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 CLEAN BODY 025/040 Receptacle Contact.

2. Applicable Contacts

Contact Part NO.*	Descriptions	Finish
1318329	CLEAN BODY 025Receptacle Contact M Type	Tin-Plated
1717148	CLEAN BODY 025Receptacle Contact S Type	Tin-Plated
1318332	CLEAN BODY 040Receptacle Contact M Type	Tin-Plated
1612775	CLEAN BODY 040Receptacle Contact C Type	Tin-Plated
1612776	CLEAN BODY 040Receptacle Contact S Type	Tin-Plated

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

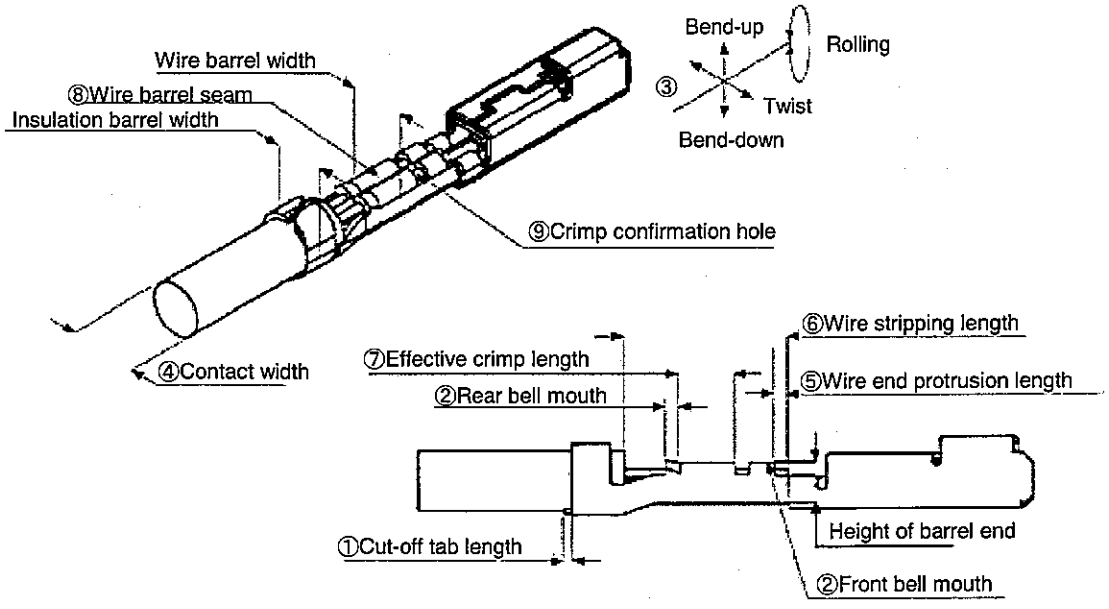

Fig.1

4. Crimping Condition

Crimping conditions \ Applicable terminal Numbers			CLEAN BODY 025 Receptacle Contact		CLEAN BODY 040 Receptacle Contact			備考
			M 1318329	S 1717148	M 1318332	C 1612775	S 1612776	
1	Cut-off Tab length		0.25 mm Max					Fig.1-①
2	Bell mouth	Front	0 mm					Fig.1-②
		Rear	0.2～0.5 mm					
3	Deformation after crimping	Bend	±3° Max					Fig.1-③
		Twist	±4° Max					
		Rolling	±10° Max					
4	Contact width after crimping		2.03mm Max		2.35mm Max			Fig.1-④
5	Wire end protrusion length		0mm					Fig.1-⑤
6	Wire insulation stripping length (2)		4.5～5 mm					Fig.1-⑥
7	Effective crimp length (1)		2 mm					Fig.1-⑦
8	Wire barrel seam		Seam must be nearly closed					Fig.1-⑧
9	Confirmation of crimping		Wire must be seen in the crimp confirmation hole					Fig.1-⑨

NOTE (1) Crimp height must keep the specification in this length.

(2) The wire must be using smooth insulation surface. Do not use the one that there is a wound and a deformation in the wire insulation surface when the contact crimping.

