

114-5238

NUMBER:

Customer Release

SECURITY CLASSIFICATION:

114-5238

## Application Specification

## Crimping Drawer Connector Power Line Contact

## 1. Scope:

This specification covers the requirements for crimping Drawer Connector, Power Line Contacts.

## 2. Applicable Contacts:

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

## Part Numbers

353581

Tab Contact, Strip Form

|       |       |   |                 |              |     |     |           |           |           |                       |                                                                        |     |          |      |
|-------|-------|---|-----------------|--------------|-----|-----|-----------|-----------|-----------|-----------------------|------------------------------------------------------------------------|-----|----------|------|
| PRINT | DIST. | 0 | Released        | FJ00-1057-97 | 9 F | 7/4 | 26/SEP/97 | DR.       | 26/SEP/97 | SHEET<br>1<br>OF<br>4 | <b>AMP</b><br>AMP (Japan), Ltd.<br>Kawasaki, Japan                     |     |          |      |
|       |       |   |                 |              |     |     |           | CHK.      | 26/SEP/97 |                       | LOC                                                                    | LOC | NO.      | REV. |
|       |       |   |                 |              |     |     |           | J. Yamada |           |                       | J                                                                      | A   | 114-5238 | 0    |
|       |       |   |                 |              |     |     |           | APP.      | 26/SEP/97 | NAME                  | Application Specification Crimping Drawer Connector Power Line Contact |     |          |      |
|       |       |   |                 |              |     |     |           | J. Yamada |           |                       |                                                                        |     |          |      |
| LTR   |       |   | REVISION RECORD |              | DR  | CHK | DATE      |           |           |                       |                                                                        |     |          |      |

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## 3. Nomenclature:

## 3.1 Tab Contact:

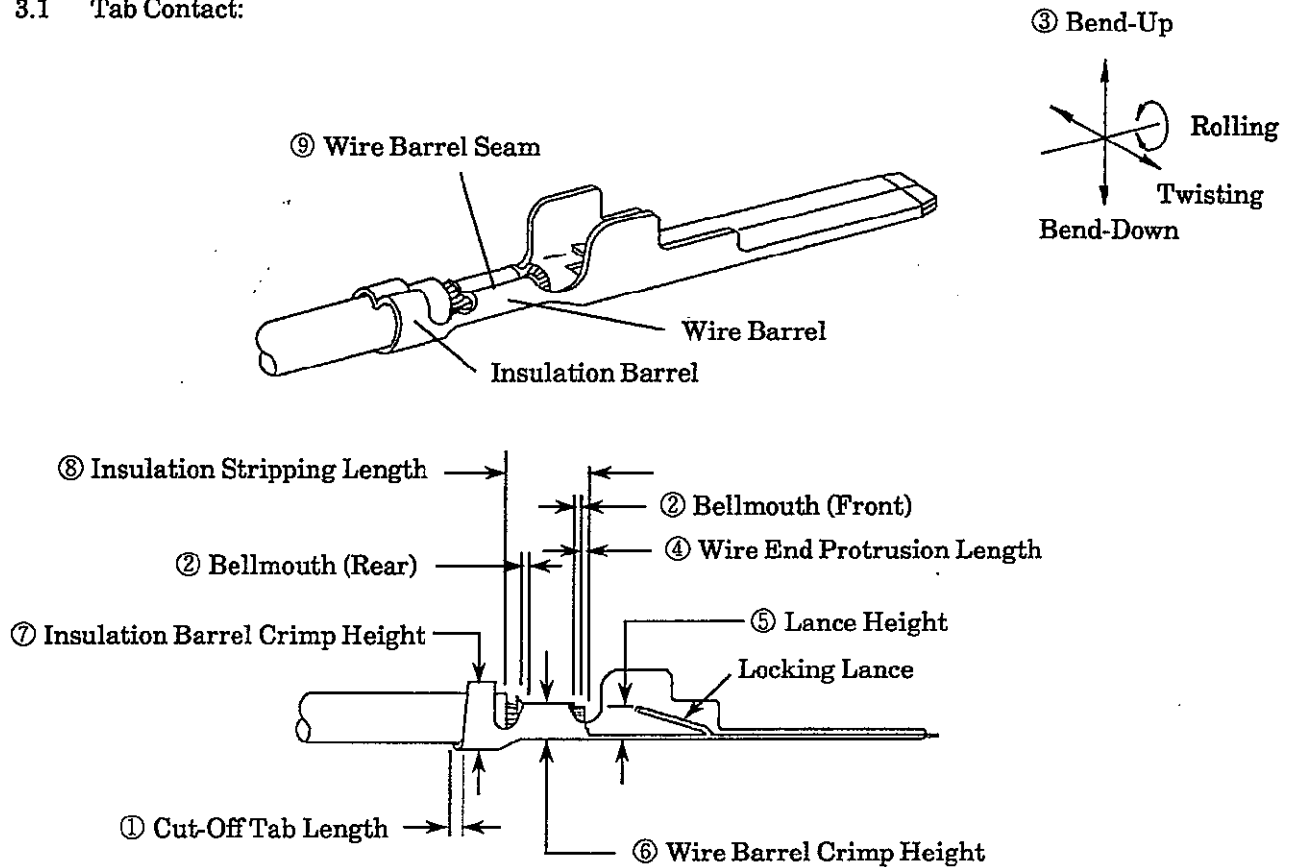


Fig. 1

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## 4. Crimping Conditions and Crimp Data:

## 4.1 Crimping Conditions:

| Item Nos. | Categories<br>Check Items   |           | Crimping Conditions                                                                                                                   | Remarks |
|-----------|-----------------------------|-----------|---------------------------------------------------------------------------------------------------------------------------------------|---------|
|           |                             |           | Tab Contacts                                                                                                                          |         |
|           |                             |           | Part Number: 353581                                                                                                                   |         |
| 1         | Cut-Off Tab Length          |           | 0.5 mm Max.                                                                                                                           | Fig. ①  |
| 2         | Bellmouth                   |           | Front bellmouth must be visually confirmed.<br>0.15~0.65 mm (For hand tool crimping only, rear bellmouth must be visually confirmed.) | Fig. ②  |
| 3         | Deformation after Crimping  | Bend-Up   | 5° Max.                                                                                                                               | Fig. ③  |
|           |                             | Bend-Down | 5° Max.                                                                                                                               |         |
|           |                             | Twisting  | 5° Max.                                                                                                                               |         |
|           |                             | Rolling   | 10° Max.                                                                                                                              |         |
| 4         | Wire End Protrusion Length  |           | 0~0.8 mm                                                                                                                              | Fig. ④  |
| 5         | Locking Lance Height        |           | 1.6~2.2 mm                                                                                                                            | Fig. ⑤  |
| 6         | Insulation Stripping Length |           | 3.5~4.0 mm (Ref.)                                                                                                                     | Fig. ⑧  |
| 7         | Wire Barrel Seam            |           | Seam must be neatly closed.                                                                                                           | Fig. ⑨  |

## 4.2 Crimp Data:

## 4.2.1 Applicator Crimp:

| Contact Part No.<br>(Strip Form) | Wire Size<br>mm <sup>2</sup> (AWG) | Wire Barrel Crimp |                                  |           | Insulation<br>Barrel<br>Crimp<br>Width | Crimp<br>Tensile<br>Strength<br>(kg) (min.) |
|----------------------------------|------------------------------------|-------------------|----------------------------------|-----------|----------------------------------------|---------------------------------------------|
|                                  |                                    | Width             | Height<br>See Note 1<br>Fig. 1-6 | Disc Ltr. |                                        |                                             |
| 353581                           | 0.85 (#18)                         | 2.3               | 1.34                             | C         | 3.56                                   | 13                                          |
|                                  | 1.25 (#16)                         | "F"               | 1.50                             | A         | "F"                                    | 18                                          |

- Notes : (1) The tolerance for wire barrel crimp height to be within  $\pm 0.05$  mm.  
 (2) Unless otherwise indicated, all the figures in the columns are in mm.

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## 5. Applicable Wires:

| Wire Size<br>mm <sup>2</sup> (AWG) | Number of Conductors/<br>Diameter of Conductor<br>(N/mm) | Calculated<br>Crosssectional<br>Area (mm <sup>2</sup> ) | Finished Wire<br>Insulation<br>Diameter (mm) | Applicable<br>Specification |
|------------------------------------|----------------------------------------------------------|---------------------------------------------------------|----------------------------------------------|-----------------------------|
| 0.85 (# 18)                        | 34/0.18                                                  | 0.87                                                    | 2.85                                         | UL 1015                     |
| 1.25 (# 16)                        | 54/0.18                                                  | 1.37                                                    | 2.53                                         | UL 1015                     |

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