

114-5232

NUMBER:

Customer Release

SECURITY CLASSIFICATION:

Application Specification

114-5232

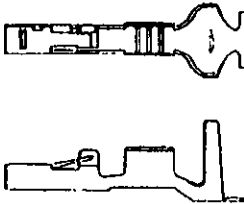
Crimping of Power Cord Contact

1. Scope :

1.1 Contents

This specification covers the requirements for crimping of Power Cord Contact.

2. Application Contacts :

Contact Features	Contact Part Nos.	Wire Sizes mm ² (AWG)	Remarks
	353439-1	(AWG #20~#16) 0.5~1.42	

DR. 11. Nov. '96

T. Yamamoto

CHK.

+

APP. 24 FEB 97

M. Shinde

SHEET
1
OF
5

AMP
AMP (Japan), Ltd.
Kawasaki, Japan

LOC
J

LOC
A

NO.

114-5232

REV.
0

NAME

Crimping of Power Cord Contact

PRINT

DIST.

0	Released FJ00-5475-96	R	M.S.	24 FEB 97
LTR	REVISION RECORD	DR	CHK	DATE

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3. Nomenclature and Crimping Features :

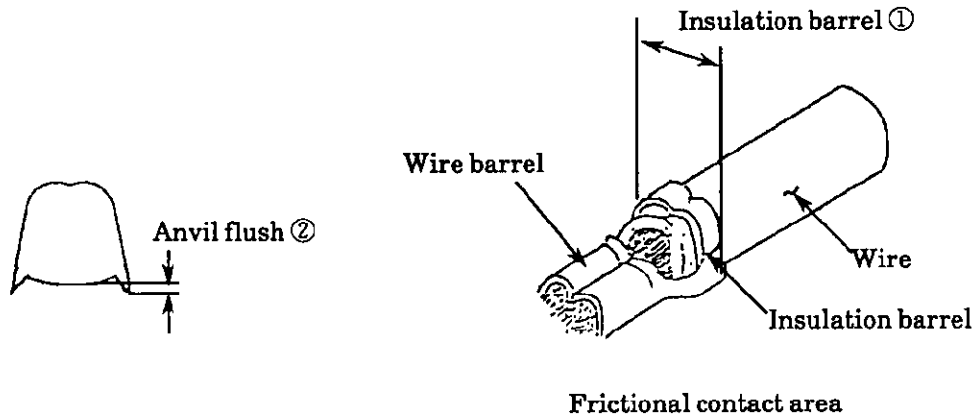


Fig. 1

Cut-Off tab Length

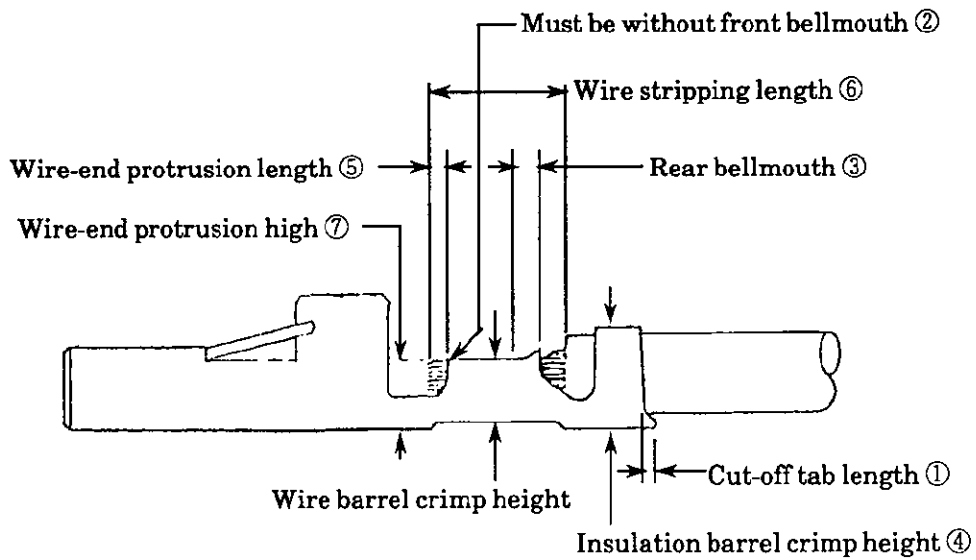


Fig. 2

SHEET 2 OF 5	AMP		AMP (Japan), Ltd. Kawasaki, Japan	
	LOC J	LOC A	NO. 114-5232	REV. 0
NAME Crimping of Power Cord Contact				

4. Crimping Conditions and Crimp Data :

4.1 Crimping Conditions :

No.	Checking Items		Requirements	Remarks
1	Allowable Deviation after Crimping	Bend-up	3° Max.	Fig. 3 ①
		Bend-down	3° Max.	Fig. 3 ②
		Twisting	4° Max.	Fig. 3 ③
		Rolling	5° Max.	Fig. 3 ④
2	Cut-off Tab Length		0.5 mm Max.	Fig. 2 ①
3	Bellmouth	Front	Must be without front bellmouth.	Fig. 2 ②
		Rear	0.1~0.7 mm	Fig. 2 ③
4	Ins. Barrel Crimp	Height	4.3 mm Max.	Fig. 2 ④
		Width	4.5 mm Max.	Fig. 1 ①
5	Anvil Flush		0.2 mm Max.	Fig. 1 ②
6	Wire-End Protrusion Length		Wire-end must protrude beyond the front edge of wire barrel, but shall not exceed 1.5 mm.	Fig. 2 ⑤
7	Insulation Stripping Length	One-wire Crimp	5.0±0.5 mm	Fig. 2 ⑥
8	Wire-End Protrusion Height		1.85 mm Max.	Fig. 2 ⑦

