

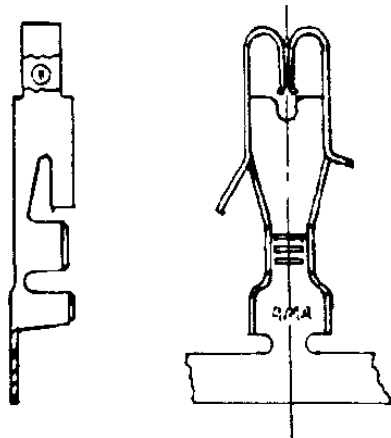
Fuse Contact

1. INTRODUCTION

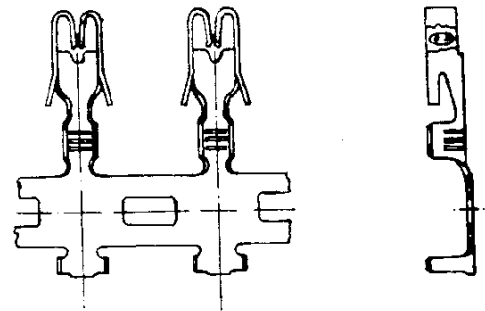
This specification covers requirements for application of "FUSE CONTACT" receptacles with the AMP* "F" crimp wire feature .

Receptacles are available in a variety of mating configurations , in order to clarify , see figures below :

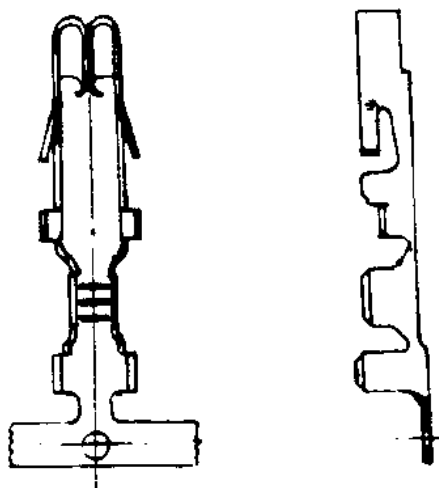
Note : All dimensions in this document are given in inches with an applied tolerance of $\pm .005$ unless otherwise specified. Metric equivalents (millimeters) may be obtained by multiplying the dimensions and tolerances by 25,4 and rounding to the nearest hundredth .



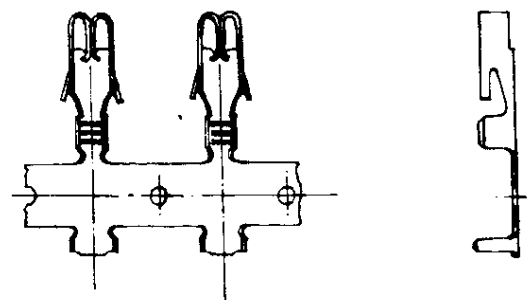
**Special Contact
Type I**



**Bus-Bar Straight
Type II**



**Single
Type III**

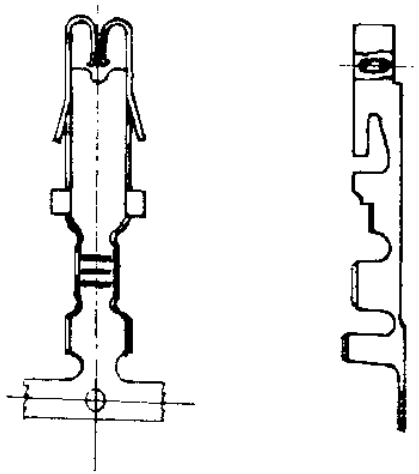


**Bus-Bar Straight
Type IV**

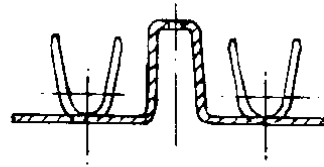
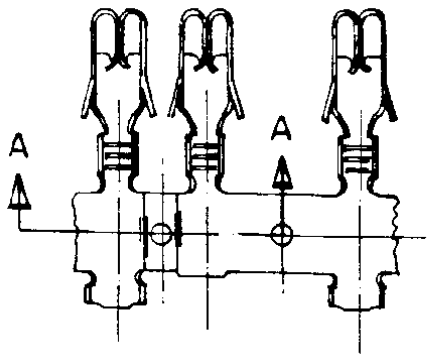
Prepared by : Stella M.Silva

