Application Specification

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LTR	REVISION RECORD	APP	DATE

DIST

DR 08.91 H. Lutsch
CHK F. Kourimsky
APP Baderschneider

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AMP | AMP DEUTSCHLAND GmbH Langen b.Ffm.

LOC		NO	REV
AI	A4	114-18020	0

NAME 2.5 mm dia Contact System Neutral Version

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1. Introduction

This specification covers the requirements for application of 2.5mm dia pin and socket contacts.
These instructions are primarily for automatic application, but use can also be made of a handtool.

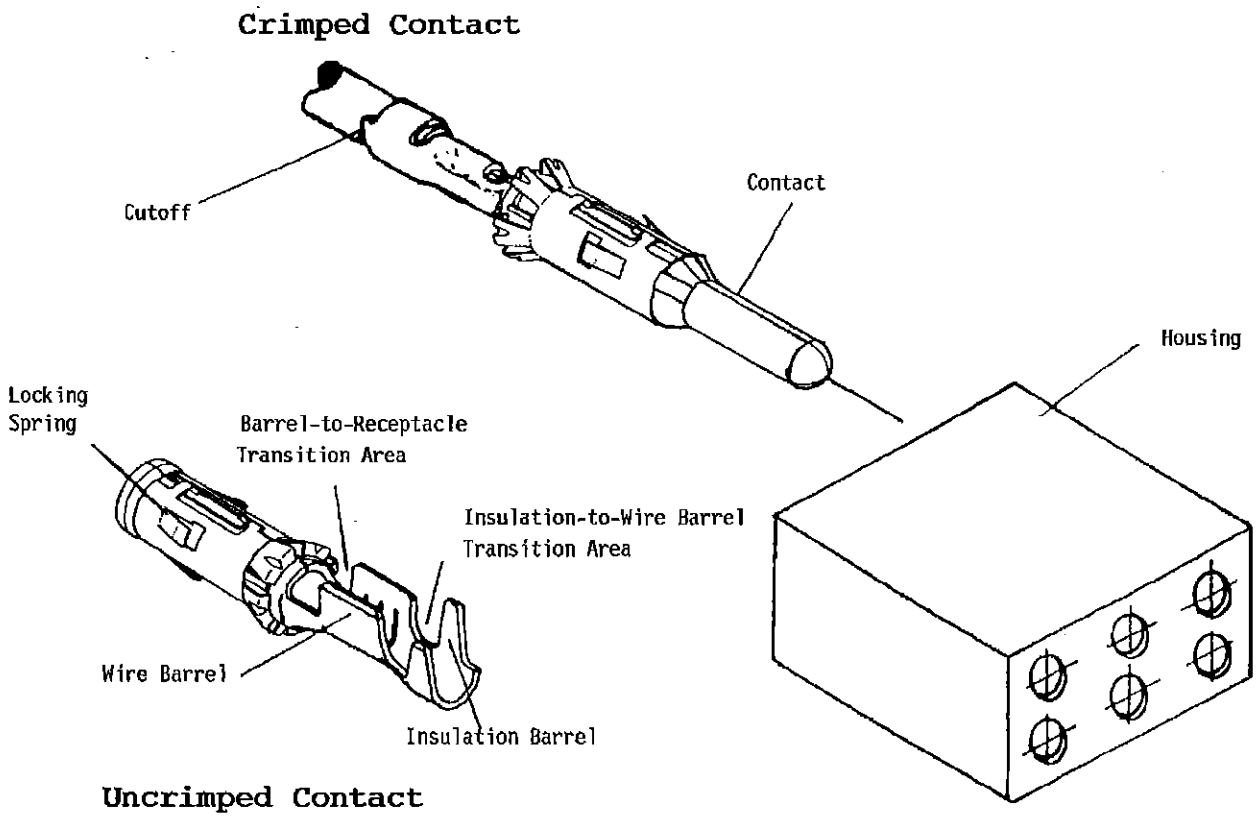


Fig.1

2. Referenced Documents

2.1 Product Numbers and Product Codes

2.5 mm dia Contact System Neutral Version

CONTACT	WIRE-TYP	WIRE-RANGE /mm²	PART NUMBER STRIP	PART NUMBER LOOSE PIECE	APPLI-CATOR NR.	HANDTOOL NR.	SINGLE WIRE SEALING SEAL NR.	SINGLE WIRE SEALING CAVITY PLUG NR.
PIN	FLR	0.2-0.4	929 962	962 966	2-878 480	734 285-1	-	-
	FLR	0.5-1.0	929 963	962 967	2-878 481	734 285-1	-	-
	FLR	> 1-2.5	929 964	962 968	2-878 482	734 285-2	-	-
	FLR	> 2.5-4	929 965	962 969	2-878 483	734 285-3	-	-
	UL1015 *	0.5-1.0	929 996	962 974	2-878 475	88-10510-1	-	-
	UL1015 *	> 1-2.5	929 997	962 975	2-878 476	88-10510-2	-	-
SOCKET	FLR	0.2-0.4	929 969	962 976	2-878 480	734 285-1	-	-
	FLR	0.5-1.0	929 970	962 977	2-878 481	734 285-1	-	-
	FLR	> 1-2.5	929 971	962 978	2-878 482	734 285-2	-	-
	FLR	> 2.5-4	929 972	962 979	2-878 483	734 285-3	-	-
	UL1015 *	0.5-1.0	929 998	962 984	2-878 475	88-10510-1	-	-
	UL1015 *	> 1-2.5	929 999	962 985	2-878 476	88-10510-2	-	-
PIN for SINGLE WIRE SEALING	FLR	0.2-0.4	929 966	962 970	2-878 484	734 289-1	828 920	828 922
	FLR	0.5-1.0	929 967	962 971	2-878 485	734 289-1	828 920	828 922
	FLR	> 1-2.5	929 968	962 972	2-878 486	734 289-2	828 921	828 922
	FLR	> 2.5-4	962 800	962 973	2-878 487	734 289-3	828 985	828 986
SOCKET for SINGLE WIRE SEALING	FLR	0.2-0.4	929 973	962 980	2-878 484	734 289-1	828 920	828 922
	FLR	0.5-1.0	929 974	962 981	2-878 485	734 289-1	828 920	828 922
	FLR	> 1-2.5	929 975	962 982	2-878 486	734 289-2	828 921	828 922