5. Crimp Data

Terminal PN (Strip form)	Wire size (Nominal)	Applicator PN	Wire barrel crimp (mm)				Ins barrel crimp(mm)		Crimp tensile strength (4) (N) Min
			Width (5)	Height	Height of barrel end (Ref.)	Disc letter.	Width (5)	Height	
1318329	0.5	1276939-2	1.57 "F"	0.92 (1)	1.05	C	1.78 "O"	See par. 6	88
	0.75			1.02(1)	1.15	B		See par. 6	118
	0.85			1.08(1)	1.21	A		See par. 6	127
1717148	0.3	1596934-2	1.4 "F"	0.79(2)	0.92	B	1.78 "O"	See par. 6	59
	0.5			0.88(2)	1.01	A		See par. 6	88
1318332	0.75	1276941-2	1.78 "F"	1.14(1)	1.27	D	2.19 "O"	See par. 6	118
	0.85			1.19(1)	1.32	C		See par. 6	127
	1.0			1.26(1)	1.39	B		See par. 6	150
	1.25			1.35(1)	1.48	A		See par. 6	176
1612775	0.3	1596476-2	1.4 "F"	0.91(3)	1.04	B	2.19 "O"	See par. 6	59
1612776	0.3	1596477-2	1.4 "F"	0.91(3)	1.04	B	1.78 "O"	See par. 6	59
	0.5			1.00(3)	1.13	A		See par. 6	88

NOTE (1) Wire barrel crimp height to be within ±0.05

(2) Wire barrel crimp height to be within ±0.03

(3) Wire barrel crimp height to be within ±0.04

(4) Crimp tensile strength includes the wire grip of insulation barrel crimp.

(5) The crimp width dimensions are not the product width after crimping, but given by the width of crimper slot for reference

6. Insulation Barrel Crimp Data

Terminal PN	Wire size (Nominal) (mm^2)	CHFUS Height (mm)[2]	CAVUS Height (mm)[2]	AVSS/CAVS Height (mm)[2]	CHFS Height (mm)[2]	CAN Height (mm)[2]
1318329	0.5	1.65	1.65	1.9	—	—
	0.75	—	—	—	1.9	—
	0.85	—	—	2.05	—	—
1717148	0.3	1.65	—	1.7	—	—
	0.5	1.65	—	1.85	—	—
1318332	0.75	—	—	2.15	2	—
	0.85	—	—	2.15	—	—
	1.0	2	—	—	—	—
	1.25	—	2.2	2.4	—	—
1612775	0.3	—	—	—	—	2.3
	0.5	—	—	—	—	—
1612776	0.3	1.6	—	1.8	—	—
	0.5	1.85	1.85	2.0	—	—

NOTE (1) -- marks indicate the wires being not applicable to this listing.

(2) Insulation barrel crimp height and applicable disk letter (reference)are applied to applicator crimp only with the tolerance of ±0.1mm.

(3) As slight cut – in of insulation barrel into insulation is permissible ,for this causes no problem in actual use.

7. Applicable Wire Data

Wire size		No of Conductor / Diameter of conductor (mm)	Calculated cross section (mm^2)	Insulation diameter (mm)	
Nominal (mm^2)	Type			Standard	Maximum
0.3	AVSS/CAVS	7/0.26	0.37	1.4	1.5
	CAN	7/C.C (3)	0.35	2.0	2.1
0.35	CHFUS	7/C.C (3)	0.34	1.1	1.2
0.5	AVSS/CAVS	7/0.32	0.56	1.6	1.7
	CAVUS	7/0.32	0.56	1.3	1.4
	CHFUS	7/C.C (3)	0.49	1.25	1.4
0.75	AVSS	19/0.23	0.79	1.8	1.9
	CHFS	11/C.C (3)	0.73	1.6	1.7
0.85	AVSS/CAVS	11/0.32	0.88	1.8	1.9
1	CHFUS	19/0.265	1.05	1.6	1.7
1.25	AVSS/CAVS	16/0.32	1.29	2.1	2.2
	CAVUS	16/0.32	1.29	1.8	1.9

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.

(3) Circular Compressed.