

Crimping .040 III Unsealed Contact, Tab

Application Specification

114-5228 02JUN03 Rev E3

The performance of applicable product is guaranteed only when processed by proper application tooling and condition described in this specification and/or AMP recognized ones. No product is guaranteed when processed with the other tool or condition.

1. Scope

This specification covers the requirements for crimping of .040 III Unsealed Contact ,Tab.

2. Appli	cable Conta	cts			
Contact Part Numbers*		Description	Finish	Applicable Wires	
Strip Form	Loose Piece			nation water and the thirt of the	
353537	1376703	Tab(Small)	Tin-plated or Gold plated	AVSS/CAVS 0.3~0.5	
1565963		Tab(Small)	Tin-plated or Gold plated	CHFUS 0.35~0.5 AVSS/CAVS 0.3~0.5	
1123654	1376705	Tab(Medium Small)	Tin-plated	AVSS/CAVS 0.85 CAVUS 0.85	

NOTE Part number is consisted from listed base number and 1 digit numeric prefix and suffix with dash. Refer to catalog or customer drawing for specific part numbers for each base number. When prefix is zero, zero and dash omitted.

3. Nomenclature



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4. Crimping Condition 4.1 Applicator Crimp

	plicable Tab P/N	Tab(S) 353537,1565963	Tab(SM) 1123654	Remarks				
np Condition								
Cut-off	Tab Length	0.5 m	m Max.	Fig.1-①				
D - Ilina - Latin	Front	0.4 m	m Max.	Fig 1 (2)				
Beilmouth	Rear	0.2~0	0.5 mm	Fig.1-2				
Deformation Bend		-1°,+	2° Max.					
3 After	Twist	±4° Max.		Fig.1-3				
Crimping	Rolling	±10°						
4 Contact Width after Crimping		2mm Max.	n Max. 2.32mm Max.					
Wire End Pr	otrusion Length	0~`	Fig.1-5					
Wire Insulation Stripping Length (before crimping)		4~4	Fig.1-6					
Wire B	arrel Seam		Fig.1-⑦					
Insula	ation End	Insulation End must be	Fig.1-®					
	Ap np Condition Cut-off Bellmouth Deformation After Crimping Contact Wid Wire End Pr Wire Insulatio (before Wire B	Applicable Tab P/N np Condition Cut-off Tab Length Bellmouth Rear Deformation After Crimping Contact Width after Crimping Wire End Protrusion Length	Applicable Tab P/NTab(S) 353537,1565963np ConditionCut-off Tab Length0.5 miCut-off Tab Length0.4 mBellmouthFront0.4 mBellmouthRear0.2~0Deformation After CrimpingBend-1° , +After CrimpingTwist±4°Rolling±10°Contact Width after Crimping2mm Max.Wire End Protrusion Length (before crimping)0~1°Wire Barrel SeamSeam must be (No strand looses)Insulation EndInsulation End must be	Applicable Tab P/N Tab(S) 353537,1565963 Tab(SM) 1123654 Cut-off Tab Length 0.5 mm Max. Bellmouth Front 0.4 mm Max. Bellmouth Rear 0.2~0.5 mm Deformation After Crimping Bend -1°, +2° Max. Rolling ±4° Max. Contact Width after Crimping 2mm Max. Wire End Protrusion Length 0~1 mm Wire Insulation Stripping Length (before crimping) Seam must be neatly closed. (No strand looses out of the seam.) Wire Barrel Seam Insulation End must be between Wire barrel and				

4.2 Hand Tool Crimp

Applicable Tab P/N Crimp Condition			Tab(S) 1376703	Tab(SM) 1376705	Remarks	
	<u></u>	Front	0.4 mm			
1	Bellmouth	Rear	0.1~0.0		Fig.1-2	
	Deformation	Bend	±5° M	Max.		
2	After	Twist	±4° N	Fig.1-3		
	Crimping	Rolling	±10°	Max.]	
3	Contact W		2mmMax.	2.32mm Max.	Fig.1-④	
	Crimping ⁽¹⁾					
4	Wire End Prot	rusion Length	0~11	Fig.1-5		
5	Wire Insulation S	Stripping Length	4.0~4.5 mm (be	Fig.1-6		
6	Wire Barr	el Seam	Seam must be	Fig.1-⑦		
		er ocam	(No strand looses of	· .9. · ·		
		Insulation End must be between Wire barrel Insulation End and				
7	Insulatio					
			Insulation	Barrel		

NOTE (1)There is possibility of the dimension is different caused of the ability of operator. Make sure the contact must be inserted smoothly into the Cap housing.



