Crimping of 0.64 III Receptacle Contact

The performance of applicable product is guaranteed only when processed by proper application tooling and condition described in this specification and/or TE recognized ones.
No product is guaranteed when processed with the other tool or condition.

1. SCOPE

This specification covers the requirements for crimping of 0.64 III Receptacle Contact.

2. APPLICABLE CONTACTS

TE Part Numbers (Strip Form)	NAME	Finish	Applicable Wires
1674936-5	0.64 III RECEPTACLE CONTACT (S)	Pre-Tin	CHFUS 0.22
1674936-6		Selective Gold	
1674311-7	0.64 III RECEPTACLE CONTACT (M)	Pre-Tin	AVSS 0.3-0.5 CAVUS 0.3 CAVS 0.3-0.5 CHFUS 0.35-0.5 AVSS/AVSSH 0.3f-0.5f HFSS 0.35f-0.5f
1674311-8		Selective Gold	

3. NOMENCLATURE

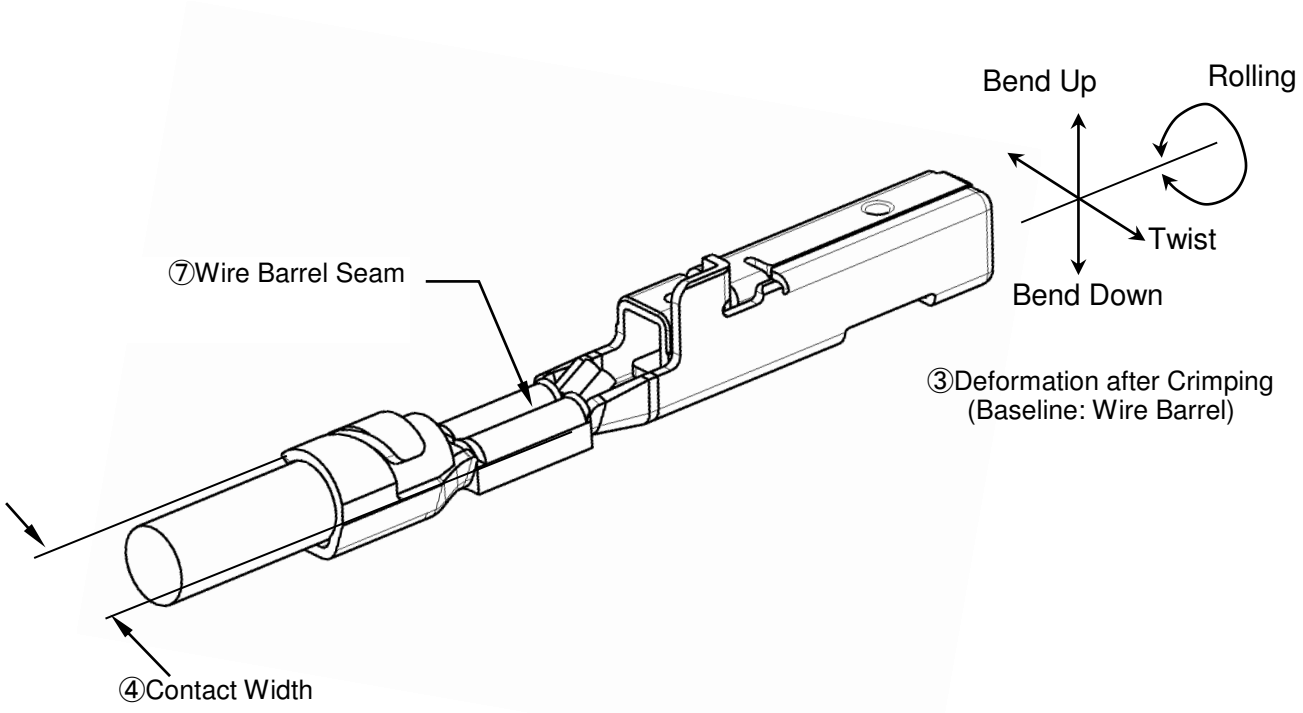

Fig.1 (To be continued)