Checked by : José L.J.Costa

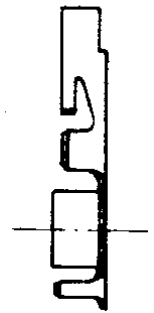
Approved by : Celso C.Lima



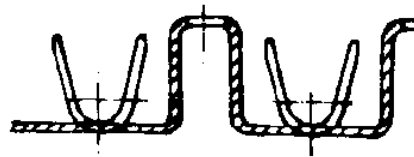
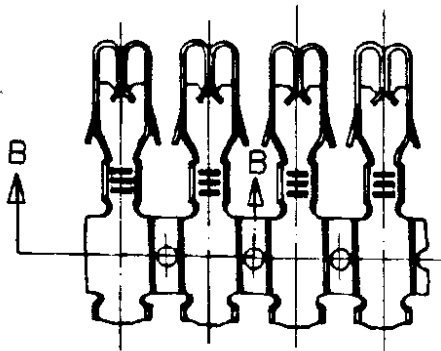
Single
Type V



Section A - A



Bus-Bar Bent
Type VI



Section B - B



Bus-Bar Bent
Type VII

2. REFERENCE MATERIAL

2.1 Product part number information

- a) These products (see figures type I to VII para .1) are used by a network of AMP customer service people to access tooling and product application. This service is provided before the purchase by local AMP representative (field sales engineer , field applications engineer , etc) or , after the purchase , by calling the “CUSTOMER HOTLINE” number at page 1 .
- b) Your local AMP representative will answer your product questions, or will contact the appropriate information source for you .

2.2 Engineering Drawings

Customer drawings for specific products are available from the responsible Tyco Electronics engineering department via the appropriate service network source (see paragraph 2.1). The information contained in customer drawing takes priority if there is a conflict with this document or with any other technical documentation supplied by Tyco Incorporated .

2.3 Technical Publications

The following Tyco applicator Instruction Sheets (AI) and customer manuals (CM) provide application tooling information as listed below :

- CM 5128 AMP-O-LETRIC* model “K” terminating machine
- CM 5290 AMPOMATOR* IV B machine.
- CM 5579 AMP Model “T” terminating unit for use in automatic machines.
- CM 5619 AMPOMATOR CLS lead-making machine.
- CM 5792 AMP-O-LECTRIC model “K II” terminating machine
- A I 8039 AMP heavy duty end-feed miniature quick-change applicators with mechanical or Air feed system
- A I 8040 AMP heavy duty end-feed miniature quick-change applicators with mechanical or Air feed system
- A I 8024 End feed miniature quick-change applicators with mechanical feed system.
- A I 8025 Side feed miniature quick-change applicators with mechanical feed system.

3. REQUIREMENTS

3.1 Storage and chemical exposure limitations

The chemicals listed below can cause stress corrosion cracking in brass receptacles :

Alkalies	Citrates	Sulfides
Amines	Nitrites	Sulfur compounds
Ammonia	Phosphates	Tartrates
Carbonates		

Note : Where the above environmental conditions exist , phosphor-bronze receptacle are recommended instead of brass .

3.2 Product Selection

The fuse contact receptacles are available in a variety configurations , types of mating ends as described below .

