

114-5234

NUMBER:

Customer
ReleaseSECURITY
CLASSIFICATION:

Application Specification

114-5234

Socket Contact for $\phi 1$ mm Pin (SQUIB Connector)

1. Scope :

1.1 Contents

This specification covers the requirements for crimping Socket Contact for $\phi 1$ mm Pin.

2. Application Contacts :

Contact Features	Contact Part Nos.	Wire Sizes mm ² (AWG)	Remarks
Socket for $\phi 1$ mm Pin	353376	(AWG #22~#20) 0.3~0.5	

DR. 11. Dec. '96

T. Hayashi

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OF
5**AMP**AMP (Japan), Ltd.
Kawasaki, Japan

CHK. 11. Dec. '96

A. Nagamine

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APP. 11. Dec. '96

S. Isohata

NAME

Socket Contact for $\phi 1$ mm Pin
(SQUIB Connector)PRINT
DIST.

A	Revised FJ00-1282-97	TH	KJ	23/11/96
0	Release FJ00-5354-96	T.H	A.N	12.11.96
LTR	REVISION RECORD	DR	CHK	DATE

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3. Nomenclature and Crimping Features :

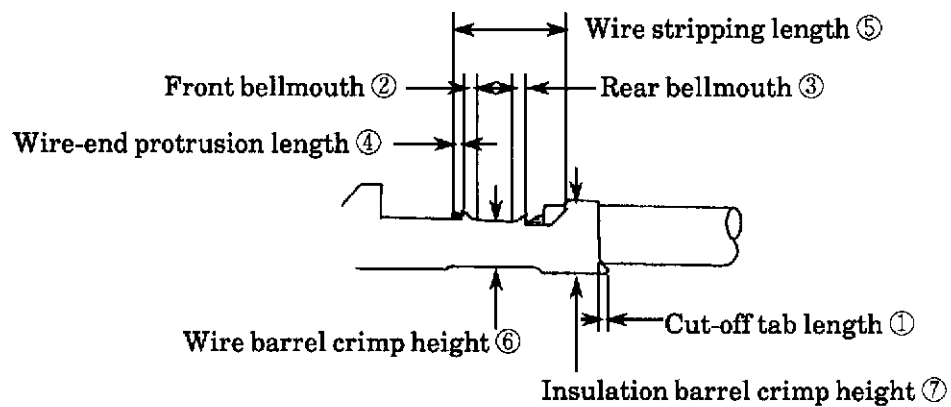
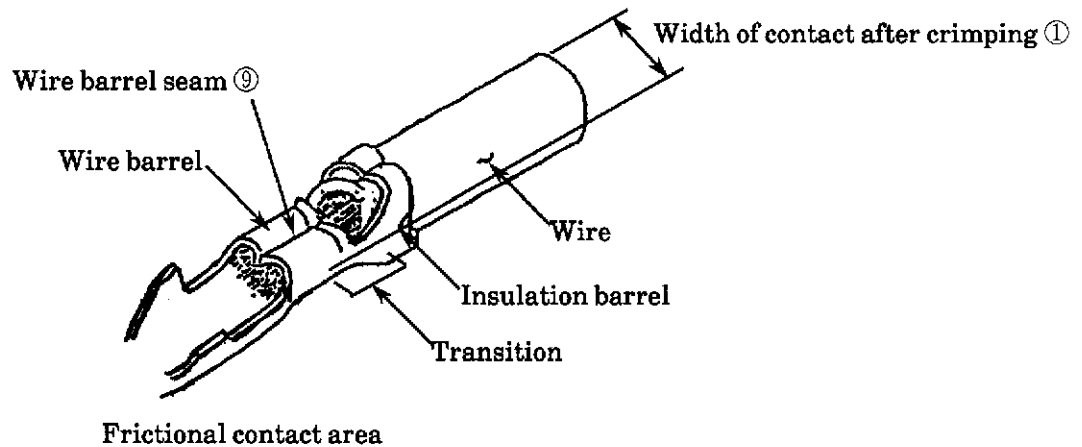


Fig. 1

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4. Crimping Conditions and Crimp Data :

4.1 Crimping Conditions :

No.	Checking Items		Requirements	Remarks
1	Allowable Deviation after Crimping	Bend-up	3 °C Max.	Fig. 2 ①
		Bend-down	3 °C Max.	Fig. 2 ②
		Twisting	3 °C Max.	Fig. 2 ③
		Rolling	10 °C Max.	Fig. 2 ④
2	Cut-off Tab Length		0.5 mm Max.	Fig. 1 ①
3	Bellmouth	Front	0.35 mm Max.	Fig. 1 ②
		Rear	0.6 mm Max.	Fig. 1 ③
4	Width of Bellmouth and Transition after Crimping		2.15 mm Max.	Fig. 1 ⑧
5	Wire-end Protrusion Length		Wire-end must protrude beyond the front edge of wire barrel, but shall not exceed 1 mm.	Fig. 1 ④
6	Insulation Stripping Length	One-wire Crimp	4~4.5 mm	Fig. 1 ⑤
7	Wire Barrel Seam		Seam of wire barrel must appear neat and closed without misgripped strands sticking out between the barrel.	Fig. 1 ⑨

