

FASTIN-FASTON* Connector, .187" Receptacle Contact.

1. SCOPE

1.1 Content

This specification covers the requirements for application of .187" series FASTIN-FASTON* Receptacle Contacts. 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 4.

1.2 Reference specification

For applicable performance requirements, see AMP Specification 108-20020.

2. NOMENCLATURE

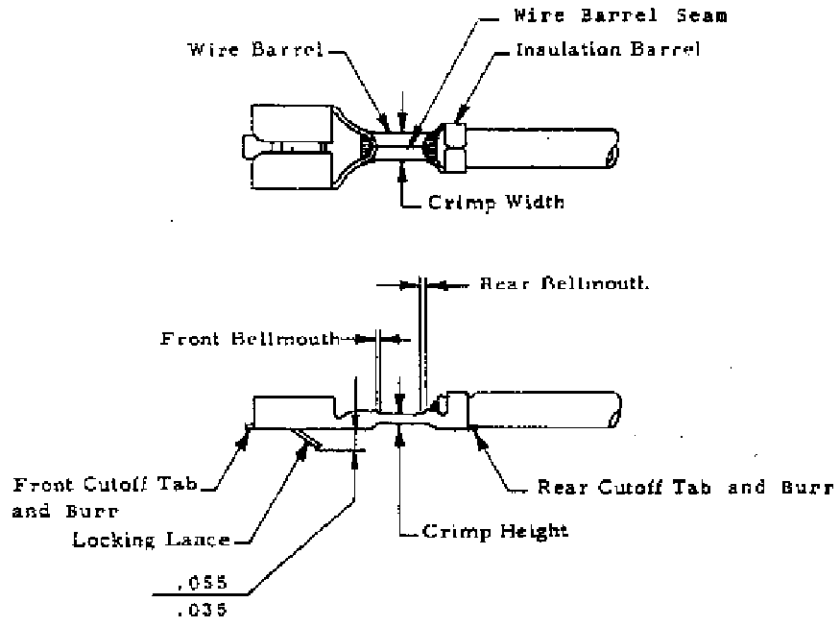


Figure 1

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1 Wire Preparation

- A. Strip Length: Insulation shall be stripped as indicated in Figure 4.
- B. Workmanship: Reasonable care shall be taken not to nick, scrape or cut any strands during the stripping operation.

C2	UPDATED LOG TABLE	H.Y.	31 MAR 2005	G.T.	31 MAR 2005
C1	REVISED FOR ET00-0206-01	H.Y.	07 SEP. 2001	C.T.	07 SEP. 2001
C	REVISED & RETYPED FOR ET00-0194-01	H.Y.	19 JULY 2001	C.T.	19 JULY 2001
rev letter	rev. record	DR	Date	CHK	Date
DR. H. YAALI		DATE 18 JULY 2001	APVD C. TARTARI		DATE 18 JULY 2001

This specification is a controlled document.

This information is confidential and is disclosed to you on condition that no further disclosure is made by you to other than AMP personnel without written authorization from AMP Italia.

3.2 Carrier Cutoff Tab and Burr

- A. Cutoff Tab: Cutoff tab shall not exceed 0.38 mm.
- B. Burr: Burr on cutoff shall not exceed 0.127 mm.

3.3 Wire Barrel Crimp

- A. Crimp dimensions and Type: Crimp height, width and type shall be as shown in Figure 4.
- B. 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.
- C. Bellmouth
 - (1) Rear bellmouth length shall be 0.38 mm – 0.63 mm.
 - (2) Front bellmouth length shall be 0.127 mm – 0.38 mm.
- D. Conductor Location
 - (1) End of the wire shall be flush with the front end of the wire barrel or extend 0.76 mm maximum 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.

3.4 Insulation barrel crimp

- A. Crimp dimensions and Type: Crimp width and type shall be as shown in Figure 4.
- 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 and shall meet requirements of Figure 1 after crimping.

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 in Figure 2.

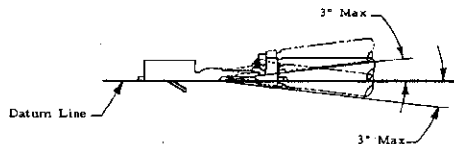


Figure 2

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

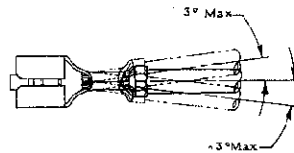


Figure 2

- B. Assembly

The following list of Do's and Don'ts are to be followed when assembling contacts into housing cavities.

- (1) Do's
 - a) Do insert contacts fully.
 - b) Do check for proper insertion by pulling back lightly.
 - c) Do ensure proper handling of contacts to eliminate lance deformation.

- (2) Don'ts
 - a) Don't insert contact into housing at an angle.
 - b) Don't rock connectors while mating.
 - c) Don't tie harness closer than 38.1 mm to back of housing.
 - d) Don't dress wires sharply to one side of housing.

C. Twist or Roll

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

AUTOMATIC MACHINE WIRE CRIMP DIMENSIONS

AMP P/N	LOG	AMP PRODUCT SPEC.	WIRE SIZE (mm ²)	INSULATION DIA. mm	STRIP LENGHT APPROX. mm	WIRE BARREL CRIMP			INSUL. BARREL CRIMP		
						WIDTH REF. mm	HEIGHT +/-0.03 mm	T Y P E	WIDTH REF. mm	HEIGHT REF. mm	T Y P E
280313 280919	780955	108-20020	0.50 0.75 1.00 1.50	2.30-3.30	4.3	2.3	1.34 1.39 1.44 1.49	F	3.3	-	F
282331 282180	680207 1239056	108-20020	0.50 0.75 1.00 1.50	1.50-2.40	4.3	2.3	1.34 1.39 1.44 1.49	F	3.0	-	F
281197	782653	108-20020	1.00 1.50 2.50	3.00-4.30	4.3	3.0	1.27 1.37 1.57	F	3.9	-	F