

114-5165

NUMBER :

Customer
ReleaseSECURITY
CLASSIFICATION :

Application Specification

114-5165

Termination and Assembly of CHAMP .050 Series (I)
Shield Type Connector (Wire-to-Board), Shield Case Kit

1. Scope :

1.1 Content :

This specification covers the requirements for termination and assembly of CHAMP* .050 Series (I), Shield Type Connector (Wire-to-board), shield case.

2. Reference Specifications :

2.1 AMP Specifications :

108-5347: Product Specification

114-5124: Application Specification (Applicable Wires and Terminating Conditions)

3. Product Nomenclature :

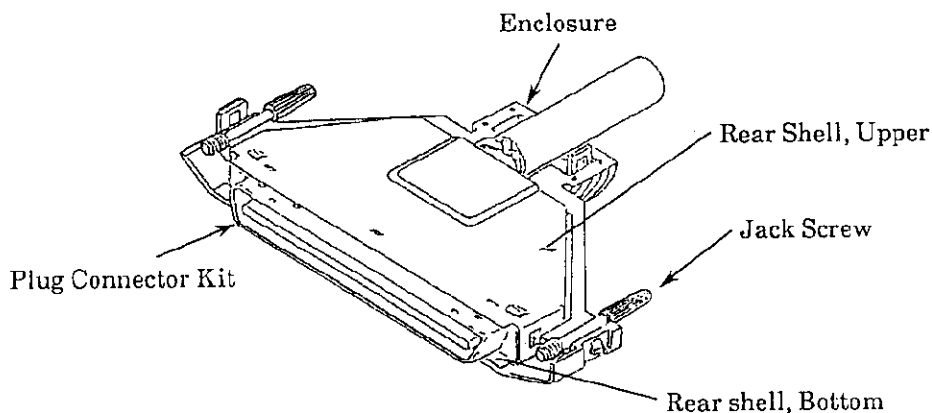


Fig. 1

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LTR	REVISION RECORD	DR	CHK	DATE	APP. 17-JAN. 192 Y. Fujima			NAME Termination and Assembly of CHAMP .050 Series (I) Shield Type Connector (W-T-B) Shield Case Kit								

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4. Product Component :

Kit Name	Product Description	Qty
Shield Case Kit	Rear Shell, Bottom (with Barrel)	1
	Rear Shell, Upper	1
	Enclosure	2
	Jack Screw	2

Table 1

5. Preparation of Cables :

5.1 Removal of Outer Sheath from Cable and Trimming of Braid Wires :

When removing outer sheath from the cable end and trimming of braid wires, care must be taken not to damage wire insulation.

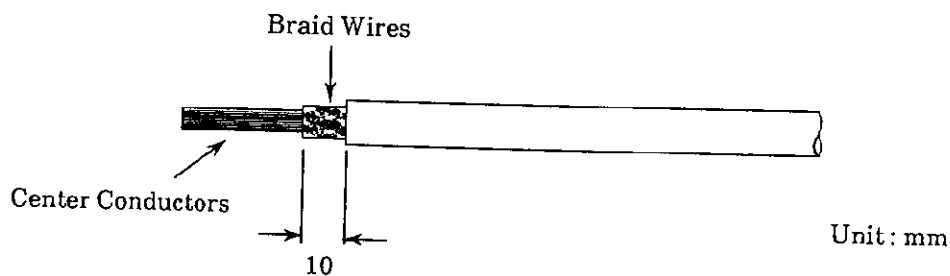


Fig. 2

5.2 Braid Wire Fold Back :

As shown in Fig. 3, fold back the braid on the outer jacket, and apply an adhesive tape twice on the jacket end. Tape width : 12 mm

