

SECURITY CLASSIFICATION: Customer Release NUMBER: 114-5193

## 114-5193 Application Specification

### Crimping of Mini-Multi-lock Connector Contacts

1. Scope :

This specification covers the requirements for crimping of Mini-Multi-lock\* Connector tab and receptacle contacts.

2. Applicable Contacts :

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

Part Number	Descriptions	Surface Finish
917308	Receptacle Contact	Tin-plated
917309	Tab Contact	Tin-plated

						DR.	4/21 '94	SHEET 1 OF 3	<b>AMP</b> AMP (Japan), Ltd. Kawasaki, Japan				
						CHK.	_____			LOC J	LOC A	NO. 114-5193	REV. B
						APP.	4/21 '94		NAME	Crimping of Mini-Multi-lock Connector Contacts			
B	Revised FJ00-0285-97	9/16/97	A.T	16.11.95		A. Tomita							
A	ECN FJ00-1413-94	K.Y	A.T	16.11.95									
LTR	REVISION RECORD	DR	CHK	DATE									

6-24-98

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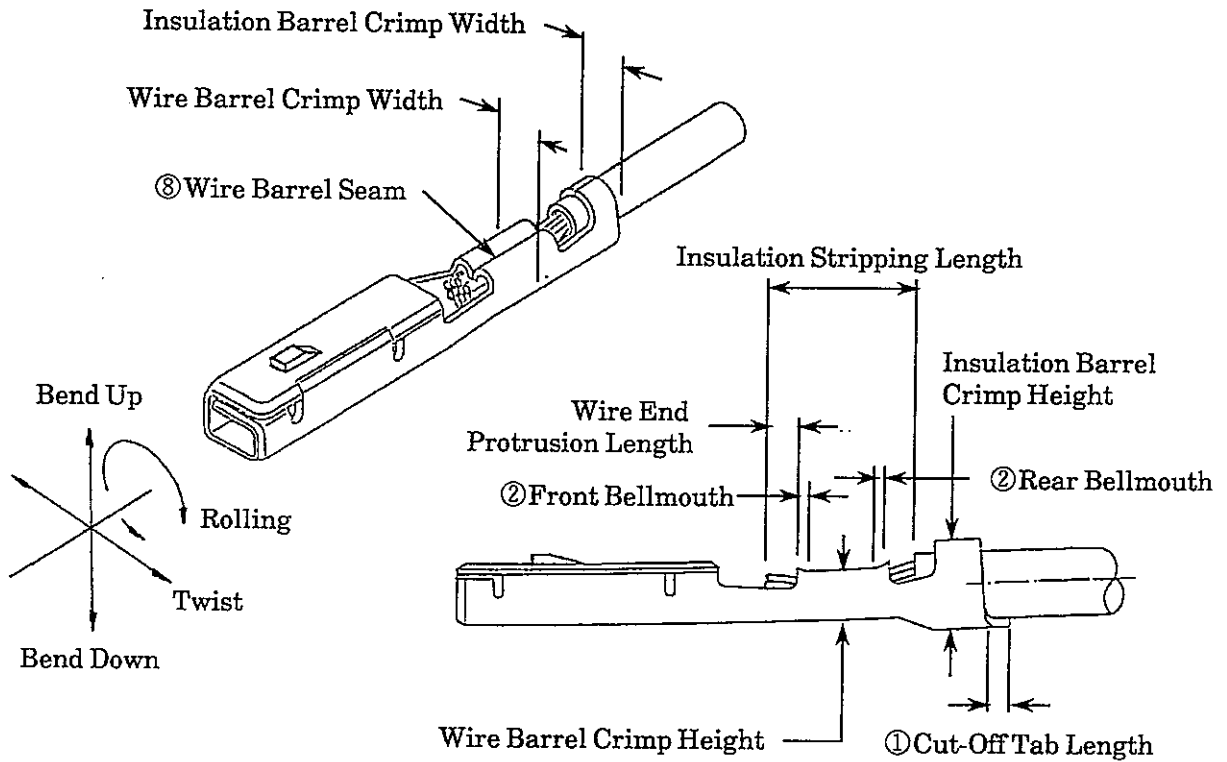
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3. Product Nomenclature :

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



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## 4. Crimping Conditions :

Para graph No.	Checking Items	Part Number	Crimping Condition		Remarks
			Receptacle Contact P/N 917308	Tab Contact P/N 917309	
1	Cut-Off Tab length		0~0.5 mm		
2	Bellmouth	Front	0.2 max.		
		Rear	0.5 max.		
3	Deformation after Crimping	Bend	±4° max.		
		Twist	±3° max.		
		Rolling	±5° max.		
4	Wire End Protrusion Length		0~1 mm		
5	Insulation Stripping Length		3.5 mm (*1)		
6	Wire Barrel Seam		Wire barrel seam must be neatly closed.		

\*1. In case of CAVUS, Insulation Stripping Length is 3 mm.

## 5. Crimp Data :

Contact Part Number (Strip Form)	Wire Size (Nominal)	Applicator Number	Wire Barrel Crimp			Insulation Barrel Crimp (mm)			Srimp Tensile Strength (kg) (min.)
			Width	Height	Disc. Ltr.	Width	Height	Disc. Ltr.	
917308	0.3	715788-2	1.27	0.9	B	1.45	1.9	4	6.0
917309	0.5			1.02	A				9.0

## 6. Applicable Wires :

Nominal Wire Size	Number of Conductors/ Diameter of a Conductor	Calculated Cross-sectional Area (mm <sup>2</sup> )	AVSS / CAVS	
			Standard	Maximum
0.3	7/0.26	0.37	1.4	1.5
0.5	7/0.32	0.56	1.6	1.7

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