

114 - 5088

Application Specification

Crimping 250 Series, M Type Tab and Receptacle Contact

1. Scope:

This specification covers the requirements for 250 Series, M Type Tab and Receptacle Contact with the use of applicator on AMP-O-LECTRIC Auto-machine.

2. Applicable Contact:

Receptacle Part No.	Tab Part No.	Applicable (AWG)	Wire Size (mm <sup>2</sup> )	Applicable Insulation Range
171655	171658	(#22-#20)	0.3 - 0.56	1.5 dia.-2.4 dia
171656	171659	(#18-#14)	0.75- 2.27	2.4 dia.-3.4 dia.
171657	171660	( # 12 )	3.08	3.8 dia.

3. Crimping Requirements and Crimp Data:

3.1 Ceimping Requirements:

Check	Items	Crimping Requirements	Remarks
1	Bend-Up	5° max.	Fig. 1 (1)
	Bend-Down	3° max.	Fig. 1 (1)
	Twisting	5° max.	Fig. 1 (1)
	Rolling	5° max.	Fig. 1 (1)
2	Cut-Off Tab Length	0.5mm max.	Fig. 1 (2)
3	Front Bellmouth Length	0.2mm - 0.7mm	Fig. 1 (3)
4	Rear Bellmouth Length	0.2mm - 0.7mm	Fig. 1 (4)
5	Wire End Protrusion Length	0.5mm - 1.0mm	Fig. 1 (5)
6	Wire Insulation Stripping Length	5.0mm - 5.5mm	N / A
7	Wire Barrel Seam Closure	Wire barrel seam must be neatly closed.	Fig. 1 (6)

DR.

CHK.

APP.

SHEET  
1  
OF  
3

**AMP**

AMP (Japan), Ltd.  
Kawasaki, Japan

LOC  
J

A

NO. 114 - 5088

REV.  
0

NAME  
Crimping 250 Series, M Type Tab  
Tab and Receptacle Contact

NUMBER:  
114 - 5088

Customer Release

SECURITY CLASSIFICATION:

Customer Release

PRINT  
DIST.

0 Rel.

REVISION RECORD

DR

CHK

DATE

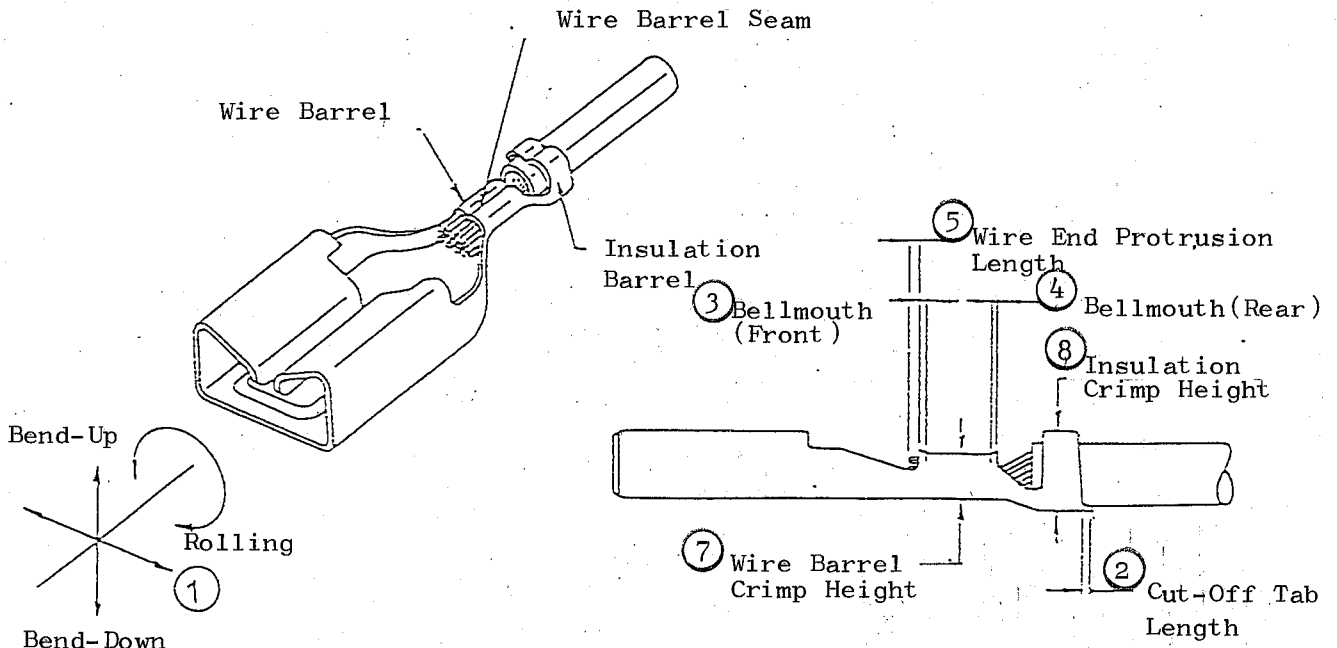
2/58

44

*[Signature]*

NUMBER: 114 - 5088  
 Customer Release  
 SECURITY CLASSIFICATION:

3.2 Nomenclature:



3.3 Crimp Data:

Contact Type	Contact Part Number	Applicator Number	Wire Size Nominal mm <sup>2</sup>	Wire Barrel Crimp			Insulation Barrel Crimp			Crimp Tensile Strength (kg)(min.)
				Width (mm)	Crimp Height (mm) <sup>7</sup>	Disc Ltr.	Width (mm)	Crimp Height (mm) <sup>8</sup>	Disc Ltr.	
Receptacle	171655	755756-2	0.3	1.78	1.02	5.59	2.5	6.0		
			0.5	"F"	1.14	Fig. 2	2.6	9.0		
	171656	755774-2	0.85	2.79	1.24	5.59	3.0	13.0		
			1.25		1.35		3.1	17.0		
			2.0	"F"	1.45	Fig. 2	3.2	25.0		
171657	755775-2	3.0	3.3 "F"	1.8	6.35 Fig. 2	3.8	35.0			
Tab	171658	755757-2	0.3	2.03	1.24	5.59	2.7	6.0		
			0.5	"F"	1.35		Fig. 2	2.8	9.0	
	171659	755781-2	0.85	3.05	1.45	5.59	2.8	13.0		
			1.25		"F"		1.55	Fig. 2	3.0	17.0
			2.0	1.6	3.3	25.0				
			171660	755782-2	3.0	3.3 "F"	2.1	6.35 Fig. 2	3.5	35.0

Note: Wire Barrel general tolerance to be plus-minus 0.05mm

\* Asterisk marked values are for reference only.

Table 3

SHEET	<b>AMP</b>			AMP (Japan), Ltd.	
				Kawasaki, Japan	
2 OF 3	LOC	LOC	NO.	114 - 5088	REV. 0
NAME					
Crimping 250 Series, M Type Tab and Receptacle Contact					

NUMBER: 114 - 5088

Customer Release

SECURITY CLASSIFICATION:

4. Instructions to Crimping Operation:

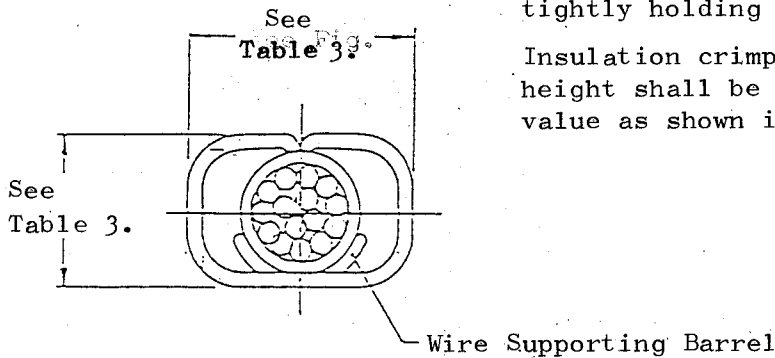
- 4.1 When to remove wire insulation, care must be taken not to damage and cut the wire conductors. Conductors shall be neatly cut stright.
- 4.2 Avoid inside of wire barrel from contamination by oily and greasy materials and other foreign particles.
- 4.3 No conductors shall be loosing out from wire barrel seam, and not any conductors shall be loosing out of the wire barrel without crimping.
- 4.4 Not any portion of wire insulation shall enter into wire barrel crimp.
- 4.5 After crimping, wire insulation shall be firmly gripped within insulation support crimping barrel.

5. Crimped Feature of Insulation Barrel of M Type Contact:

After crimping, insulation barrel crimp shall appear as shown in Fig. 2.

Wire support barrel shall hold wire in place normally, and insulation barrel shall be tightly holding the wire insulation.

Insulation crimp width and insulation crimp height shall be conforming to the specified value as shown in Table 3.



SHEET 3 OF 3	<b>AMP</b>		AMP (Japan), Ltd. Kawasaki, Japan	
			LOC	LOC
NAME Crimping 250 Series, M Type Tab and Receptacle Contact				