

Application Specification

114-5094

Crimping .040 Series Receptacle Contact

1. Scope:

This specification covers crimping requirements for .040 Series Receptacle Contact.

2. Applicable Contact:

Part No.: 173681 Receptacle Contact (Strip Form)  
 175062 " " (Loose Piece)

3. Nomenclature of Product:

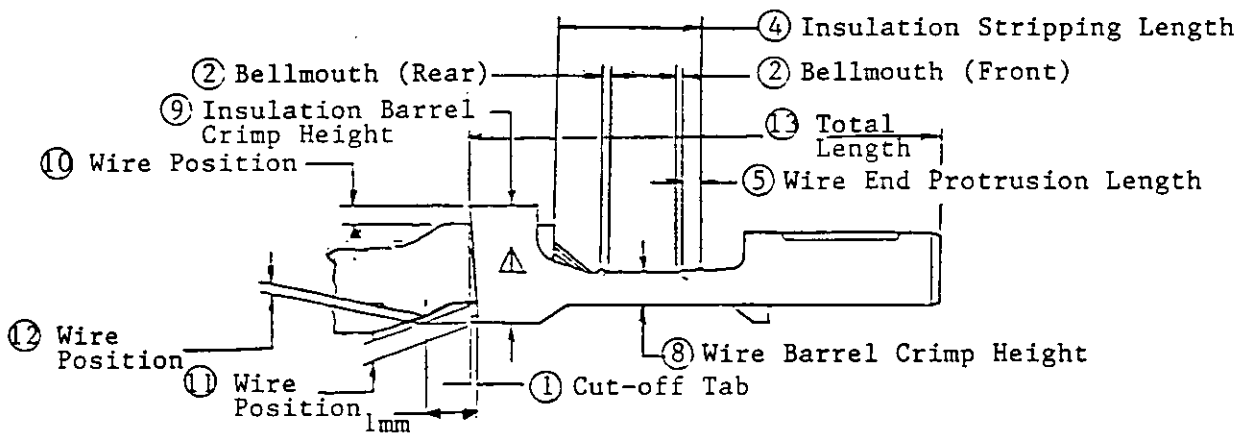
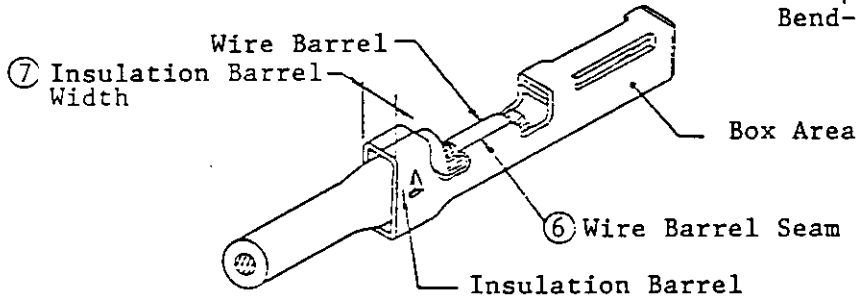
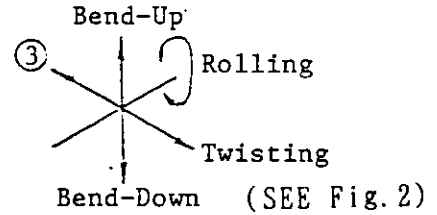


Fig.1

NUMBER 114-5094  
 Customer Release  
 AMP SECURITY CLASSIFICATION

				DR <i>J. Yamada</i> 26 FEB 88 R. Toyama 1 MAR 88 H. Iseki		AMP (Japan), Ltd. TOKYO, JAPAN	
B	Revised FJ00-0656-94	DA/KO	3/24/94	J	A	NO 114-5094	REV B
A	Revised RFA-1509	YK/Sm	2/9/90				
0	Released RFA-1257	DA/H	3/88				
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4. Crimping Requirements:

No.	Item	Crimping Requirements	Remarks
1	Cut-off Tab	0.25 mm max.	Fig.1 ①
2	Bellmouth	Front	0 ~ 0.4 mm
		Rear	0.15 ~ 0.65 mm
3	Allowable Limit of Deformation	Bending	Within +2° & -4°
		Twisting	Within 3°*
		Rolling	Within 5°
4	Wire Insulation Stripping Length (Ref.)	4 ~ 4.5 mm	" ④
5	Wire End Protrusion Length	0 ~ 1.5 mm	" ⑤
6	Wire Barrel Seam	Core wire shall not be seen.	" ⑥
7	Insulation Barrel Width (after crimping)	2.05 mm max.	" ⑦
8	Wire Position	Upper Side	0.35 mm min.
		Lower " (1)	0.35 mm min.
		Lower " (2)	0 min.
9	Total Length of Contact (including cutting tab)	14.95 mm max.	" ⑬

\* Wire barrel shall not come out from box area.

