

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.

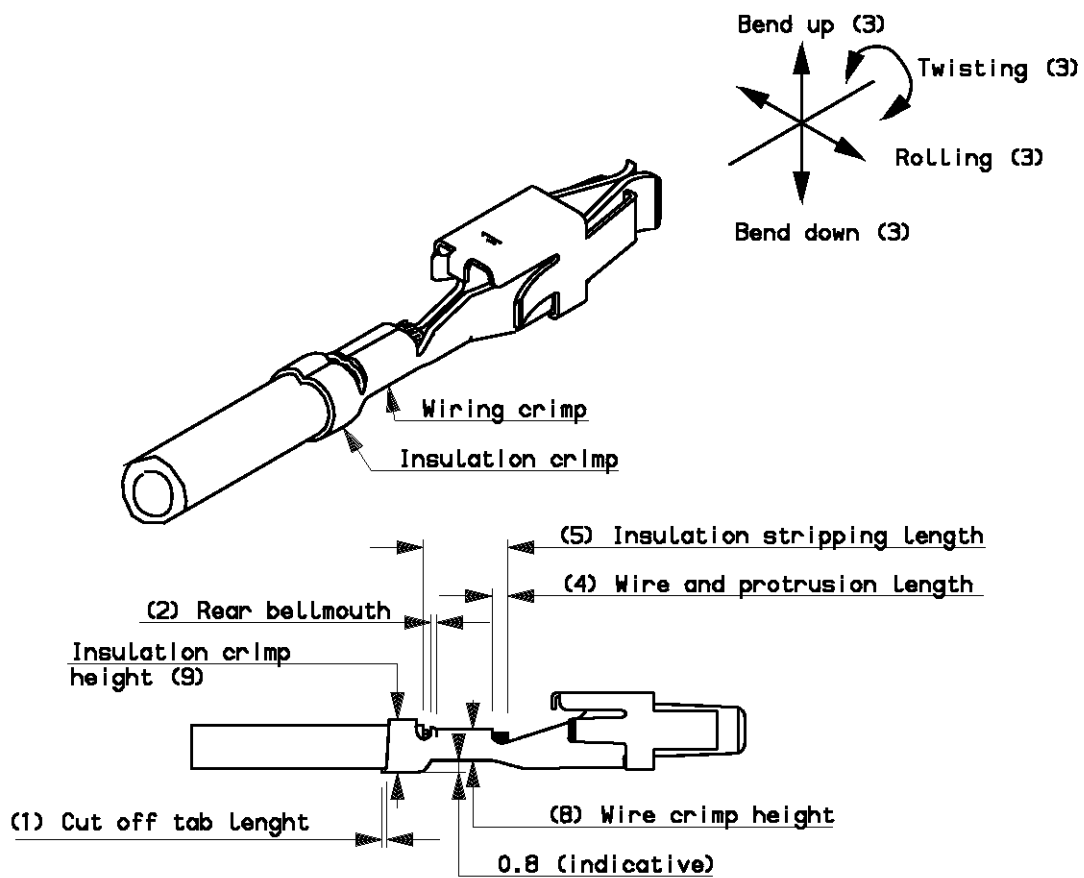


Figure 1

Drawing by : J.-C. JOLY

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)	height 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).