	FLR	> 2.5-4	962 801	962 983	2-878 487	734 289-3	828 985	828 986

NOTES: General use, * only for Bosch ; design objectivs 108-18027; application specification for sealing 114-18018; extraction tool 518 082-1; spare tube 548 551-1.
contact dash-Nr.: -1 CuNiSi pre tin; -2 CuNiSi silver plated; -3 CuNiSi gold plated; -4 CuFe2 pre tin; -5 CuFe2 silver plated; -6 CuFe2 gold plated. Minimum pitch (mm): 6 x 6 (6 x 5,2) for normal application and wire size range till 2,5 mm² and for single wire sealing or 7,2 x 7,2 (7,2 x 6,2) for wire size range till 4 mm² for single wire sealing.
() = for displaced rows

Fig.2

DIST

2.2 Customer Drawing

An AMP Customer Drawing is available for each part number assigned to this product line (see Fig.2). In the event of a variance between this specification and the customer drawing, the customer drawing will take precedence.
Crimp information shall be taken from the customer drawings.

2.3 Instructional Material

IS 7424 AMP Instruction Sheet describes measurement of the crimp height.

B-D/E-29-07/91 Operation Manual for the extraction tool.

AI 8025 deals with the MQC - crimp tool.

CM 5128 includes information for the crimping machine.

2.4 Specifications

AMP Spec. 108-18027	-Design Objective containing the requirements and performance of these contacts.
AMP Spec. 114-18022	-General instructions for the application of contacts with open barrel.
AMP Spec. 114-18018	-Application Specification for single wire sealing.

3. Requirements

3.1 Wire

A. Wire Selection

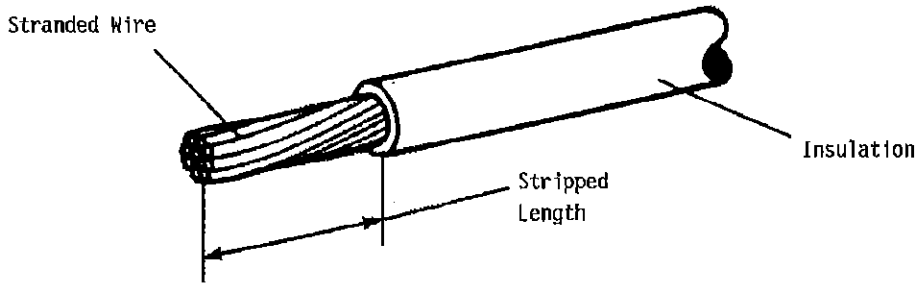
The crimping barrels of each contact are designed to receive stranded copper wire (Fig. 2).
Other wires need the approval of the Engineering Department. Consult AMP for details. Only single termination is permissable.

B. Wire Preparation

The wire must be stripped to the dimension shown in figure 3.
Care must be exercised to prevent cutting or nicking of the wire strands.
Care must also be taken, when handling wire during crimping to prevent cracking or breaking of the wire strands or the insulation.

