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 .040III Unsealed Contact ,Tab.

2. Applicable Contacts

Contact Part Numbers*		Description	Finish	Applicable Wires
Strip Form	Loose Piece			
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

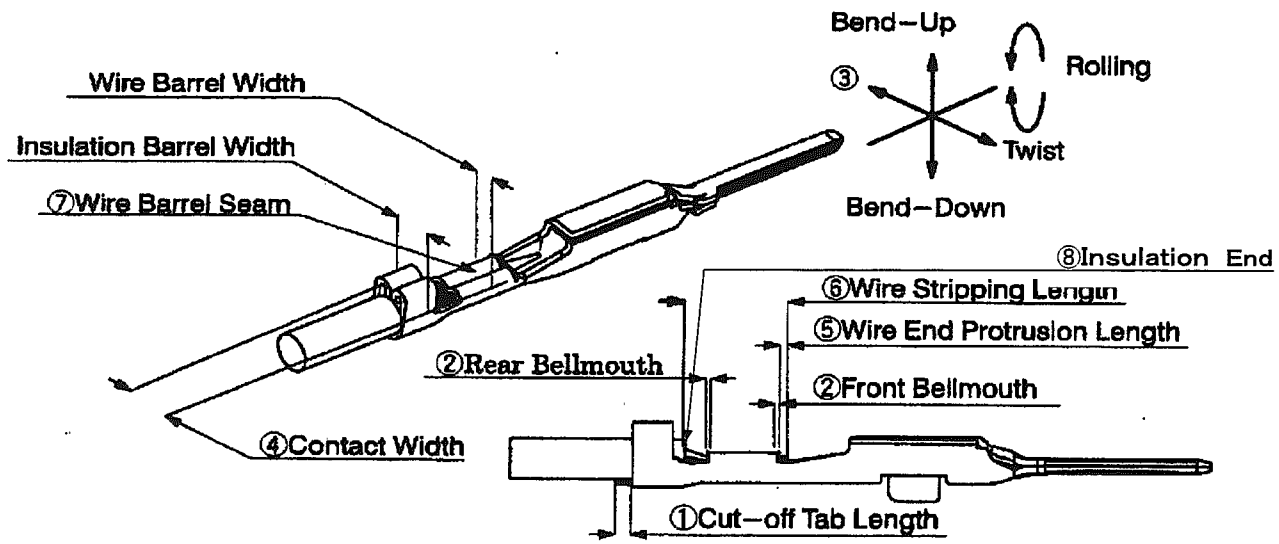

Fig.1

4. Crimping Condition

4.1 Applicator Crimp

Crimp Condition \ Applicable Tab P/N			Tab(S) 353537,1565963	Tab(SM) 1123654	Remarks
1	Cut-off Tab Length		0.5 mm Max.		Fig.1-①
2	Bellmouth	Front	0.4 mm Max.		Fig.1-②
		Rear	0.2~0.5 mm		
3	Deformation After Crimping	Bend	-1° , +2° Max.		Fig.1-③
		Twist	±4° Max.		
		Rolling	±10° Max.		
4	Contact Width after Crimping		2mm Max.	2.32mm Max.	Fig.1-④
5	Wire End Protrusion Length		0~1 mm		Fig.1-⑤
6	Wire Insulation Stripping Length (before crimping)		4~4.5 mm		Fig.1-⑥
7	Wire Barrel Seam		Seam must be neatly closed. (No strand looses out of the seam.)		Fig.1-⑦
8	Insulation End		Insulation End must be between Wire barrel and Insulation Barrel		Fig.1-⑧

4.2 Hand Tool Crimp

Crimp Condition \ Applicable Tab P/N			Tab(S) 1376703	Tab(SM) 1376705	Remarks
1	Bellmouth	Front	0.4 mm Max.		Fig.1-②
		Rear	0.1~0.6 mm		
2	Deformation After Crimping	Bend	±5° Max.		Fig.1-③
		Twist	±4° Max.		
		Rolling	±10° Max.		
3	Contact Width after Crimping[1]		2mmMax.	2.32mm Max.	Fig.1-④
4	Wire End Protrusion Length		0~1 mm		Fig.1-⑤
5	Wire Insulation Stripping Length		4.0~4.5 mm (before crimping)		Fig.1-⑥
6	Wire Barrel Seam		Seam must be neatly closed (No strand looses out of the seam.)		Fig.1-⑦
7	Insulation End		Insulation End must be between Wire barrel and Insulation Barrel		Fig.1-⑧

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

5.2 Hand Tool Crimp

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 (S)	0.3	1463381-1	1.4-1.7	22-20	1.08-1.24	59 Min.
	0.5					88 Min.
1376705 (MS)	0.85		1.5-1.9	18	1.21-1.37	127 Min.

NOTE (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.

6. Insulation Barrel Crimp Data

Contact Part Number (Strip Form)	Wire Size (Nominal)	AVSS/CAVS		CAVUS		CHFUS	
		Height(2) (mm)	Disk Ltr. (Ref.)	Height(2) (mm)	Disk Ltr. (Ref.)	Height(2) (mm)	Disk Ltr. (Ref.)
353537(S)	AVSS/CAVS 0.3	2.8	3	—	—	—	—
	AVSS/CAVS 0.5	2.9	3	—	—	—	—
1565963	AVSS/CAVS 0.3	2.5	5	—	—	—	—
	AVSS/CAVS 0.5	2.7	5	—	—	—	—
	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	—	—

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

Wire Size (Nominal)	Number/ Diameter of conductor (mm)	Calculated Cross sectional Area (mm^2)	Insulation Diameter (mm)					
			AVSS/CAVS		CAVUS		CHFUS	
			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
0.5	7/0.32	0.56	1.6	1.7	—	—	—	—
	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