Name	Type	Bus-bar single	feed	No. ways	Wire size
Special contact	I	Single	.590 (15 mm)	Not applicable	0,5-1,5
Fuse contact	II	Bus-bar straight	.590 (15 mm)	2 and 3	1-2,5
Fuse contact	V	Single	.590 (15 mm)	Not applicable	0,5-4,0
Fuse contact	III	Single	.590 (15 mm)	Not applicable	0,5-5,0
Fuse contact	VI	Bus-bar bent	.335 (8,55)	2 to 4	1-2,5 mm ²
Fuse contact	IV	Bus-bar straight	.590 (15 mm)	2 and 3	1-2,5
Fuse contact	VI	Bus-bar bent	.335 (8,50)	2 to 4	2,5-6,0 mm ²
Fuse contact	IV	Bus-bar straight	.590 (15 mm)	1 to 4	2,5-4,0
Fuse contact	VII	Bus-bar bent	.433 (11 mm)	As required	1-5,0

Figure 1

3.3 Descriptions

a) Fuse contact (Single)

The fuse contact is formed by resilient contact and double face with spring action in order to keep up stream in tab of the fuse . See figure III and V .

b) Fuse contact (Bus-bar Straight)

It is the same physical construction of the fuse contact (Single) except center carrier and Bus-bar application form . See fig. II and IV .

c) Fuse Contact (Bus-bar Bent)

It is the same physical construction of the fuse contact (Bus-bar Bent) except bend to reduce pitch . See fig. VI and VII .