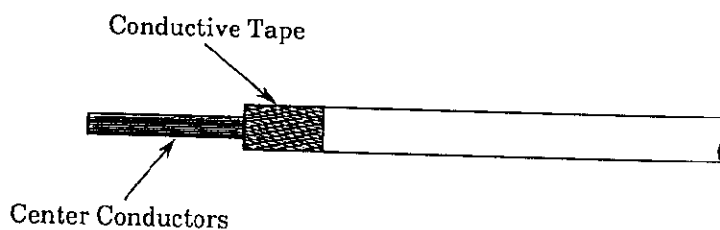


Fig. 3

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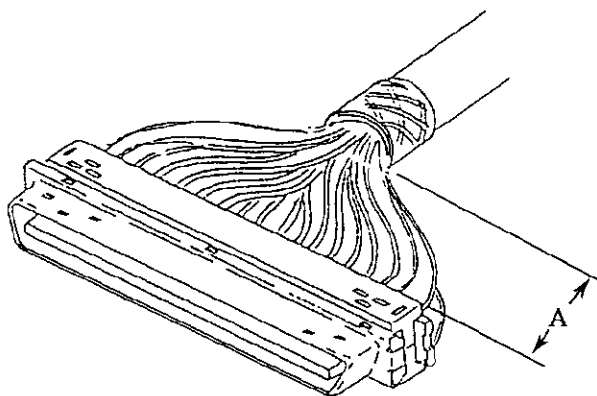
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6. Wire Termination :

See Application Specification, 114-5124 for the termination tools required and the quality control items. The length "A", shown in Fig. 4 from the connector end to the outer jacket should be controlled as given in Table 2.



Number of Positions	Dimension "A" (mm)
120	25

Table 2

Fig. 4

7. Cable Termination :

As shown in Fig. 5, first attach the plug connector onto the rear bottom shell stopper and latch the projection on the rear bottom shell into the matching holes on the plug connector. Then, crimp the barrel by using the appropriate tool (915697-). Crimp height and crimp width are shown in Table 3. The tensile strength of the crimped barrel shall be 10 kgf minimum.

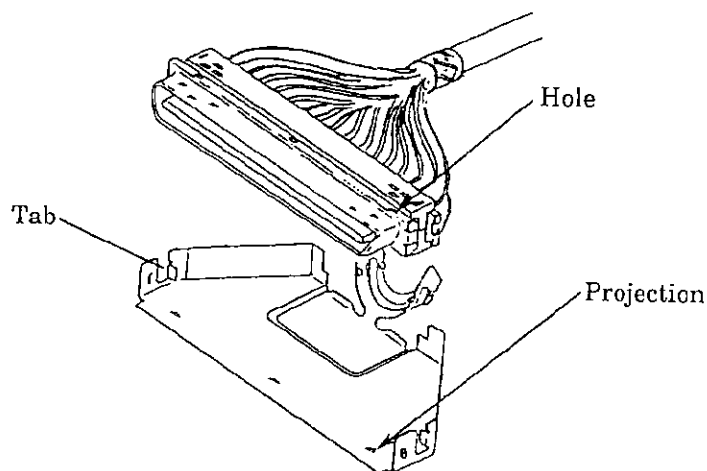


Fig. 5

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8. Assembly of the Rear Upper Shell :

As shown in Fig. 5, first align the projections of the upper shell with the matching holes on the plug connector. Then, engage the four projections on the bottom shell into the four connecting holes on the upper shell walls. Make sure the plug connector is not slanted as shown in Fig. 7. When the upper and rear shell are connected, there should be clicking sound. Also make sure that the connected shell shall not bulge raised or that the upper shell side walls shall be not open as shown in Fig. 8.

