

APPLICATION SPECIFICATION

1. SCOPE

This specification covers the requirements for application of DUO-TYNE* flag contacts. These requirements are applicable to hand or automatic machine crimping tools. For specific wire and insulation ranges relative to the products covered in this specification see Figure 4 & 5.

2. NOMENCLATURE

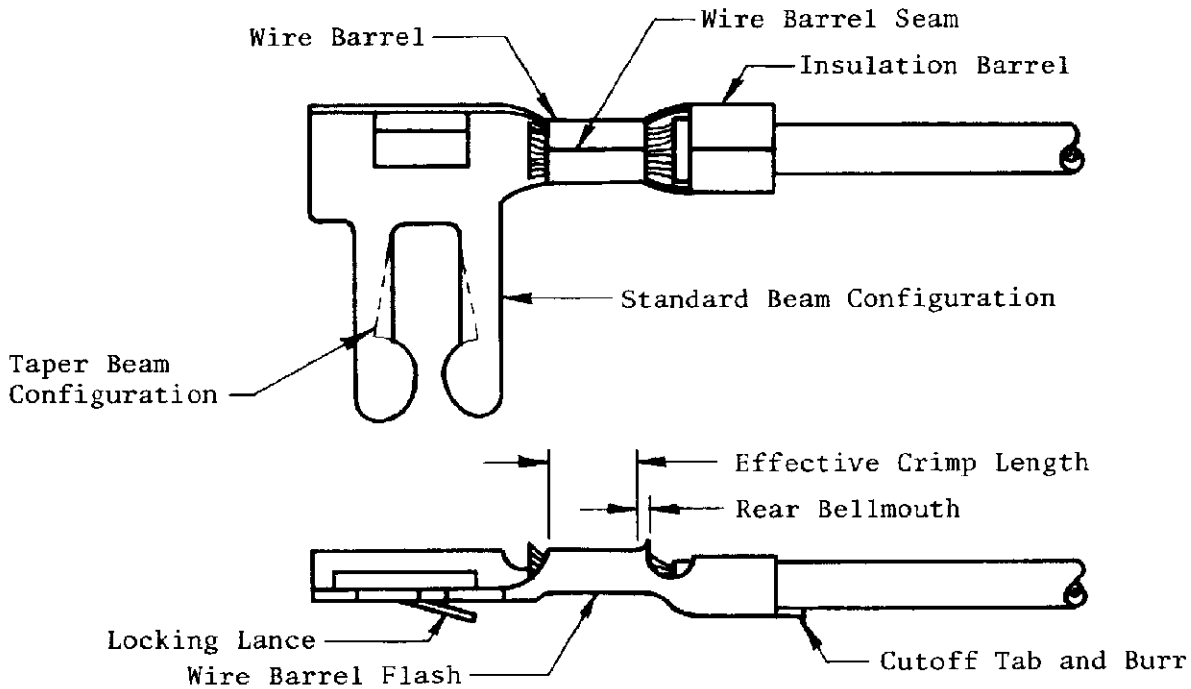


Figure 1

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1. Wire Preparation

A. Strip Length

Insulation shall be stripped as indicated in Figure 4 and 5.


B. Workmanship

Reasonable care shall be taken not to nick, scrape or cut any strands or the solid wire during the stripping operation.

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NO 114-9002

				DR <i>C.E. Fitz</i> 9-4-75	 AMP INCORPORATED Harrisburg, Pa.				REV
				CHK <i>W. Buckley</i> 9-4-75			LOC	NO	A
				APP <i>R. Shawman</i> 9-4-75	B	A	114-9002		
				NAME					
A Rev per ECN 4775				SHEET		CONTACT, DUO-TYNE FLAG, APPLICATION OF			
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3.2. Carrier Cutoff Tab and Burr

A. Cutoff Tab

Cutoff tab length shall be .005 - .015.

B. Burr

Burr on cutoff shall not exceed .003.

3.3. Wire Barrel Crimp

A. Crimp Dimensions and Type

Crimp height, width and type shall be as shown in Figure 4 and 5.

B. Effective Crimp Length

Effective crimp length shall be .085 min, and is defined as that portion of the barrel, excluding bellmouth, fully formed by the crimping tool.

C. Wire Barrel Flash

Wire barrel flash shall not exceed .005.

D. Wire Barrel Seam


Wire barrel seam shall be completely closed and there shall be no evidence of loose wire strands or wire strands visible in the seam.

E. Bellmouth

Rear bellmouth length shall be .005 min.

F. Conductor Location

- (1) End of the wire shall be flush with the front end of the wire barrel or extend .030 max after crimping.
- (2) 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.

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3.4. Insulation Barrel Crimp

A. Crimp Type

Crimp type shall be as shown in Figure 4 and 5.

B. Workmanship

Reasonable care shall be taken not to cut or break the insulation during the crimping operation.

3.5. Locking Lance

Locking lance shall not be deformed.

3.6. 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 2.

