# APPLICATION SPECIFICATION

## 1. SCOPE

This specification covers the requirements for application of AMP* PN 66140 taper pin contact. These requirements are applicable to automatic machine crimping tools. For specific wire and insulation ranges relative to the products covered in this specification see Figure 4.

## 2. NOMENCLATURE

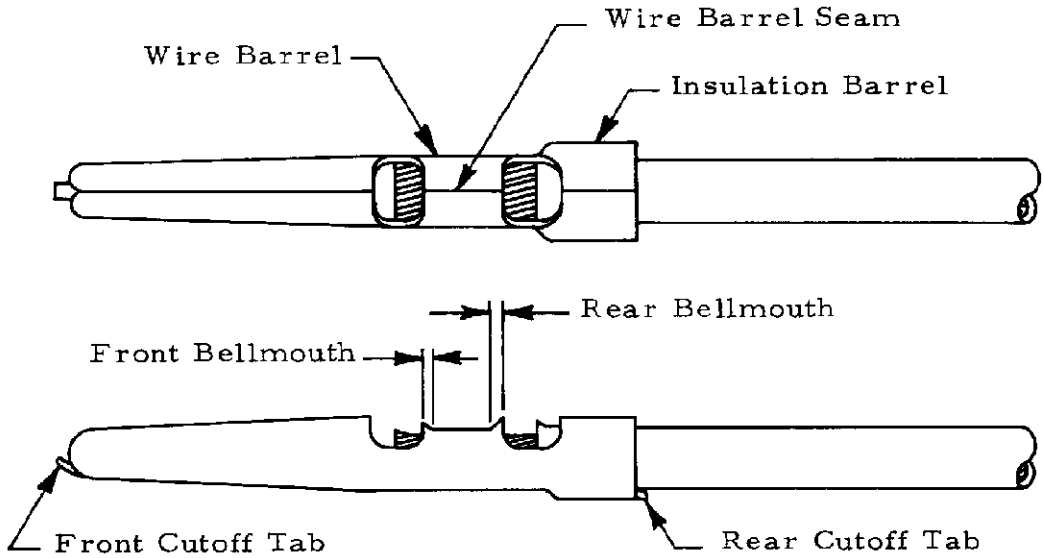


Figure 1

## 3. CRIMP AND DIMENSIONAL REQUIREMENTS

### 3.1. Wire Preparation

A. Strip Length

Insulation shall be stripped as indicated in Figure 4.

B. Workmanship

Reasonable care shall be taken not to nick, scrape or cut any strands or the solid wire during the stripping operation.

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3.2. Carrier Cutoff Tab

A. Front cutoff tab shall not exceed .020 and shall lie within the cone-shaped extension of the taper as indicated in Figure 2.

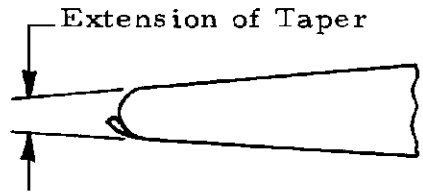


Figure 2

B. Rear cutoff tab shall not exceed .020.

3.3. Wire Barrel Crimp

A. Crimp Dimensions and Type

Crimp height, width and type shall be as shown in Figure 4.

B. Wire Barrel Seam

Wire barrel seam shall be completely closed and there shall be no evidence of loose wire strands or wire strands visible in the seam.

C. Bellmouth

(1) Rear bellmouth length shall be .010 - .025.

(2) Front bellmouth length shall not exceed .016.

D. Conductor Location

(1) End of the wire shall be flush with the front end of the wire barrel or extend .032 maximum after crimping.

(2) Both insulation and conductor shall be visible between the insulation barrel and wire barrel. Care shall be taken not to allow insulation to be crimped in the wire barrel.

3.4. Insulation Barrel Crimp

A. Crimp Dimensions and Type

Crimp height, width and type shall be as shown in Figure 4.

B. Workmanship

Reasonable care shall be taken not to cut or break the insulation during the crimping operation.

3.5. Alignment

A. The axial concentricity of the crimped product shall fall into an area defined by a .105 diameter tube whose length exceeds the total length of the crimped contact as indicated in Figure 3.

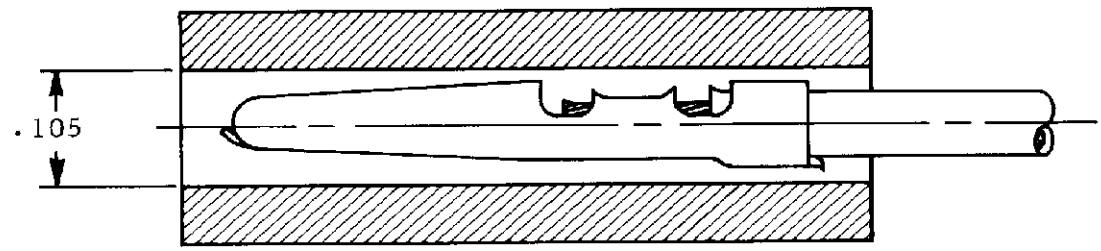


Figure 3

B. Twist or Roll

There shall be no twist or roll in crimped portion that will impair usage of the contact.

| Part No | Wire | | Insulation Diameter | Strip Length ±.015 | Wire Barrel Crimp | | | Insulation Barrel Crimp | | |
|---|---|---|---|---|---|---|---|---|---|---|
| | Qty | Size | | | Width | Height ±.001 | Type Crimper | Width | Height, minimum | Type Crimper |
| 66140 | 1 | 24 | .048-.071 | .156 | .070 | .040 | F | .090 | .085 | F or O |
| | 1 | 22 | | | | | | | | |
| | 1 | 20 | | | | | | | | |

Figure 4

Automatic Machine Wire Crimp Dimensions

| | | | |
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