5. Crimp Data:

5.1 Applicator Crimp:


Contact Part No. (Strip Form)	Wire Size (Nominal)	Applicator Part No.	Wire Barrel Crimp			Insulation Barrel Crimp			Crimp Tensile Strength (kg)
			Width (mm)	Height +0.05 (mm) (Fig.1 ⑧)	Disk	Width (mm)	Height (mm) (Fig.1 ⑨)	Disk (Ref.)	
173681-1 -2	0.3	755830-1 -2	1.57 "F"	0.92	B	1.78	3.7±0.1	4	6 min.
	0.5			1.02	A			5	9 min.

Note: Crimp tensile strength includes the strength of insulation support.

5.2 Hand Tool Crimp:

Contact Part No. (Loose Piece)	Wire Size (mm <sup>2</sup> )	Hand Tool Part No.	Wire Barrel Crimp			Insulation Barrel Crimp		Crimp Tensile Strength (kg)
			Width (mm)	Height (mm) Fig. 1 ⑧	Crimp Sym-bols	Width (mm)	Height (mm) Fig. 1 ⑨	
175062-1 -2	0.3	911738-1	1.57 "F"	0.74-0.90	B	1.78	3.7 ±0.1	6.0 min.
	0.5			0.90-1.07	A			9.0 min.

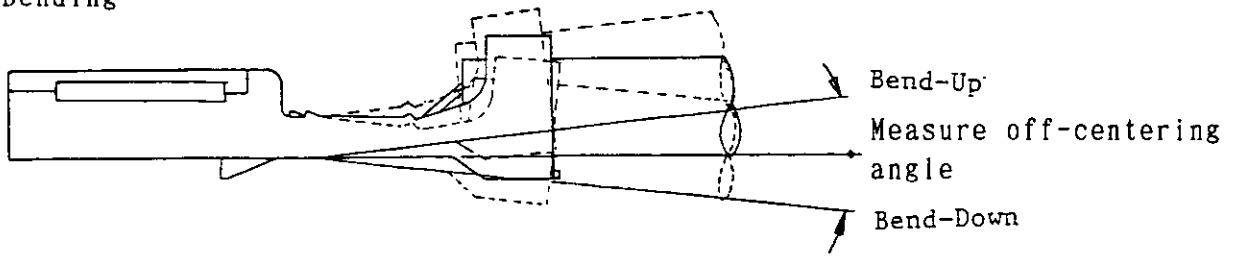
Note: Crimp tensile strength includes the strength of insulation support.

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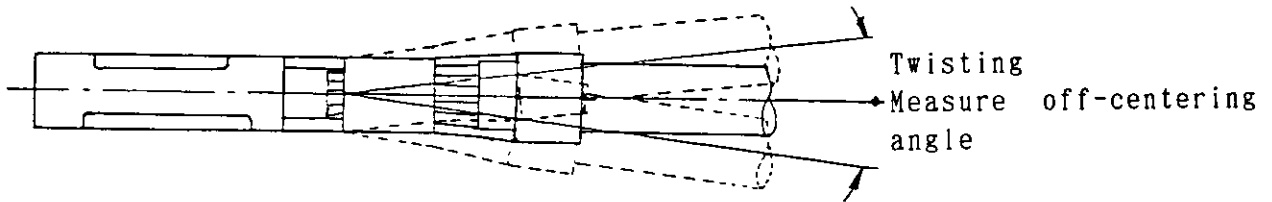
6. Applicable Wire:

Nominal	No. of Conductors / Diameter of a Conductor (mm)	Calculated Cross-sectional Area (mm <sup>2</sup> )	Finished Overall Diameter (mm)	Symbol of Wire (Ref.)	Wire Specification
0.3	7/0.26	0.37	1.8	AVS	(Low voltage wire and cable for automobile)
0.5	7/0.32	0.56	2.0	AVS	

Bending



Twisting



Rolling

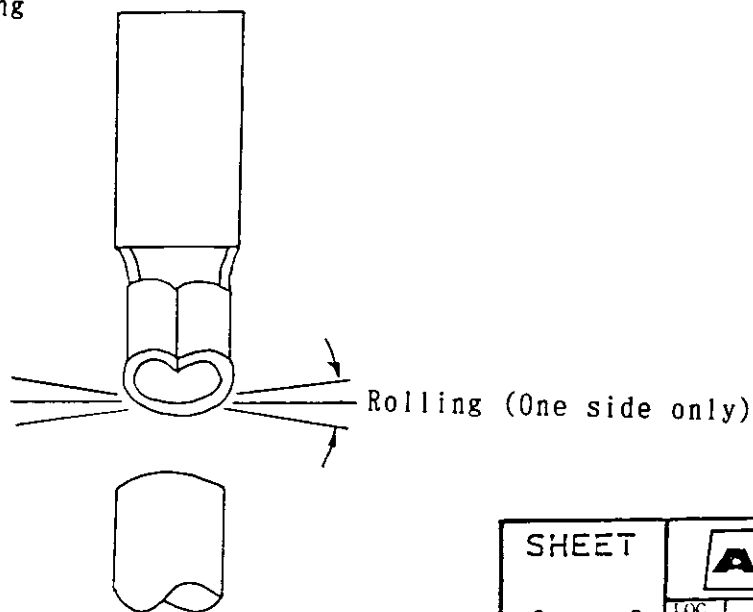


Fig. 2 Deformed Contact

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