APPLICATION SPECIFICATION

1. SCOPE

This specification has been prepared by the Automachine Group of AMP Incorporated as a guide for visual inspection of terminals as they are being crimped. Its intended use is for personnel responsible for setting up wire preparation and terminator machines.

2. APPEARANCE

A properly crimped terminal will have the appearance depicted in the illustration titled "Finished Crimp", Figure 1.

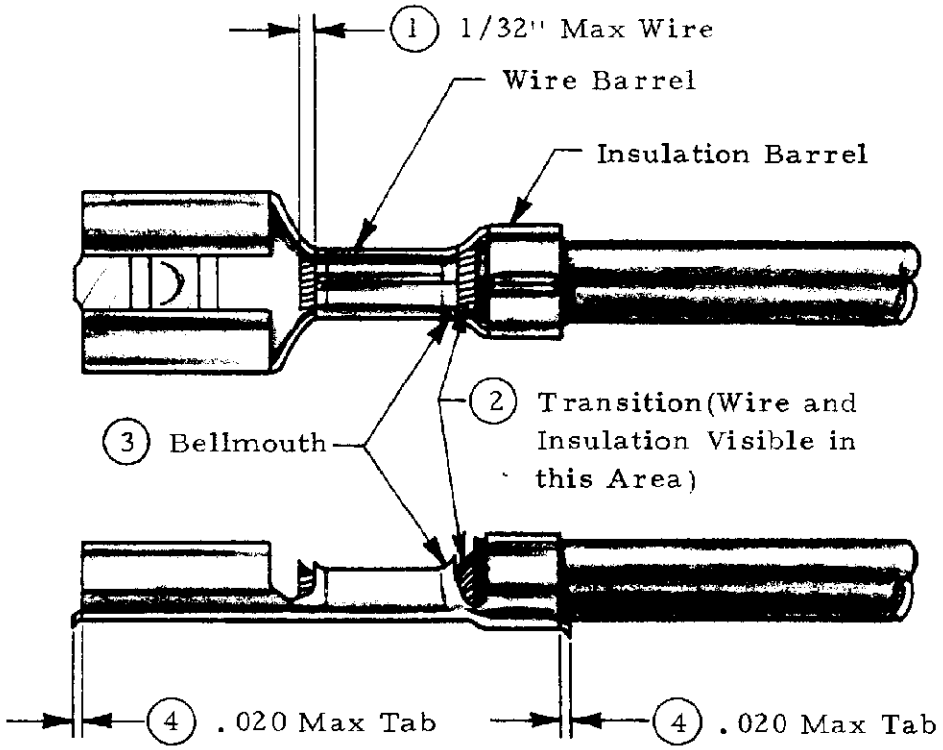

Figure 1

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A	Typing Correction	[illegible]	9/4/79

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LOC B | A | NO 114-35000 | REV A

SHEET 1 OF 3

NAME WIRE PREPARATION AND CRIMP INSPECTION GUIDE

2.1. Important Considerations

A. Wire Strip Length and Placement

(1) Wire should be stripped and placed within a terminal so that wire strands are visible at the front (contact) end of the wire barrel ① Figure 1. If wire extension is excessive, it can interfere with mating terminals and/or insertion of the terminal into an insulator or housing.

(2) Wire strands and insulation should be visible within the transition between the wire and insulation barrel ② Figure 1.

These conditions will ensure:

(a) That the wire extends through the wire barrel.

(b) That there is no insulation crimped in the wire barrel.

(c) Maximum effectiveness of the insulation crimp.

3. WIRE STRIP LENGTH

Recommended wire strip lengths for terminal wire barrel designs are listed in Figure 2.

Wire Stripping Guide		
Wire Barrel Length	Wire Strip Length	Fixed Spacer Block (a)
.093-.108	4/32 (1/8)	4/32 (1/8)
.109-.141	5/32	5/32
.142-.174	6/32 (3/16)	6/32 (3/16)
.175-.207	7/32	7/32
.208-.240	8/32 (1/4)	8/32 (1/4)
.241-.273	9/32	9/32

(a) Fixed spacer blocks used to set wire strip lengths in most commercially available wire stripping machines come in 1/32 inch increments.

Figure 2

4. WIRE BARREL BELLMOUTH

Crimp tooling and terminal alignment should be such that a definite bellmouth, ③ Figure 1, is evident at the rear (wire end) of the wire barrel. This feature eliminates the abrupt change from the reduced cross section of the crimp to the full diameter of the wire. It is necessary to maintain the mechanical integrity of the wire.

Too much bellmouth at the rear (wire end) or bellmouth at the front (contact) end of the wire barrel reduces the effective length of the crimp and its current carrying capability.

5. TERMINAL FEED

5.1. End Feed Terminals

The terminal feed has been properly adjusted when the cut-off tab is centered on the bottom of the crimped terminal with equal length to the front and rear of the terminal ④ Figure 1. A cut-off tab exceeding .020 maximum can interfere with mating terminals or tabs and/or full insertion of the terminal into a housing or insulator.

5.2. Side Feed Terminals

The terminal feed has been properly adjusted when the crimps (wire and insulation) are symmetrical. The meeting of the crimped seam should be on the centerline of the terminal. A cut-off tab exceeding .020 maximum ④ Figure 1, can interfere with mating terminals or tabs and/or full insertion of the terminal into a housing or insulator.

6. CRIMP TOOLING AND DIMENSIONS

For specific crimp tooling and crimp dimensions consult applicator parts list by terminal part number.