

FASTON* Connector, .187" & .197" sr.s Receptacle Contact & L.I.F. Receptacle Contact.

1. SCOPE

This specification covers the requirements for application of FASTON* Connectors, .187" & .197" sr.s receptacle contacts & L.I.F. receptacle contact. These requirements are applicable to automatic machine crimping tools. For specific wire and insulation ranges relative to the products covered in this specification see figure 6.

1.1 REFERENCE SPECIFICATION.

For applicable performance requirements, see AMP Product specification listed in Figure 6.

2. PRODUCT FEATURES.

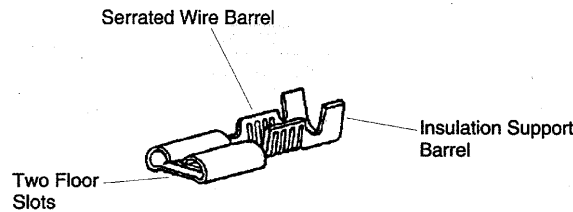


Figure 1

3. NOMENCLATURE

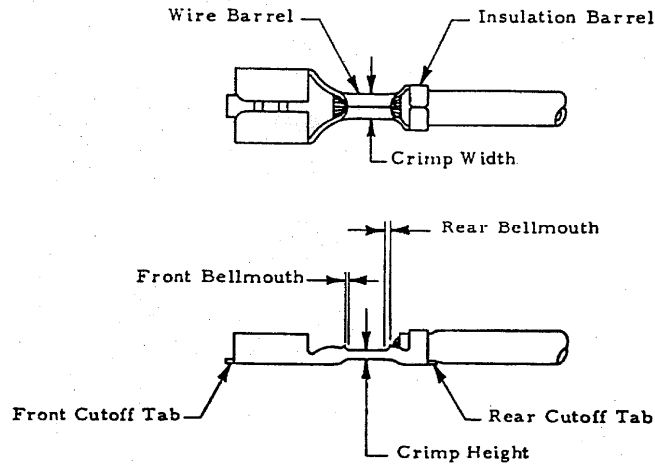


Figure 2

D5	UPDATED	H.Y.	13 JUN 2008	G.T.	13 JUN 2008
D4	UPDATED	H.Y.	11 DEC 2006	G.T.	11 DEC 2006
D3	ADED ALTERNATIVE LOG	H.Y.	13 OCT 2006	G.T.	13 OCT 2006
D2	ADED ALTERNATIVE LOG FOR ET00-0050-03	H.Y.	24 APR 2003	C.T.	24 APR 2003
D1	ADED ALTERNATIVE LOG FOR ET00-0226-02	H.Y.	12 NOV 2002	C.T.	12 NOV 2002
D	ADED PARTS FOR ET00-0127-01	H.Y.	15 MAY 2001	C.T.	15 MAY 2001
C	REVISED AND RETYPED FOR ET00-0059-01	H.Y.	20 FEB 2001	C.T.	20 FEB 2001
rev letter	rev. record	DR	Date	CHK	Date
DR. H. YAALI	DATE 03 APR 2001	APVD C. TARTARI	DATE 03 APR 2001		

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4. CRIMP AND DIMENSIONAL REQUIREMENTS.

4.1 Wire preparation

- A. **Strip length:** Insulation shall be stripped as indicated in Figure 6.
- B. **Workmanship:** Reasonable care shall be taken not to nick, scrape or cut any strands during the stripping operation.

4.2 Carrier Cutoff Tab and Burr

- A. **Cutoff Tab:** shall not exceed .012 [0.31 mm. max.].
- B. **Burr on cutoff:** shall not exceed .006 [0.15 mm. max.].

