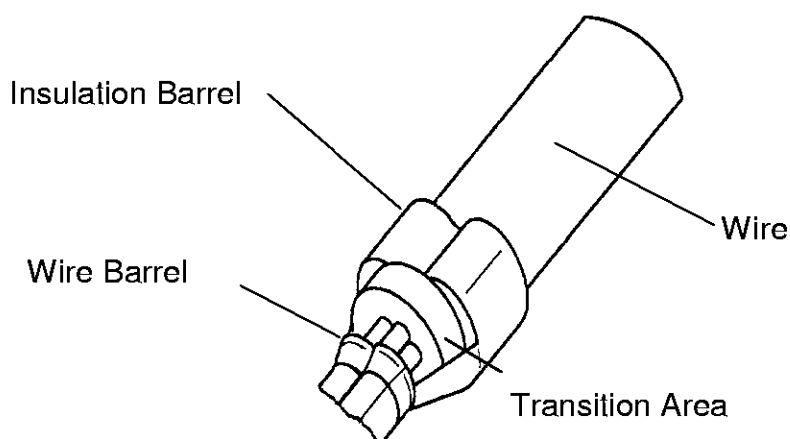


**AMP 2.5mm Pitch EMIX
Economic Metric Interconnect Series
Wire-To-Board System.****1. SCOPE**

This specification covers the requirements for crimping of 2.5mm pitch EMIX (Economic Metric Interconnect Series, Crimp Type, Wire-To-Board System) Connector. These requirements are applicable to specific tools. For specific wire and products covers in this specification refer to the appropriate AMP customer drawing.

2. APPLICABLE PRODUCT

Contact Form	Product Part Number	Crimping Tool	Wire Size (SQ mm)	Ins. Diameter (mm)
Strip Terminal	X-1470223-X	Applicator	0.08 ~ 0.32mm2 (AWG #28 ~ #22)	ϕ 1.2 ~ ϕ 1.7mm

3. NOMENCLATURE

DR	DATE	APVD	DATE
Oblic Hu	22-Jan-2002	Jebb Wu	22-Jan-2002
FZ00-0009-02			

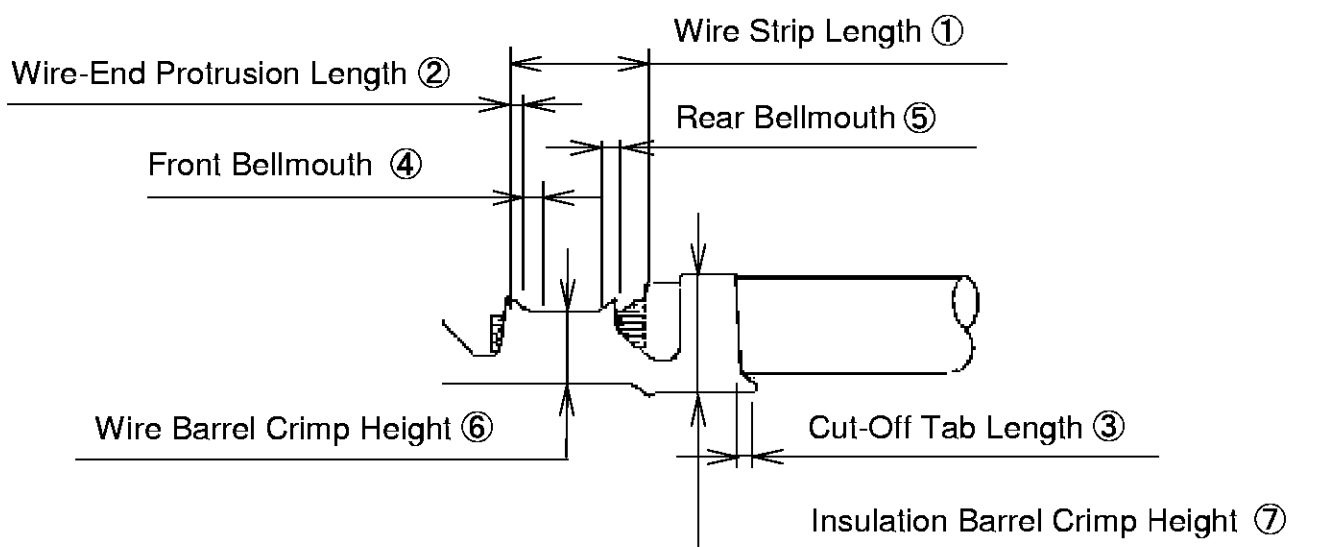
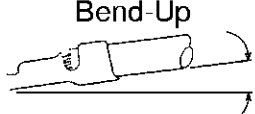
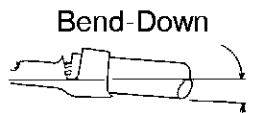
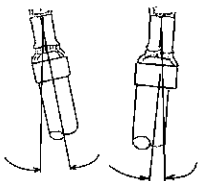
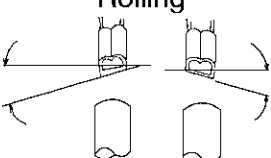