PART NUMBER	STRIP LENGTH	PART NUMBER	STRIP LENGTH
929 962	4.2 ± 0.3 mm	929 998	4.8 ± 0.3 mm
929 963	4.2 ± 0.3 mm	929 999	5.9 ± 0.3 mm
929 964	5.2 ± 0,3 mm	929 966	4.5 ± 0.3 mm
929 965	5.2 ± 0.3 mm	929 967	4.5 ± 0.3 mm
929 996	4.8 ± 0.3 mm	929 968	5.5 ± 0.3 mm
929 997	5.9 ± 0.3 mm	962 800	5.5 ± 0.3 mm
929 969	4.2 ± 0.3 mm	929 973	4.5 ± 0.3 mm
929 970	4.2 ± 0.3 mm	929 974	4.5 ± 0.3 mm
929 971	5.2 ± 0.3 mm	929 975	5.5 ± 0.3 mm
929 972	5.2 ± 0.3 mm	962 801	5.5 ± 0.3 mm

Fig.3



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NAME

2.5 mm dia Contact System
Neutral Version

3.2 Crimped Contact

A. Cutoff

The cutoff must be visible after crimping. The maximum length is 0.5mm. Burrs resulting from shearing of the cutoffs may not exceed 0.08mm.

B. Wire Barrel

The crimp form, crimp height and crimp width as well as the wire range can be taken from the customer drawing.

The crimp extractions forces must meet the requirements of DIN IEC 352 part 2.

The rear bellmouth is 0.4 ± 0.2 mm for all wire ranges. A front bellmouth is permissable.

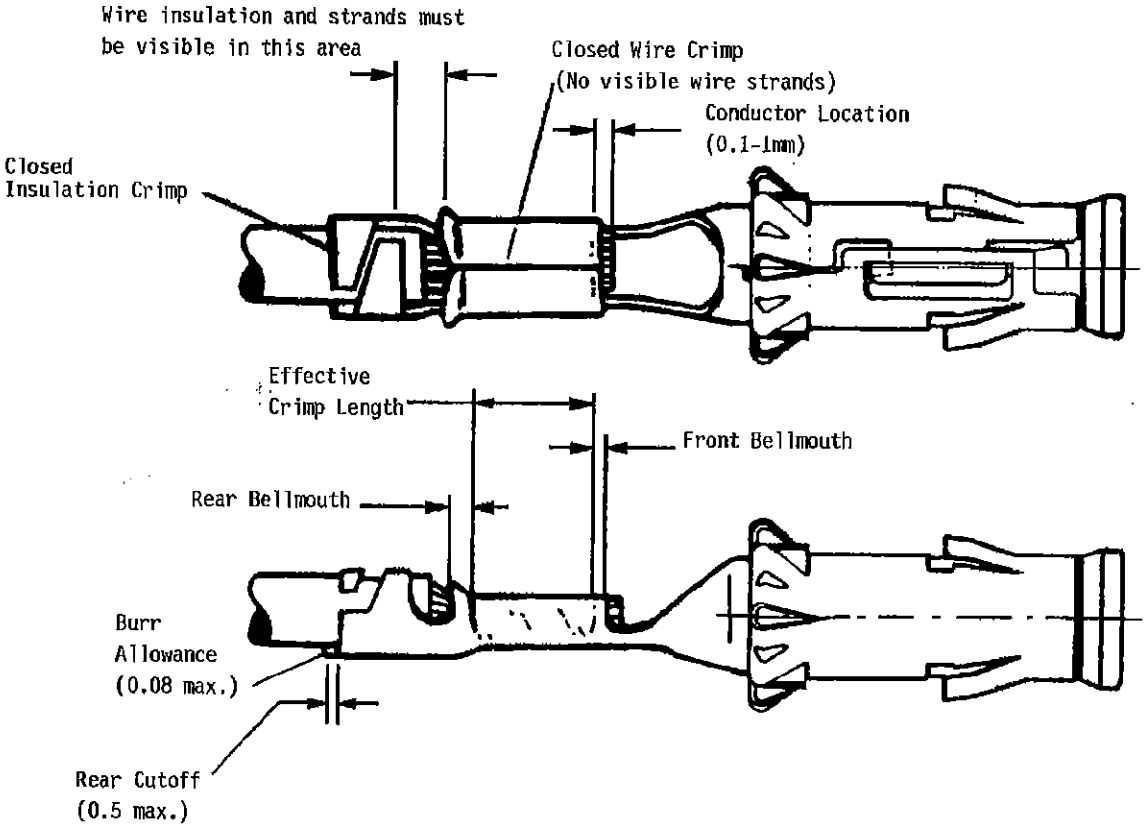
The conductor ends must extend beyond the front of the wire barrel by 0.1 mm min. / 1.0 mm max.

C. Insulation Barrel

The requirements for the insulation grip effectiveness are laid down in DIN IEC 352 part 2.

D. Contact Area

Locking spring with back up spring and the contact body may not be distorted or damaged after crimping.



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NAME

2.5 mm dia Contact System
Neutral Version

Mouser Electronics

Authorized Distributor

Click to View Pricing, Inventory, Delivery & Lifecycle Information:

TE Connectivity:

929974-1 (MOUSER REEL) 929974-1 (CUT STRIP)