5. Crimp Data

5.1 Applicator Crimp

Contact		Vire Size Applicator		Wire Barrel Crimp(mm)			Insulation Barrel Crimp (mm)		
Part Number (Strip Form)	(Nominal)	Part Number	Width ⁽³⁾	Height ⁽¹⁾	Disk Ltr.	Width ⁽³⁾	Height ⁽¹⁾	Disk Ltr.	Tensile Strength ⁽²⁾ (N)
353537	AVSS/CAVS 0.3	409571-2		1.17	B, C ⁽⁵⁾				59 Min.
(S)	AVSS/CAVS 0.5	1596465-2 ⁽⁴⁾	1.7"F"	1.26	Α	1.57"F"	See Para. 6	See Para. 6	88 Min.
1565963	AVSS/CAVS 0.3 CHFUS 0.35			1.15	D				59 Min.
	AVSS/CAVS 0.5 CHFUS 0.5	1596465-2		1.23	В				88 Min.
1123654 (MS)	AVSS/CAVS CAVUS 0.85	1276073-2	2.03"F"	1.39	А	2.16"F"	See Para. 6	See Para. 6	127 Min.

NOTE (1) Wire Barrel Crimp Height to be within ± 0.05

(2) Crimp Tensile Strength includes the wire grip of insulation barrel crimp.

(3) Crimp Width dimensions are not the product width after crimping , but given by the width of crimper slot for reference

(4)Applicator of P/N1596465-2 is available for 353537 and 1565963.

(5)409571-2 : B , 1596465-2 : C

Contact Part Number (Loose Piece)	Wire size (Nominal)	Hand Tool Part Number	Insulation Diameter (mm)	Crimp Symbol	Wire Barrel Crimp Height (mm) ⁽¹⁾	Crimp Tensile Strength ⁽²⁾ (N)
1376703	0.3					59 Min.
(S)	0.5]	1.4-1.7	22-20	1.08-1.24	88 Min.
1376705 (MS)	0.85	1463381-1	1.5-1.9	18	1.21-1.37	127 Min.
	(1) This tool is	f				

5.2 Hand Tool Crimp

(1) This tool is for maintenance. The different dimension may be caused according to the ability of operator. Except for the purpose above, you should use the applicator.

(2) Crimp Tensile Strength includes the wire grip of insulation barrel crimp.

o. Insulation Darrei Oninp Data									
_		AVSS/CAVS		CAV	บร	CHFUS			
Contact	Wire Size	Height ⁽²⁾	Disk	Height ⁽²⁾	Disk	Height ⁽²⁾	Disk		
Part Number	(Nominal)	(mm)	Ltr.	(mm)	Ltr.	(mm)	Ltr.		
(Strip Form)			(Ref.)		(Ref.)		(Ref.)		
	AVSS/CAVS 0.3	2.8	3						
353537(S)	AVSS/CAVS 0.5	2.9	3						
	AVSS/CAVS 0.3	2.5	5				<u></u>		
	AVSS/CAVS 0.5	2.7	5						
1565963	CHFUS 0.35					2.2	7		
	CHFUS 0.5					2.35	7		
1123654(MS)	AVSS/CAVS/ CAVUS 0.85	2.7	4	2.55	7				

6. Insulation Barrel Crimp Data

NOTE (1)There is possibility of the dimension is different caused of the ability of operator.

Make sure the contact must be inserted smoothly into the Plug housing.

(2) Insulation Barrel Crimp Height to be within ± 0.1

7. Applicable Wire Data

	Number/	Calculated Cross	Insulation Diameter (mm)						
Wire Size (Nominal)	Diameter of conductor	sectional	AVSS	CAVS	CA	vus	СНЕ	US	
(Norrinal)	(mm)	Area (mm²)	STD.	MAX.	STD.	MAX.	STD.	MAX.	
0.3	7/0.26	0.37	1.4	1.5					
0.35	7/Compressed	0.34					1.1	1.2	
	7/0.32	0.56	1.6	1.7					
0.5	7/Compressed	0.50					1.25	1.40	
0.85	11/0.32	0.88	1.8	1.9	1.5	1.6			

NOTE

(1) Please follow the clause "6" about applicable wires of each connectors.

(2) Please follow the instruction sheet or specification of each application connector. because that is often different from that of the application connector