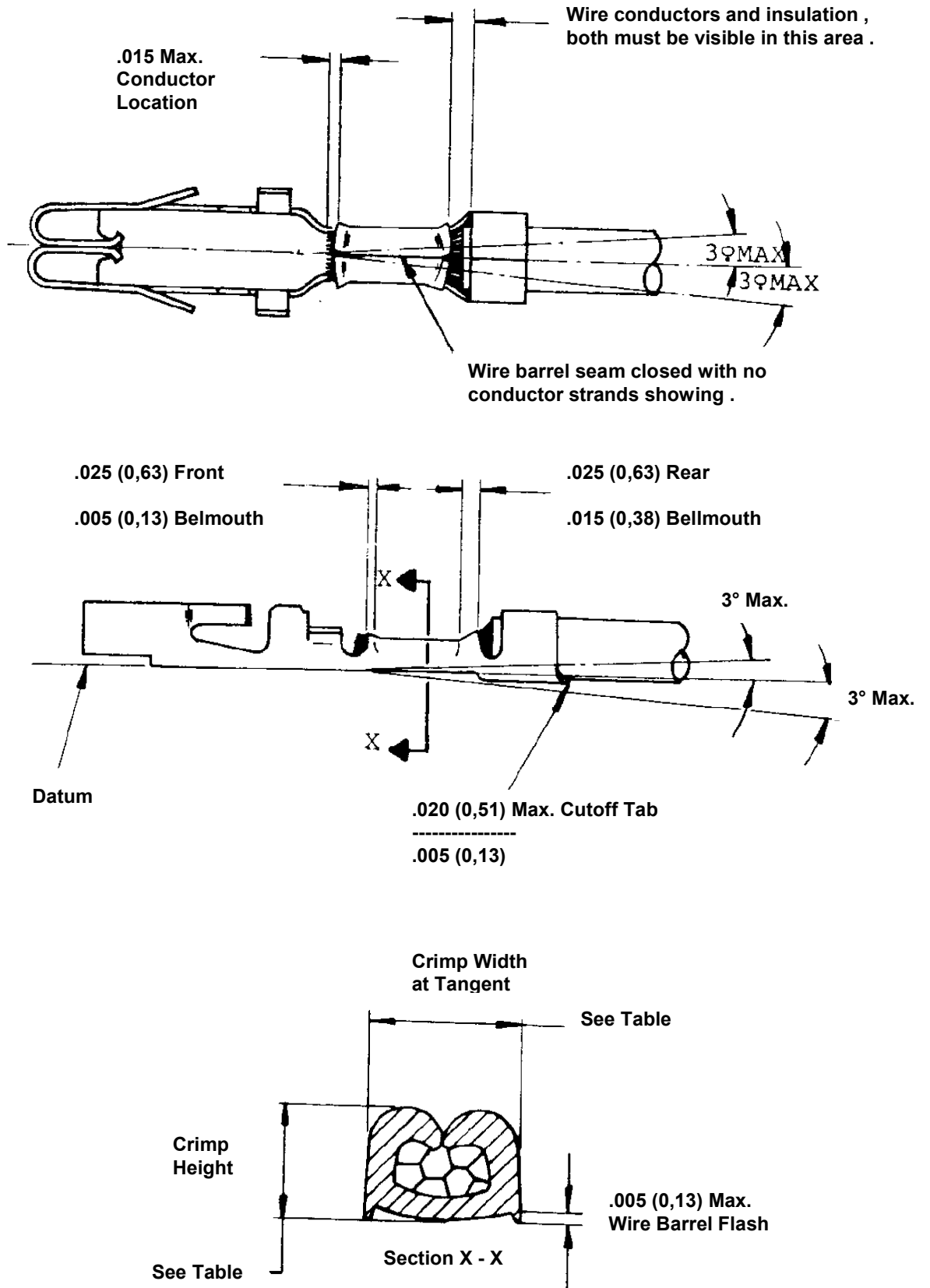
d) Special contact

It is the same physical construction of the fuse contact (Single) except the locking system in housing cavity . See Fig. I .

3.4 Reference specification

For applicable performance requirements see Tyco specification 108-37011 .

4. NOMENCLATURE



5. CRIMP AND DIMENSIONAL REQUIREMENTS

5.1 Wire preparation

- a) **Strip length**
Insulation shall be stripped as indicated in fig. 3.
- b) **Workmanship**
Reasonable care shall be taken not to nick , scrape or cut any strands or the solid wire during the stripping operation .

5.2 Carrier Cutoff tab and Burr

- a) **Cutoff tab**
Cutoff tab shall not exceed .020 (0,51) .
- b) **Burr**
Burr on cutoff tab shall nor exceed .005 (0,13)

5.3 Wire barrel crimp

- a) **Crimp dimension and type**
Crimp height , width and type shall be as shown in Figure 3 .
- b) **Wire barrel flash**
Burr on cutoff tab shall not exceed .005 (0,13)
- c) **Wire barrel seam**
Wire barrel seam shall be completely closed and there shall be no evidence of loose wire strands or wire strands or wire strands visible in the seam .
- d) **Bellmouth**
Rear bellmouth length shall be .015 (0,38) - .025 (0,63) .
- e) **Conductor location**
 - (1) End of the wire shall be flush with the front end of the wire barrel or extend .030 (0,46) max. 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 .

5.4 Insulation barrel crimp

- a) **Crimp dimensions and type**
Crimp height and type shall be as shown Ffigure 2 and 3 .
- b) **Workmanship**
Reasonable care shall be taken not cut or break the insulation during the crimp operation .

5.5 Locking latch

Locking latch shall not be deformed .

