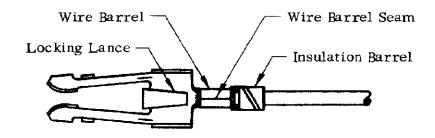
## APPLICATION SPECIFICATION

## 1. SCOPE

This specification covers the requirements for application of modified fork contacts. These requirements are applicable to hand or automatic machine crimping tools. For specific wire and insulation ranges relative to the products covered in this specification see Figure 3 and 4.

#### 2. NOMENCLATURE



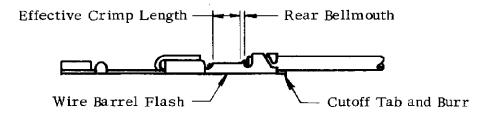


Figure 1

# 3. CRIMP AND DIMENSIONAL REQUIREMENTS

## 3.1. Wire Preparation

#### A. Strip Length

Insulation shall be stripped as indicated in Figure 3 and 4.

## B. Workmanship

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

RESER U.S.					Col E. 7 m	8/28/75 out 1/20/15	A-M	AMP INCORPORA Harrisburg, Pa	
					R. Showna	8/20/25	B A	1000 - 114 · 14	RE B
БT		Rev Para 3.3.E. Rev Fig 3 and 4	ADE	1-13	SHEET		-	ODIFIED FORK,	
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#### 3.2. Carrier Cutoff Tab and Burr

A. Cutoff Tab

Cutoff tab shall not exceed .015.

B. Burr

Burr on cutoff tab shall not exceed .003.

#### 3.3. Wire Barrel Crimp

A. Crimp Dimensions and Type

Crimp height, width and type shall be as shown in Figure 3 and 4.

B. Effective Crimp Length

Effective Crimp Length shall be .085 minimum, and is defined as that portion of the barrel, excluding bellmouth, fully formed by the crimping tool.

C. Wire Barrel Flash

Wire barrel flash shall not exceed .005.

D. Wire Barrel Seam

The wire barrel seam shall be closed adequately to confine all strands of the wire. There shall be no loose wire strands or wire strands embedded in the outside of the wire barrel.

E. Bellmouth

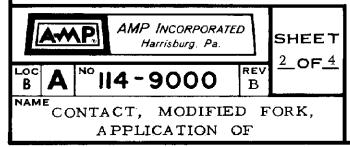
Rear bellmouth length shall be .005 minimum.

- F. Conductor Location
  - (1) End of the wire shall be flush with the front end of the wire barrel or extend .015 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 width and type shall be as shown in Figure 3 and 4.

B. Workmanship

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



# 3.5. Locking Lance

Locking lance shall not be deformed.

# 3.6. Alignment

# A. Straightness

The contact, including the cutoff tab and burr shall not be bent **above** the datum line or more than .015 below the datum line as shown in Figure 2.

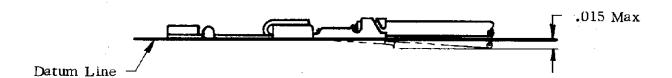
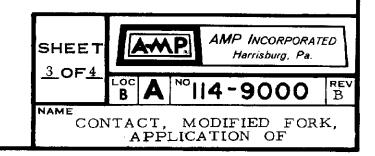


Figure 2

#### B. Twist or Roll

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



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	Wi	Wires	10:40	Strip	Wire	e Barre	l Crimp	Wire Barrel Crimp Insulation Barrel Crimp	arrel Crimp
Part No		Qty Size	Diameter	Length ±.016	Width	Height	Width Height Type Crimper	Width	Type Crimper
	1	20				.042			
583259		22	.050090	.156	.062	.039	1्य	.100	0
	1	24				.037			
( ) ( ) ( ) ( ) ( ) ( ) ( ) ( ) ( ) ( )		18			020	190'	ĺ	-	(
292586	1	20	.070110	.156	0/0.	. 048	-1	011.	O
	1	24	020	7 2 1	1110	080		0	(
583497	1	97	. 020 - 043	061.	cc0 •	.030	4	0/0.	0
	1	28	.030045	.156	.055	.028	ĮΞį	070.	0

Figure 3

Automatic Machine Wire Crimp Dimensions

	Wi	Wires	Inculation	Strip	Wire	Barrel	Wire Barrel Crimp	Insulation Barrel Crimp	arrel Crimp	Hand Tool
Part No	Qty	Qty Size		Length ±.016	Width	Height ±.002	Height Type ±.002 Crimper	Width	Type Crimper	Part No
583261	1	24-20	24-20 .050090	, 156	. 062	. 062 . 039	ഥ	. 100	0	90215-1
583363	1	20-18	20-18 .070110	. 156	.070	.048	F	011.	0	90215-1
00100	1	26-24	26-24 .038045	. 156	. 055	.030	F	020.	0	90253-1
565498		28	28 .030045	156	. 055	.028	F	020	0	
583261	1	24-20	24-20 .050090	156	. 062	.039	F	001	0	90253-1

Figure 4

Hand Tool Wire Crimp Dimensions

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