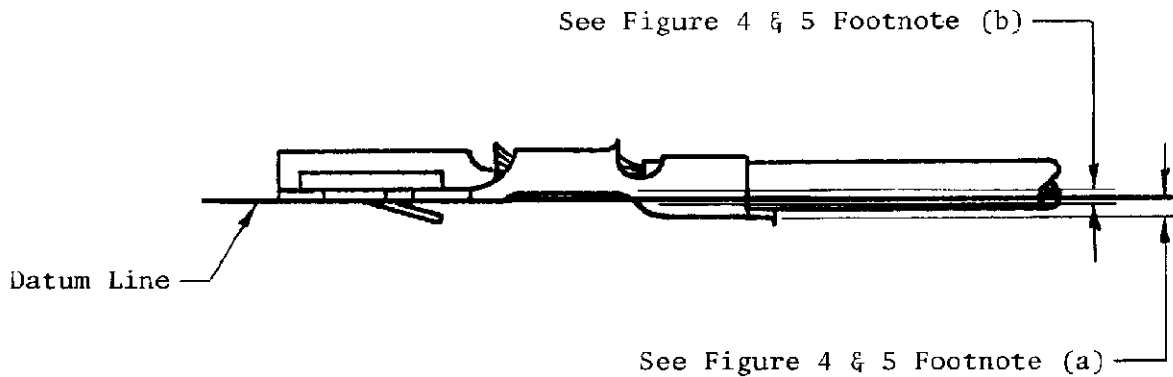



Figure 2

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(2) The side to side bending of the contact shall not exceed the limits specified in Figure 3.

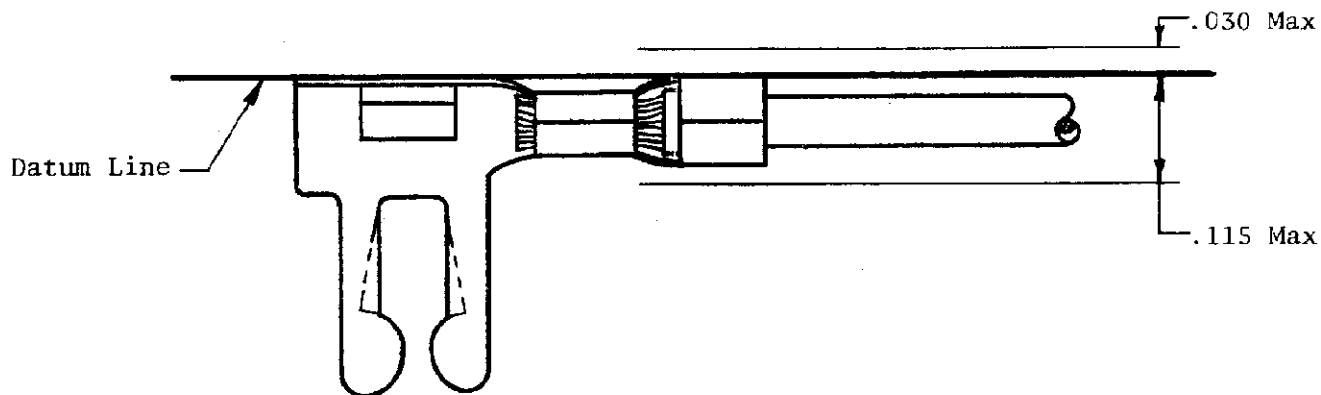


Figure 3

B. Twist or Roll

There shall be no twist or roll in crimped portion that will impair usage of the contact.

Part No	Wires		Insulation Diameter	Strip Length	Wire Barrel Crimp			Insulation Barrel Crimp
	No	Size			Width	Height ±.002	Type Crimper	Type Crimper
530501 (a) 530503 (a) 530505 (a) 530507 (a)	1	16-18	$\frac{.130}{.090}$	$\frac{.170}{.140}$.090	.062	F	O
60215 (a) 66335 (a) 530002 (a) 530006 (a) 583284 (a)	1	18 20 22	$\frac{.090}{.060}$	$\frac{.170}{.140}$.080 .080 .080	.056 .052 .048	F F F	F or O F or O F or O
66149 (b) 66362 (b) 530000 (b) 530004 (b) 583379 (b)	1	22 24 26	$\frac{.055}{.035}$	$\frac{.170}{.140}$.062 .062 .062	.039 .039 .039	F F F	F or O F or O F or O

(a) The lowest point of the insulation barrel, less cutoff tab and burr, shall be .015 - .042 in below the datum line shown in Figure 2.

(b) The lowest point of the insulation barrel, less cutoff tab and burr, shall be .012 max above and .015 below the datum line shown in Figure 2.



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Figure 4

Automatic Machine Wire Crimp Dimensions

Part No	Wires		Insulation Diameter	Strip Length	Wire Barrel Crimp		Insulation Barrel Crimp		Hand Tool Part No
	No	Size			Width	Height ±.002	Type	Type	
530502 (a)	1	16-18	.130 .090	.170 .140	.090	.062	F	O	90335-1
60215 (a)	1	18	.090 .060	.170 .140	.080	.057	F	F or O	900027
66088 (a)									
530003 (a)	1	20-22	.090 .060	.170 .140	.080	.053	F	F or O	
530007 (a)									90094
583285 (a)									
66149 (b)	1	22-26	.055 .035	.170 .140	.062	.039	F	F or O	

- (a) The lowest point of the insulation barrel, less cutoff tab and burr, shall be .015 - .042 in below the datum line shown in Figure 2.
- (b) The lowest point of the insulation barrel, less cutoff tab and burr, shall be .012 max above and .015 below the datum line shown in Figure 2.

Figure 5
Hand Tool Wire Crimp Dimensions

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