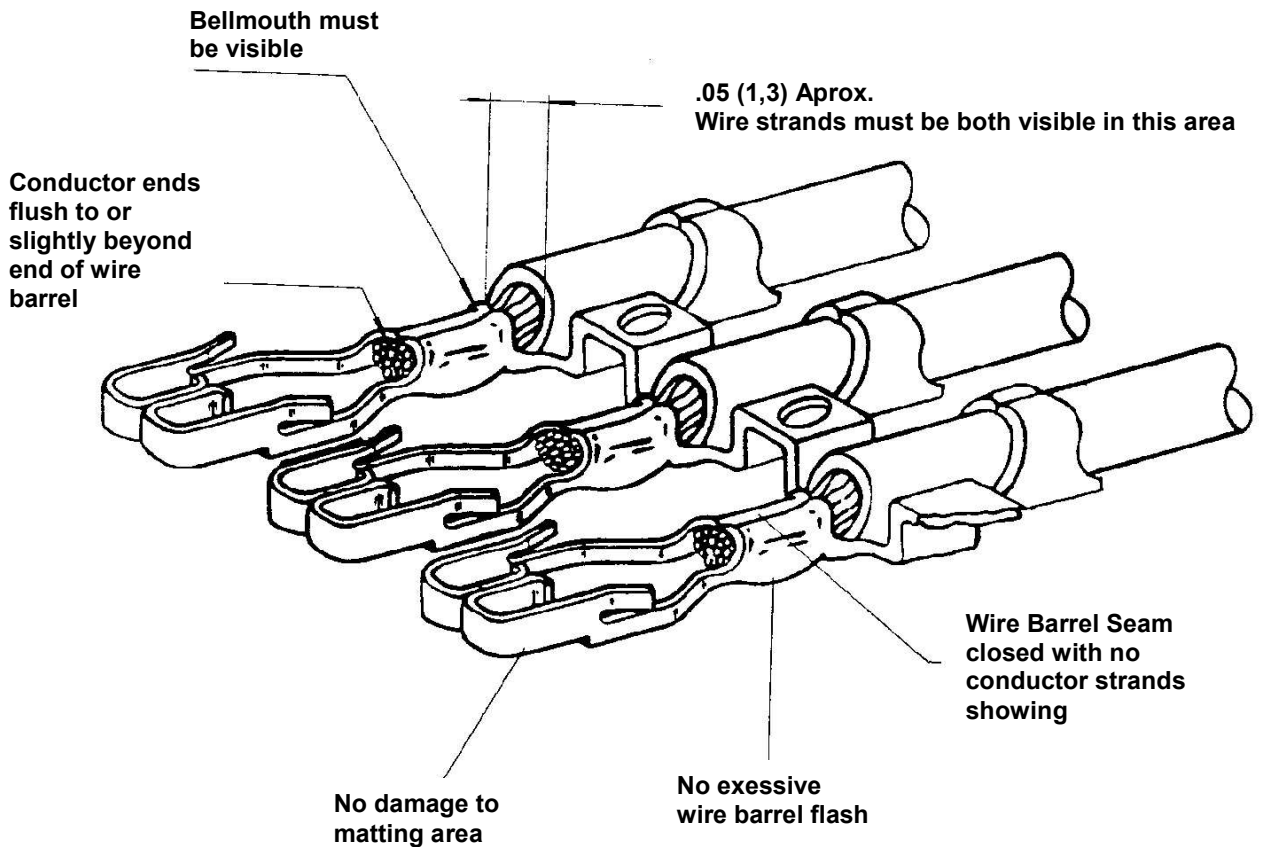
- a) **Straightness**
 - (1) The contact , including the cutoff tab and burr shall not be bent above or below the datum line more than the amount shown in figure 2 .
 - (2) The side to side bending of the contact shall not exceed the limits specified on figure 2 .
- b) **Twist or roll**
There shall be not twist or roll in crimped portion that will impair usage of the contact .

Part Number	Wire Size	Insulation Diameter	Strip length ± .015 (0,38)	Wire Barrel Crimp			Insulation Barrel Crimp			Applicator	Remarks
				Width	Height +.002	Type crimper	Width	Height max.	Type crimp		
880399	2,5 mm ² 3,0 mm ² 4,0 mm ² 5,0 mm ²	3,3-5,0 mm	4,8-5,6	.140 (3,56)	.083 (2,11) .086 (2,18) .095 (2,41) .104 (2,64)	F	.220 (5,56)	5,8 mm	F	573655 (HD)	
880490	1,0 mm ² 1,5 mm ² 2,0 mm ² 2,5 mm ²	3,0-4,3 mm	4,8-5,6	.110 (2,79)	.064 (1,62) .070 (1,78) .076 (1,93) .082 (2,01)	F	.180 (4,57)	5,1 mm	F	572788-1	Pneum.Feed
880491	1,0 mm ² 1,5 mm ² 2,0 mm ² 2,5 mm ²	3,0-4,3mm	4,8-5,6	.110 (2,79)	.064 (1,62) .070 (1,78) .076 (1,93) .082 (2,01)	F	.180 (4,57)	5,1 mm	F	571717 (HD) 571717-1 (HD) 571717-2 (HD) 573773-1	Pneum. Feed Pneum. Feed Special Appl.
880492	2,5 mm ² 3,0 mm ² 4,0 mm ² 5,0 mm ²	3,3-5,0 mm	4,8-5,6	.140 (3,56)	.083 (2,11) .086 (2,18) .095 (2,41) .104 (2,64)	F	.210 (5,33)	5,8mm	F	572789-1	Pneum. Feed
880547	1,0 mm ² 1,5 mm ² 2,0 mm ² 2,5 mm ²	3,0-4,3 mm ²	4,8-5,6	.110 (2,79)	.064 (1,62) .070 (1,78) .076 (1,93) .082 (2,01)	F	.180 (4,57)	5,1 mm	F	572937	Use conjugated with log 572935
880548	2,5 mm ² 3,0 mm ² 4,0 mm ² 5,0 mm ²	3,3-5,0 mm ²	4,8-5,6	.140 (3,56)	.083 (2,11) .086 (2,18) .095 (2,41) .104 (2,64)	F	.210 (5,33)	5,8 mm	F	572938	Use conjugated with log 572935
881572	4,0 mm ² 5,0 mm ² 6,0 mm ²	4,0-5,1 mm ²	4,8-5,6	.140 (3,56)	.096 (2,44) .105 (2,67) .114 (2,90)	F	.180 (4,57)	5,9 mm	F	573707	Special appl.

