

1. SCOPE

This specification covers general requirements for crimping JUNIOR POWER TIMER receptacle contacts manufactured by AMP de France. These requirements must be maintained to have satisfying performance product.

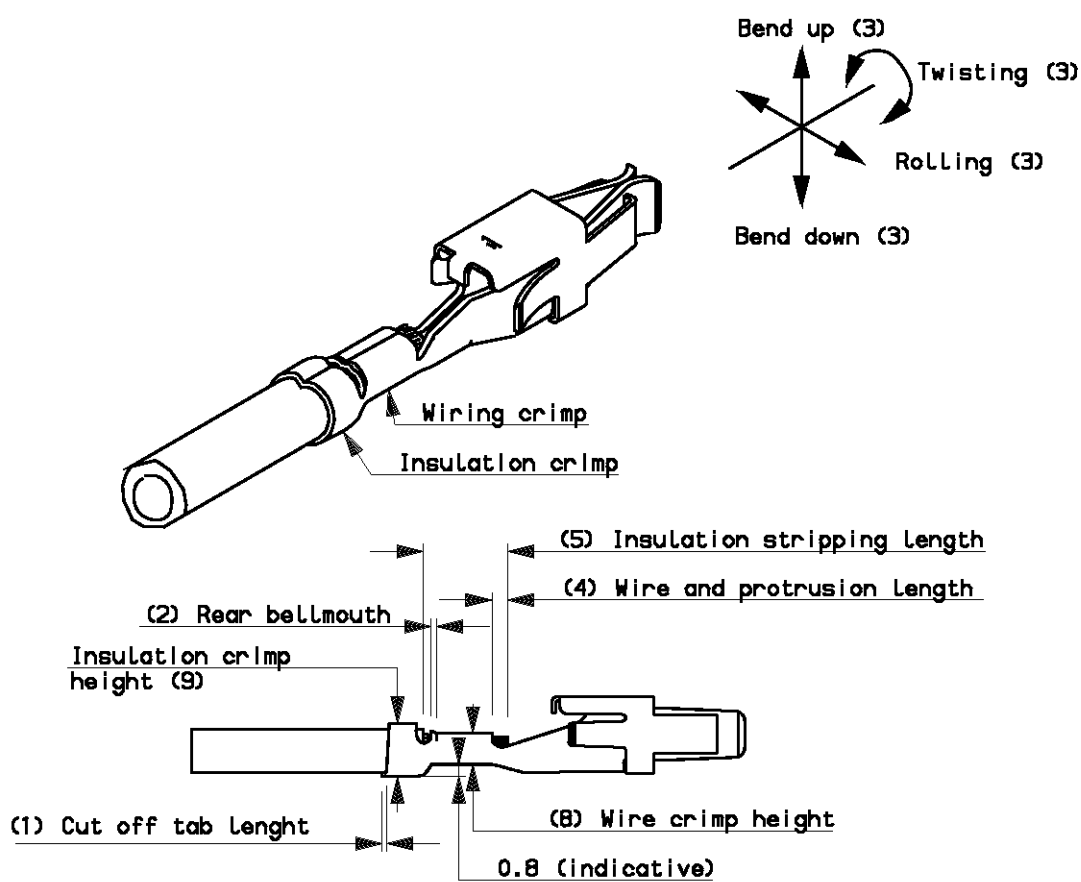


Figure 1

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Date : Juin 1991

Approved by : J. -J. REVIL

Date : 01 Avril 1998

2. CRIMPING REQUIREMENTS ON APPLICATOR

| | Chek items | | Specified requirements | See figure n° |
|---|---------------------------------|-----------|-----------------------------|---------------|
| A | Cut off tab | | 0,5 mm max | (1) |
| B | Rear bellmouth | | Must be visually identified | (2) |
| C | Alowed deviation after crimping | Bend-up | 7° max | (3) |
| | | Bend down | 6° maxi | |
| | | Rolling | 5° maxi | |
| | | Twisting | 10° maxi | |
| D | Wire end protrusion length | | 0,8 ± 0,4 mm | (4) |
| E | Insulation stripping | | 5 ± 0,5 | (5) |

3. CRIMPING VALUES

| Contact p/n Strip form | Wire size (mm ²) | Wire crimp | | Disc code | Insulation crimp | | Crimping tensile strength (daN) |
|---------------------------|---------------------------------|------------------|-------------------------|-----------|------------------|-----------------------|---------------------------------|
| | | anvil width (mm) | height mm (± ±0.05) (8) | | anvil width (mm) | heigth mm (± 0.1) (9) | |
| 144432-1 | 0.35 + 1 | 2.79 | 1.57 | C | 3.84 | 3.24 | 15 |
| | 0.35 + 1.4 | | 1.69 | C | | 3.24 | 20 |
| | 0.35 + 2 | | 1.86 | B | | 3.65 | 20 |
| | 0.6 + 0.6 | | 1.52 | D | | 2.85 | 15 |
| | 0.75+0.75 | | 1.63 | C | | 3.24 | 20 |
| | 0.6 + 1 | | 1.64 | C | | 3.24 | 20 |
| | 0.6 + 1.4 | | 1.76 | B | | 3.65 | 20 |
| | 0.6 + 2* | | 1.94 | B | | 3.65 | 20 |
| | 1 | | 1.46 | D | | 2.85 | 15 |
| | 1 + 1 | | 1.76 | B | | 3.65 | 20 |
| | 1 + 1.4* | | 1.88 | B | | 3.65 | 20 |
| | 1.4 | | 1.58 | C | | 3.24 | 20 |
| | 1.4 + 1.4* | | 2.00 | A | | 3.90 | 20 |
| | 1.5 | | 1.61 | C | | 3.03 | 20 |
| | 2.0 | | 1.76 | B | | 3.65 | 20 |
| | 2.5 | | 1.90 | A | | 3.78 | 20 |
| 3.0 | 2.05 | A | 3.90 | 25 | | | |

(*) Not used (blocking up).