4.3 Wire Barrel Crimp.

- A. **Crimp Dimensions and Type:** Crimp height, width and type shall be as shown in Figure 6.
- B. **Wire barrel flash:** Shall not exceed .006 [0.15 mm. max.].
- C. **Wire barrel seam:** shall not be completely closed and there shall be no evidence of loose wire strands or wire strands visible in the seam.
- D. **Bellmouth:**
 - (1) Rear bellmouth length shall be .015x60° max. [0.38x60° max.]
 - (2) Front bellmouth length shall be .015x60° max. [0.38x60° max.]
- E. **Conductor location:**
 - (3) End of the wire shall be flush with the front end of the wire barrel or extend .0015 [0.4mm] maximum after crimping.
 - (4) 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.

4.4 Insulation Barrel Crimp.

- A. **Crimp Dimensions and Type:** Crimp width and type shall be as shown in Figure 6.
- B. **Workmanship:** Reasonable care shall be taken not to cut or break the insulation during the crimping operation.

4.5 Alignment.

A. Straightness.

- (1) The contact, including the cutoff tab and burr shall not be bent above or below the datum line more than the amount shown in Figure 3.

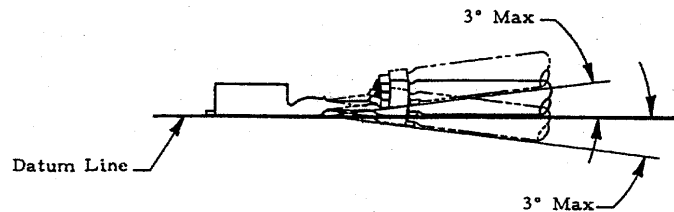


Figure 3

- (2) The side to side bending of the contact shall not exceed the limits specified in Figure 4.

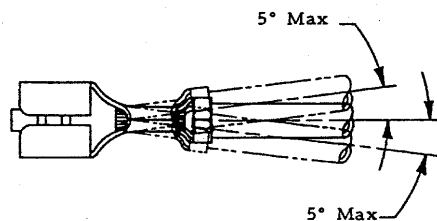


Figure 4

- B. **Twist or Roll:** Twist or Roll of the crimped contact shall not exceed the limits specified in Figure 5.

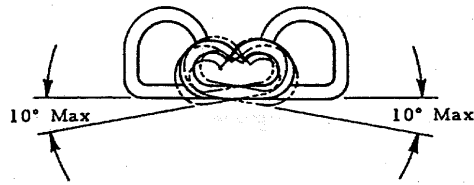


Figure 5

AUTOMATIC MACHINE WIRE CRIMP DIMENSIONS

AMP P/N	LOG	AMP PRODUCT SPEC.	WIRE SIZE mm ²	INSULATION DIA. mm	STRIP LENGTH APPROX. mm	WIRE BARREL CRIMP			INSUL. BARREL CRIMP		
						WIDTH REF. mm	HEIGHT +/-0.05 mm	T Y P E	WIDTH REF. mm	HEIGHT REF. mm	T Y P E
281369 160433 160430 160713 100651 100494	782447 677520 1339541 1529021	108-20019	1.50 1.00 0.75 0.50	2.3-3.3	4.5	2.29	1.50 1.45 1.40 1.35	F	3.30		F
100494	1529021	108-20019	1.50 1.40 1.00 0.75 0.50	2.3-3.3	4.5	2.29	1.50 1.47 1.45 1.40 1.35	F	3.30		F
160433 160430 160713 100651 100494 281369 160726 160782	878010(*) 541520(*) 1529044(*) 1339813(*)	108-20019	1.50 1.00 0.75 0.50	2.3-3.3	4.5	2.29	1.56 (*) 1.39 (*) 1.31 (*) 1.22 (*)	F	3.30		F
282332 282183	785133	108-20019	1.50 1.00 0.75 0.50	1.5-2.4	4.5	2.29	1.49 1.45 1.40 1.35	F	3.05		F
160429 160431	677738	108-20019	2.50 2.00 1.50 1.00	3.0-4.3	4.5	3.05	1.58 1.47 1.37 1.27	F	3.94		F

(*) Alternative values

Figure 6