Part Number	Wire Size	Insulation Diameter	Strip length ± .015 (0,38)	Wire Barrel Crimp			Insulation Barrel Crimp			Applicator	Remarks
				Width	Height +.002	Type crimper	Width	Height max.	Type crimp		
626499	1,0 mm ² 1,5 mm ² 2,0 mm ² 2,5 mm ²	3,0-4,3 mm dia	4,8-5,6	.110 (2,79)	.064 (1,62) .070 (1,78) .076 (1,93) .082 (2,08)	F	.180 (4,57)	5,1 mm	F	571717 571717-1 571717-2	(H.D) Pneum. Feed (HD) Pneum. Feed (HD)
626500	1,0 mm ² 1,5 mm ² 2,0 mm ² 2,5 mm ²	3,0-4,3 mm dia	4,8-5,6	.110 (2,79)	.064 (1,62) .070 (1,78) .076 (1,93) .082 (2,08)	F	.180 (4,57)	5,1 mm	F	572718-1 (HD) 572762	
626526	0,5 mm ² 0,75 mm ² 1,0 mm ² 1,5 mm ²	2,0-3,0mm dia	4,8-5,6	.090 (2,29)	.055 (1,40) .059 (1,50) .063 (1,60) .070 (1,78)	F	.180 (4,57)	3,8 mm	F	572761 572761-5	Isol.160 (4,06) "OV"
626527	0,5 mm ² 0,75 mm ² 1,0 mm ² 1,5 mm ²	2,0-3,0 mm dia	3,8-4,6	.090 (2,29)	.055 (1,40) .059 (1,50) .063 (1,60) .070 (1,78)	F	.180 (4,57)	3,8mm	F	571720 (HD) 572996	
626560	2,5 mm ² 3,0 mm ² 3,5 mm ² 4,0 mm ²	3,3-4,5 mm ² dia	4,8-5,6	.140 (3,56)	.075 (1,90) .079 (2,00) .083 (2,11) .088 (2,23)	F	.220 (5,59)	5,3 mm	F	571724 (HD) 572999	
880397	0,5 mm ² 0,75 mm ² 1,0 mm ² 1,5 mm ²	2,0-3,0 mm ² dia	4,8-5,6	.090 (2,29)	.055 (1,40) .059 (1,50) .063 (1,60) .070 (1,78)	F	.180 (4,57)	3,8mm	F	572761 572761-5	Isol.160 (4,06) "OV"
880398	1,0 mm ² 1,5 mm ² 2,0 mm ² 2,5 mm ²	2,3-3,5 mm ² dia	4,8-5,6	.110 (2,79)	.064 (1,62) .070 (1,78) .076 (1,93) .082 (2,08)	F	.180 (4,57)	5,1 mm	F	571718 (HD) 572762	

6. VISUAL AID

Figure 5 is to be used by production personnel to ensure a properly applied product . Sample receptacle is shown as it should appear for best quality termination . Applications which are NOT visually correct should be inspected using the information in the main body of this specification and in the instructional material shipped with the product or tooling .



Revision Record		
Letter	Date	Description
O	Feb-1992	Released
A	04-Jul-2002	LB00-0177-02
B	12-Jan-2004	Revised by EC LB00-0012-04