

114 - 5208  
Application Specification  
Crimping of SHUR PLUG\* Contacts

NUMBER: 114 - 5208

Customer Release

SECURITY CLASSIFICATION:

1. Scope:

This specification covers the requirements for crimping of AMP SHUR PLUG\* Contact of the part numbers listed in Para. 2.

2. Applicable Contact Part Numbers:

The contacts of the part numbers shown below are applicable to this specification.

Descriptions	Part Number	Descriptions	Part Number
∅4 SHUR PLUG* Contact	170002-2	∅5 SHUR PLUG* Receptacle Contact	170003-4

3. Nomenclature:

For the purpose of this specification, the following nomenclature shall apply.

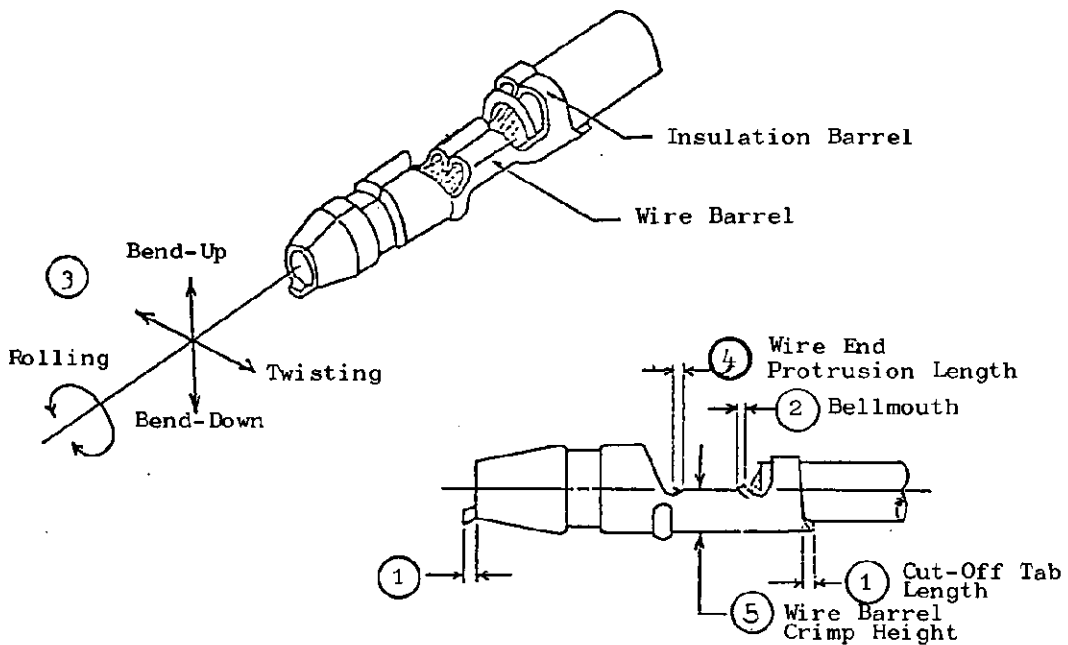


Fig. 1

				DR. <i>[Signature]</i> 2-25-95	SHEET 1 OF 3	<b>AMP</b> AMP (Japan), Ltd. Kawasaki, Japan			
				CHK. 27.FEB.'95		LOC J	A	NO. 114 - 5208	REV. 0
				<i>[Signature]</i>					
				APP. 27 FEB '95	NAME Crimping of SHUR PLUG* Contacts				
PRINT	0	ECN FJ00-2077-95	<i>[Signature]</i> 2-23-95						
LTR	REVISION RECORD	DR	CHK	DATE					