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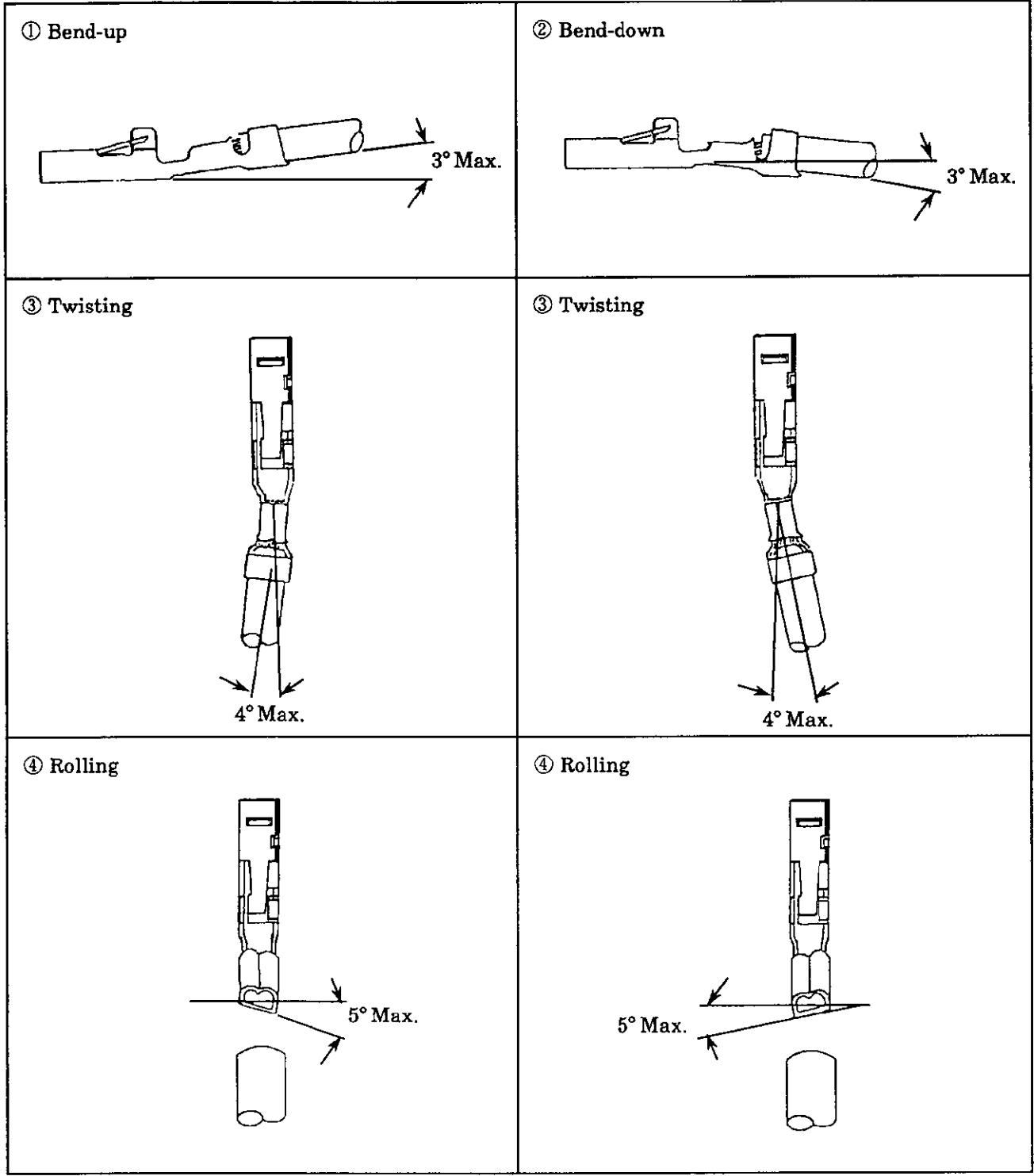


Fig. 3

SHEET 4 OF 5	AMP		AMP (Japan), Ltd. Kawasaki, Japan	
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NAME Crimping of Power Cord Contact				

5. Crimp Data :

Application Crimp :

Contact Part No. (Strip Form)	Applicator Number	Wire Size		Insulation Stripping Length ± 0.5 (mm)	Wire Barrel Crimp			Insulation Barrel Crimp Width (mm)	Finished Insulation Diameter (mm)	Crimp Tensile Strength (kg) (Min.)
		No. of Wires	mm ² (AWG)		Width (mm)	Crimp Height (mm)	Disc Letter			
353439-1	409593-2	1	0.5 (#20)	5.0	1.78 "F"	1.10	C	4.32 "F"	2.0~3.8	6
		1	0.75 (#18)		1.78 "F"	1.23	B			7
		1	1.25 (#16)		1.78 "F"	1.46	A			8

Notes : (1) Tolerance of wire barrel crimp height must be ± 0.05 mm.

- (2) When stripping the wire, care must be taken not to nick, cut or damage the wire conductors, and the stripped wire end must appear straight and neat.
- (3) The inner part of the wire barrel must be kept clean, being free from the contamination by foreign particles and lubrication.
- (4) The wire conductors must be crimped within wire barrel, and any part of the conductors shall not loose out from the wire barrel seam.
- (5) Never allow any portion of wire insulation to be crimped in the wire barrel.
- (6) After crimping, wire insulation shall be securely gripped within the insulation barrel crimp.
- (7) The crimping on the wires having a diameter of 3.0 mm or less may result off-centered crimp of the wire in the insulation barrel. (Fig. 4)



Fig. 4

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