. 1 (1)
2	Bellmouth	Front Applicator Crimp 0-0.4mm	Fig. 1 (2)
		Rear Hand Tool Crimp 0-0.5mm	
3	Deformation after Crimping	Bend Applicator Crimp +2° -4°	Fig. 1 (3)
		Twisting Applicator Crimp 3° Max.	
		Rolling Hand Tool Crimp +3° -4° 4.5° Max.	
4	Wire Insulation Stripping Length	4.0 - 4.5mm	Fig. 1 (4)
5	Wire End Protrusion Length	0 - 0.6mm	Fig. 1 (5)
6	Wire Barrel Seam	Seam shall be neatly closed, and no wire strand shall be visible in it.	Fig. 1 (6)
7	Width of Insulation Barrel (after Crimping)	2.4mm Max.	Fig. 1 (7)
8	Contact Overall Length (Cut-Off Tab Inclusive)	15.0mm Max.	Fig. 1 (10)

## 5. Crimp Data:

## 5.1 Applicator Crimp:

Contact Part No. (Strip)	Wire Size (Nominal)	Applicator Number	Wire Barrel Crimp			Insulation Barrel Crimp			Crimp Tensile Strength kg (Min.)
			Width (mm)	Height <sup>+0.05mm</sup> Fig. 1 (8)	Disc Ltr.	Width (mm)	Height Fig. 1 (9)	Disc Ltr.	
175197	0.5	914589-2	1.78	1.14	C	2.29	2.8	6	See Note 2. 9.0
	0.85			1.27	B				
	1.25		"F"	1.46	A	6	18.0		

- Note: 1. Unless otherwise noted, all the dimensions are in millimeter.  
2. The wires, having substantial strength of 9.0 kg minimum, shall be used.

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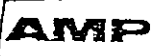
5.2 Hand Tool:

Contact Part No.	Wire Size (Nominal)	Hand Tool Number	Insulation Diameter (mm)	Crimp Symbols	Wire Barrel Crimp Height (mm)	Crimp Tensile Strength (kg)
179422 (175197)	0.5	934194-1	1.6 - 2.1	20 - 18	0.99 - 1.15	5.8 Min.
	0.85				0.99 - 1.26	12.0 Min.
	1.25			16	1.18 - 1.49	18.0 Min.

6. Applicable Wires:

Wire Size Nominal mm <sup>2</sup>	Number of Conductors / Diameter of a Conductor (mm)	Calculated Cross-sectional Area (mm <sup>2</sup> )	Finished Insulation Diameter	Wire Symbols	Applicable Wire Specification
0.5	7 / 0.32	0.56	1.6	AVSS	Low Voltage Cables for Automobiles
	7 / 0.32*			CAVS	
0.85	19 / 0.24	0.86	1.8	AVSS	
	11 / 0.32*	0.88		CAVS	
1.25	19 / 0.29	1.26	2.1	AVSS	
	16 / 0.32*	1.29		CAVS	

\* Denotes the diameter of a conductor of the wire before crimping.

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NAME Crimping .630 Series, Receptacle Contacts for 120-Pos. Sealed PAIR MATE* Connector					