

NUMBER: 114-5238

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 covered under this specification.

Part Numbers

353581

Tab Contact, Strip Form

PRINT	DIST.					DR. 26/SEP/97 T. Furukawa	SHEET 1 OF 4	AMP AMP (Japan), Ltd. Kawasaki, Japan		
						CHK. 26/SEP/97 T. Yamada				
LTR	0	Released	FJ00-1057-97	9.F. 7/1	26/SEP/97 T. Yamada	APP. 26/SEP/97 T. Yamada	NAME Application Specification Crimping Drawer Connector Power Line Contact			
		REVISION RECORD		DR	CHK	DATE				

Sept. 26, 1997

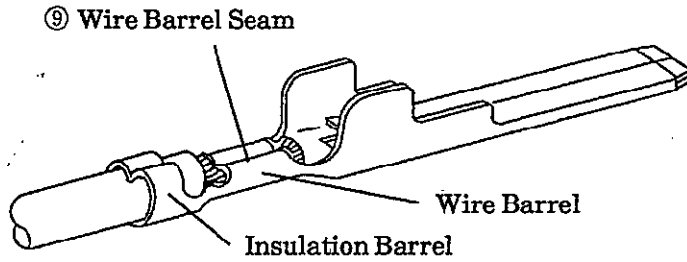
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3. Nomenclature:

3.1 Tab Contact:



③ Bend-Up

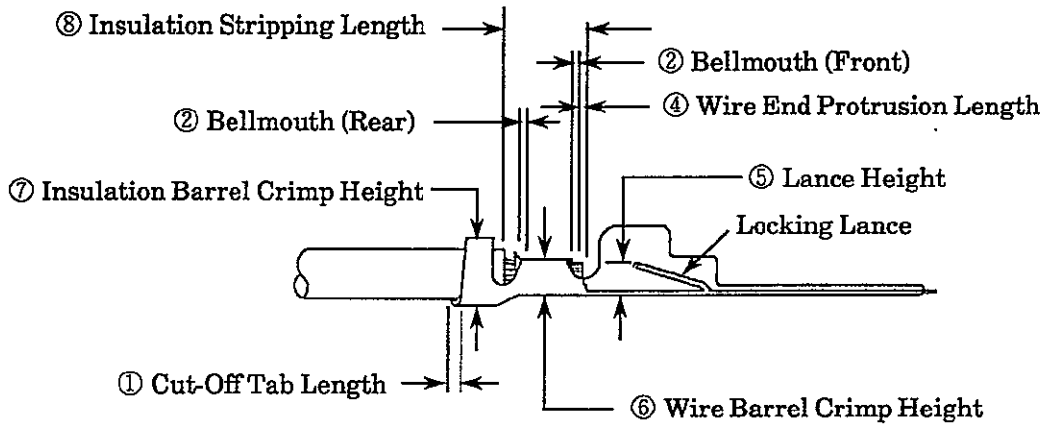
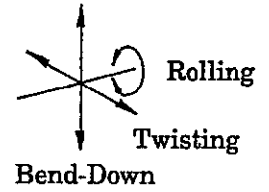


Fig. 1

SHEET 2 OF 4	AMP		AMP (Japan), Ltd. Kawasaki, Japan	
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4. Crimping Conditions and Crimp Data:

4.1 Crimping Conditions:

Item Nos.	Categories 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.		Fig. ②
			0.15~0.65 mm (For hand tool crimping only, rear bellmouth must be visually confirmed.)		
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. (Strip Form)	Wire Size mm ² (AWG)	Wire Barrel Crimp			Insulation Barrel Crimp Width	Crimp Tensile Strength (kg) (min.)
		Width	Height See Note 1 Fig. 1-6	Disc Ltr.		
353581	0.85 (#18)	2.3 "F"	1.34	C	3.56 "F"	13
	1.25 (#16)		1.50	A		18

- Notes : (1) The tolerance for wire barrel crimp height to be within ± 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 mm ² (AWG)	Number of Conductors/ Diameter of Conductor (N/mm)	Calculated Crosssectional Area (mm ²)	Finished Wire Insulation Diameter (mm)	Applicable 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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