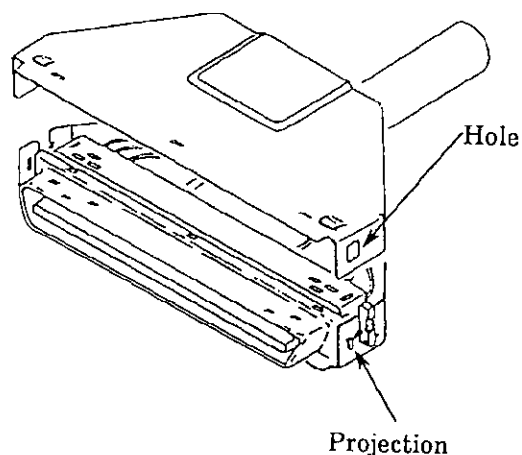


Fig. 6

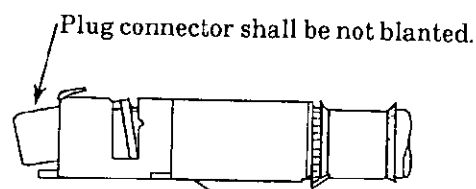


Fig. 7

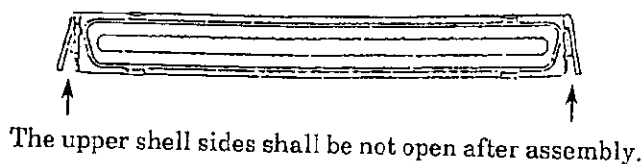
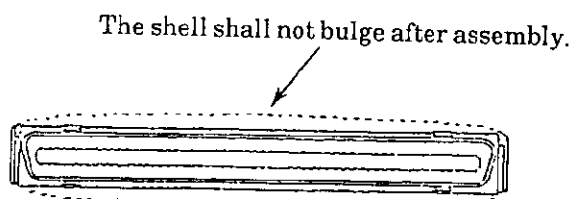


Fig. 8

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9. Applying Enclosure and Jack Screw :

To install enclosure on the housing shell, apply it to fit on both ends of the shell as shown in Fig. 9. Insert jack screws on either side in the unlocked condition. Then, have the enclosure locked on the sides and the cable retention area.

When the enclosure is locked, a clicking sound is heard. Confirm its secure fitting in place by this clicking sound.

Insert jack screws on either side with the enclosure placed in position but being unlocked.

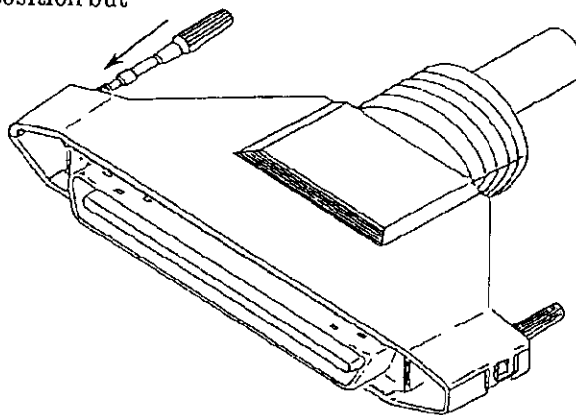


Fig. 9

10. Crimp Data :

No. of Pos.	No. of Cable Conductors	Applicable Cable Outer Diameter (mm)	Crimp Height (C/H) (mm)	Crimp Width (C/W) (mm)	Crimping Tool Part Number
120	6 8	8.1 - 9.0	8.6 ± 0.1	8.6 ± 0.1	915697-2
	120	10.8 - 12.0	9.0 ± 0.1	12.9 ± 0.1	915697-4

Table 3

Note 1 Crimp width is reference data.

Note 2 Crimp height may be adjusted to obtain crimp tensile strength of 10.0 kgf.

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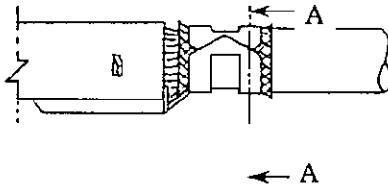
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Fig. 10

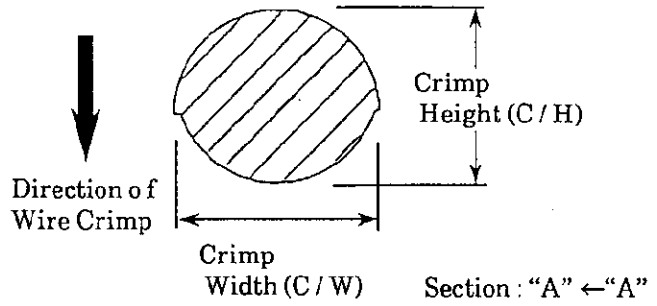


Fig. 11

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0	<i>K. Maeyama</i>	<i>[Signature]</i>	27 JAN 92
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