FIG 1.

4. CRIMPING REQUIREMENT

No.	Check Items		Crimping Requirements		Remarks
			Applicator	Hand Tool	
1	Wire Strip Length		2.5 ~ 3.0 mm		Fig.1—①
2	Wire-End Protrusion Length		0.3 ~ 0.6 mm		Fig.1—②
3	Cut-Off Tab Length		0 ~ 0.2 mm		Fig.1—③
4	Bellmouth	Front	Front bellmouth can be visible.		Fig.1—④
		Rear	0.2 ~ 0.4 mm		Fig.1—⑤
5	Wire Barrel Crimp		Refer Table.1		Fig.1—⑥
7	Insulation Barrel Crimp Height		Refer Table.1		Fig.1—⑦
8	Allowable Deviation after Crimping	Bend-Up 	6° Max.	6° Max.	
9		Bend-Down 	6° Max.	6° Max.	

10		Twisting 	5° Max.	5° Max.	
11		Rolling 	7° Max.	7° Max.	

5. CRIMPING DATA

Table.1

Contact Part Number	Applicator Part Number	Wire Size		Insulation Strip Length	Wire Barrel		Insulation Barrel	
		Number of Wire	Size		Crimp Width (D)	Crimp Height (C)	Crimp Width (B)	Crimp Height (A)
X-1470223-X	X-1470223-X	1	0.32mm ² (#22)	2.5~3.0 mm	1.35mm	0.80mm	1.75mm	1.60mm
		1	0.21mm ² (#24)		1.35mm	0.70mm	1.75mm	1.50mm
		1	0.13mm ² (#26)		1.35mm	0.65mm	1.70mm	1.45mm
		1	0.08mm ² (#28)		1.30mm	0.60mm	1.70mm	1.40mm

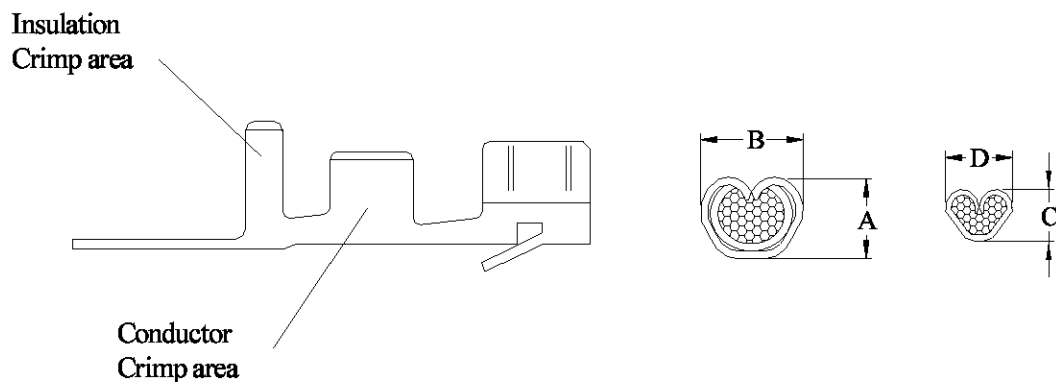


Table.2

Wire Size		Crimp Tensile Strength
mm2	AWG#	N (kgf) Min.
0.22	22	34.3 (3.5)
0.21	24	29.4 (3.0)
0.13	26	24.5 (2.5)
0.08	28	19.6 (2.0)

Note: (a) Tool mark is allowable at crimped areas and transition areas only.
(b) The dimensions of crimp width of wire barrel and insulation barrel are the dimensions of crimping tool.