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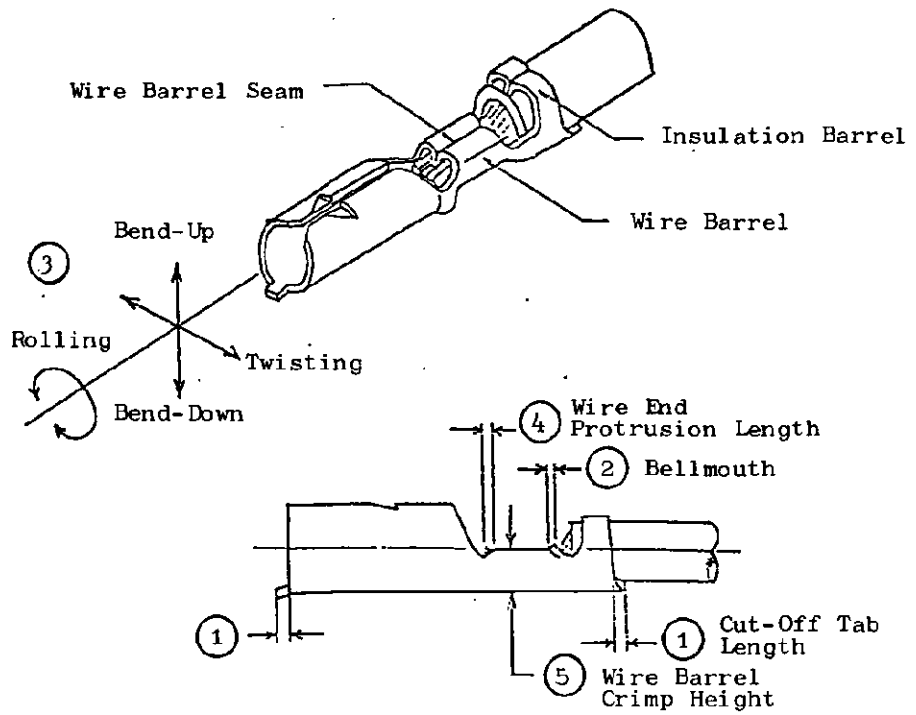


Fig. 2

SHEET 2 OF 3	<b>AMP</b>		AMP (Japan), Ltd. Kawasaki, Japan	
	LOC	LOC	NO. 114 - 5208	REV. 0
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4. Crimping Conditions and Crimp Data:  
 4.1 Crimping Conditions:

No.	Check Items	Crimping Requirements	Remarks
1	Cut-Off Tab Length	0.5mm max.	Fig. 1 (1)
2	Bellmouth(Rear End of the Barrel)	0.2 - 1.0mm	Fig. 1 (2)
3	Allowable Limits of Deformation after Crimping	Bend( <sup>Up</sup> / <sub>Down</sub> )	6° max.
		Twisting	6° max.
		Rolling	12° max.
4	Wire End Protrusion Length	0 - 1.5mm	Fig. 1 (4)
5	Insulation Stripping Length	5 - 6mm	—//—


4.2.1 Crimp Data: (Plug)

Contact Part Number	Wire Size mm <sup>2</sup> (Nominal)	Applicator Number	Wire Barrel Crimp			Insulation Barrel Crimp		Crimp Tensile Strength (kg)(min.)
			Width (mm)	Height Note 1. Fig.15	Disc Pad. Ltr.	Width (mm)	Finished Insulation Diameter (mm)	
170002-2	0.5	686141-2	2.79 "F"	1.50	D	4.57 "F"	2.54mm / 3.68mm	8.0 min.
	0.75			1.63	C			15.0 min.
	1.25			1.73	B			20.0 min.
	2.0			1.88	A			25.0 min.

4.2.2 Crimp Data: (Receptacle)

Contact Part Number	Wire Size mm <sup>2</sup> (Nominal)	Applicator Number	Wire Barrel Crimp			Insulation Barrel Crimp		Crimp Tensile Strength (kg)(min.)
			Width (mm)	Height Note 1. Fig.15	Disc Pad. Ltr.	Width (mm)	Finished Insulation Diameter (mm)	
170003-4	0.5	686270-2	2.79 "F"	1.37	D	4.57 "F"	2.54mm / 3.68mm	8.0 min.
	0.75			1.42	C			15.0 min.
	1.25			1.55	B			20.0 min.
				1.73	A			25.0 min.

- Notes: (1) General tolerance of wire barrel crimp height to be within plus/minus(±) 0.05mm.  
 (2) Unless otherwise noted, all the dimensions are in millimeters.

SHEET 3 OF 3	 AMP (Japan), Ltd. Kawasaki, Japan		NO. 114 - 5208	REV. 0
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