

114-5047

Application Specification

Crimping of
"312" Series,
Positive Lock Receptacle Contact

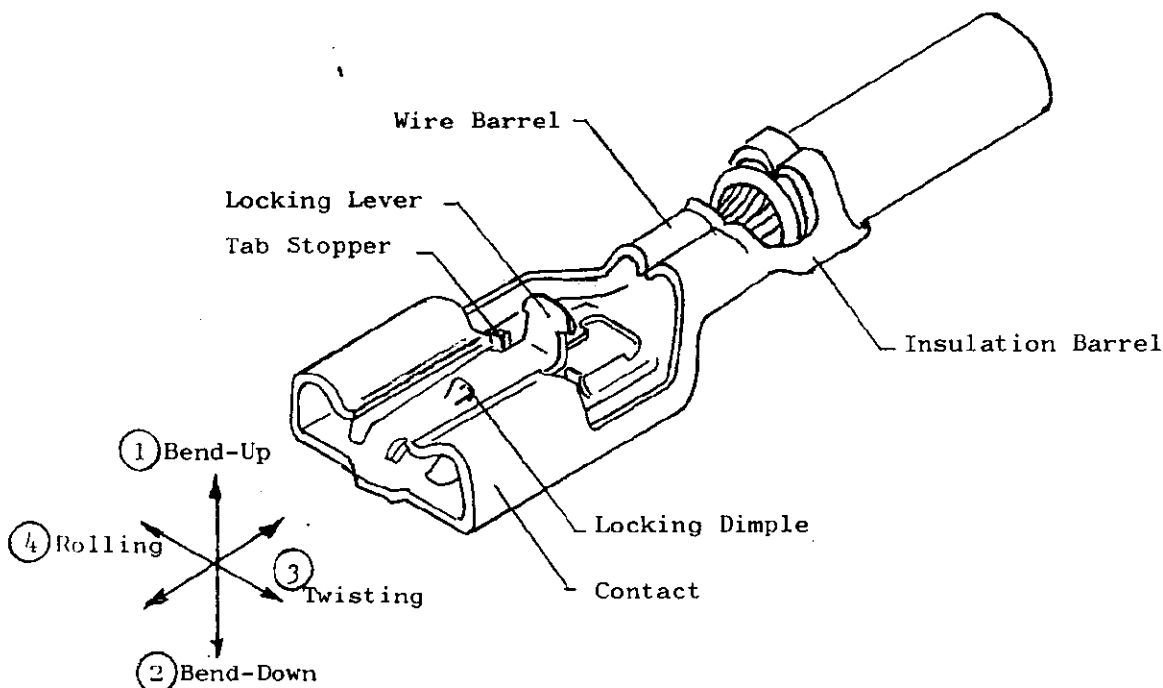
1. Scope:

This specification covers requirements for crimping of "312" Series, Positive Lock Receptacle Contacts.

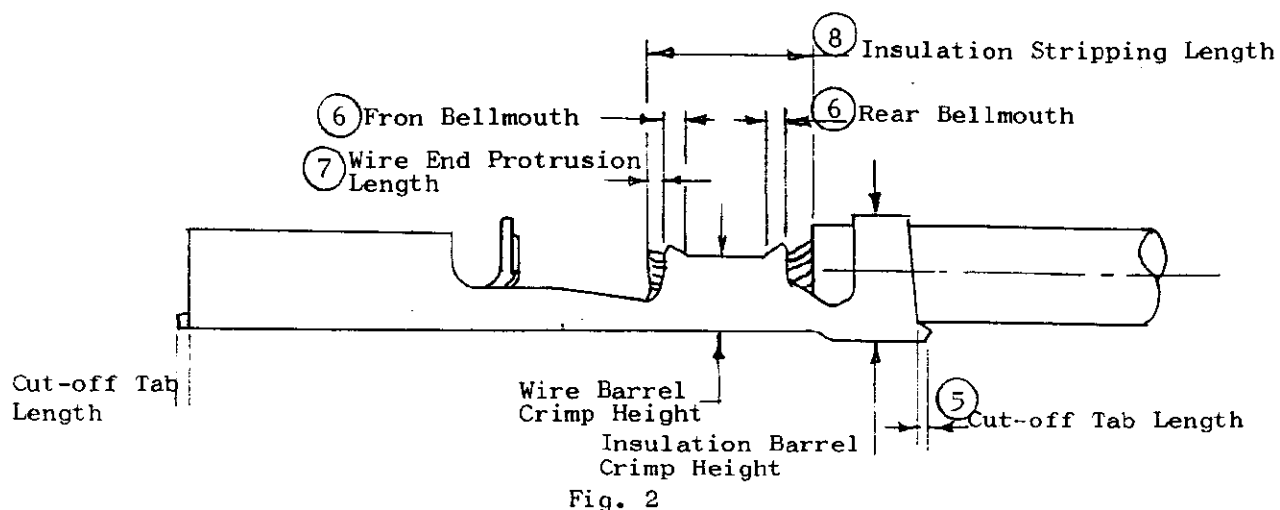
2. Applicable Part Numbers:

The products of the following part numbers shall be governed under this specification.

Contact No.	Contact Form	Tooling No.	Tooling Type
170381	Strip	722786	Miniapplicator
173603	"	755771	Miniapplicator



PRINT DIST					DR	5-23-80	AMP	AMP (Japan), Ltd. TOKYO, JAPAN	LOC	NO	114-5047	REV	A1
					CHK	5-23-80							
					APB	5-23-80							
A1	Revised RFA-1814												
A	Added 173603 RFA-806												
O	Released												
CTR	REVISION RECORD				DR	CHK	DATE						
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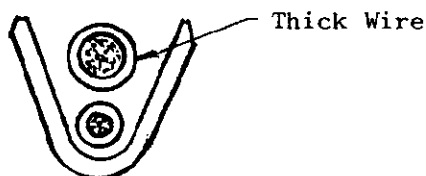


4. Crimp Requirements and Crimp Data:

4.1 Crimp Requirements:

Check Points		Requirements		Remarks
		170381	173603	
Allowable Limits of Deformation After Crimping		Bend-Up	3° max.	Fig. 1 (1)
		Bend-Down	5° max.	Fig. 1 (2)
		Twisting	5° max.	Fig. 1 (3)
		Rolling	5° max.	Fig. 1 (4)
Cut-off Tab Length		0.5 mm max.		Fig. 2 (5)
Bellmouth	Front	0.7 mm max.		Fig. 2 (6)
	Rear	0.2 - 0.7 mm		Fig. 2 (6)
Wire End Protrusion Length		1.0 mm max.		Fig. 2 (7)
Insulation Stripping Length		4.5 ⁺ 0.5mm	5.0-5.5mm	Fig. 2 (8)

Note: When to make a two-wire crimp in a same barrel, stack the wires as shown in Fig. 3.



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Table 2

When to make a two-wire crimp in a same barrel, place thin wire first and stack the other one upon it, as shown in Fig. 3.

5. Applicable Wire

Wire Size (mm ²)	Strand Composition Number of Strands of Dia. meter	Calculated Cross-Sectional Area (mm ²)	Insulation Diameter Nominal (mm)	Applicable Specification
0.5	7 / 0.32	0.56	2.2	JIS C 3406 Low Voltage Cables for Automobiles
0.85	11 / 0.32	0.88	2.4	
1.25	16 / 0.32	1.29	2.7	
2.0	26 / 0.32	2.09	3.1	

Table 3

Tooling Design Group
Design Engineer:

Approved by:

[Signature] 8/20/85

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