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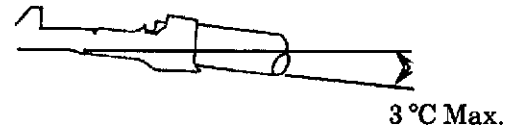
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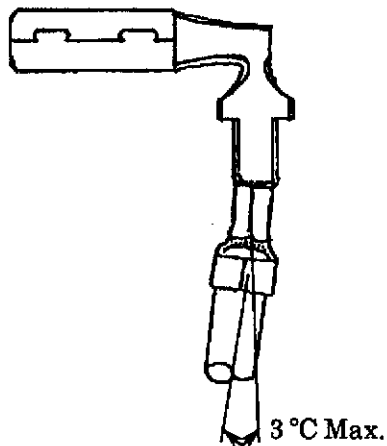
① Bend-up



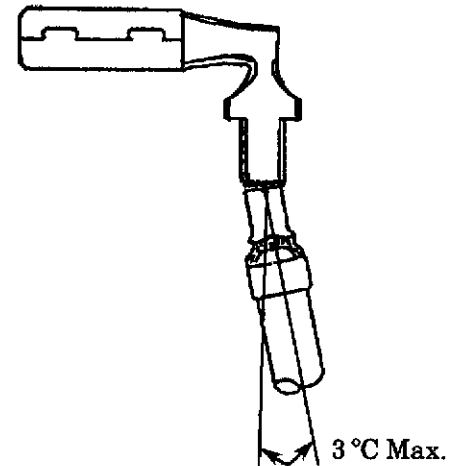
② Bend-down



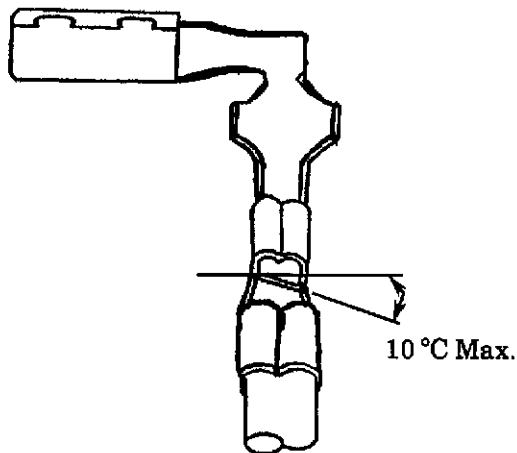
③ Twisting



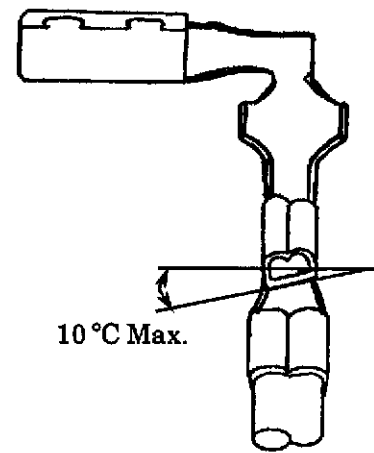
③ Twisting



④ Rolling



④ Rolling



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5. Crimp Data :

Application Crimp :

Contact Part No. (Strip Form)	Applicator Number	Wire Size mm ² (AWG)	Wire Barrel Crimp			Insulation Barrel Crimp			Crimp Tensile Strength (N) (Min.)
			Width (mm)	Crimp Height (mm)	Disc Letter	Width (mm)	Crimp Height (mm)	Disc Letter	
353376	409644-2	0.3 (#22)	1.78 "F"	0.94	C	1.78 "F"	2.29	3	59
		0.5 (#20)		1.03	B		2.37	3	88

Note : (1) Tolerance of wire barrel crimp height shall be within ± 0.05 mm.

(2) Tolerance of insulation barrel crimp height shall be within ± 0.1 mm.

(3) Crimp tensile strength includes the strength of insulation support.

(4) The width of wire barrel and insulation barrel are not the actual width but the width of wire and insulation crimper slot.

(5) See "6. Applicable Wires Data" about applicable wire.

(6) Control the width of wire and insulation barrel within 2mm after crimp.

6. Applicable Wires Data :

Nominal Size	Number of Strands / Diameter of Stand (mm)	Calculated Cross Section Area (mm ²)	Overall Outside Diameter AVSS/CAVS	
			Standard	Maximum
0.3	7/0.26	0.37	1.4	1.5
0.5	7/0.32	0.56	1.6	1.7

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