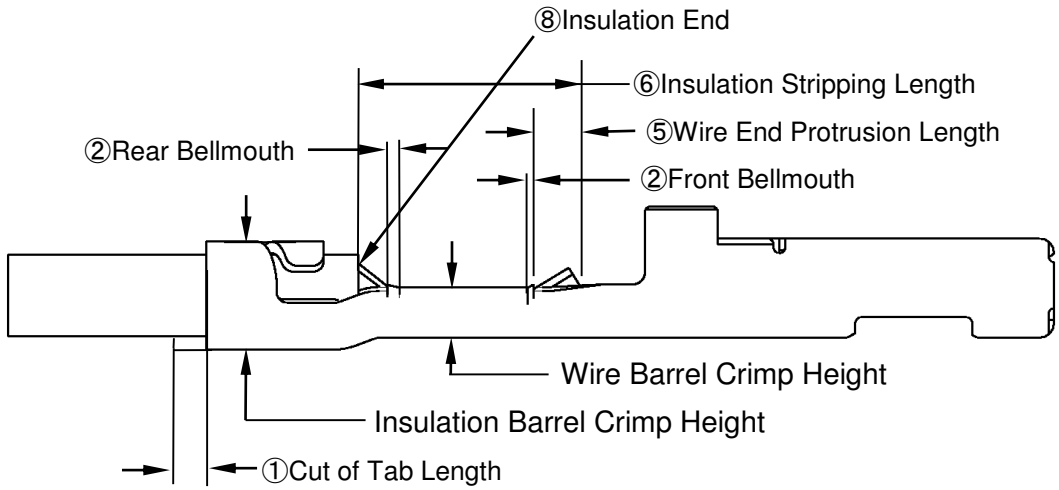

Fig.1 (End)

4. CRIMPING CONDITION

Applicator Crimp

Check Items			Requirements	Remarks
1	Cut-off Tab Length		0.1－0.5 mm	Fig.1－①
2	Bellmouth	Front	0.2 mm Max.	Fig.1－②
		Rear	0.1－0.5 mm	
3	Deformation after Crimping (Baseline: Wire Barrel)	Bend	－1°, +2°Max.	Fig.1－③
		Twist	±4°Max.	
		Rolling	±10°Max.	
4	Contact Width after Crimping		1.7mm Max.	Fig.1－④
5	Wire End Protrusion Length		0－1.0 mm	Fig.1－⑤
6	Insulation Stripping Length		3.0－3.5 mm（Before Crimping）	Fig.1－⑥
7	Wire Barrel Seam		Seam must be closed (No strand looses out of the seam)	Fig.1－⑦
8	Insulation End		Insulation End must be between Wire Barrel and Insulation Barrel	Fig.1－⑧

5. CRIMP DATA

Applicator Crimp

Contact Part Number (Strip Form)	Applicator Part Number	Wire Type	Wire Size (Nominal)	Wire Barrel Crimp (mm)			Insulation Barrel Crimp (mm)			Crimp Tensile Strength (N)
				Width(2)	Height	Disk Ltr.	Width(2)	Height	Disk Ltr. (Ref.)	
1674936-5 1674936-6	1729145-2	CHFUS	0.22	1.16 "F"	0.73(1)	A	1.4 "O"	1.3 ±0.1	5	30Min.
1674311-7 1674311-8	1596731-2	AVSS	0.3 0.3f	1.4 "F"	0.76(1)	B	1.4 "O"	1.85 ±0.1	5	50Min.
			0.5 0.5f		0.86(1)	A				70Min.
		AVSSH	0.3f	1.4 "F"	0.76(1)	B	1.4 "O"	1.85 ±0.1	5	50Min.
			0.5f		0.86(1)	A				70Min.
		CAVUS	0.3	1.4 "F"	0.76(1)	B	1.4 "O"	1.5 ±0.1	5	50Min.
		CAVS	0.3	1.4 "F"	0.76(1)	B	1.4 "O"	1.85 ±0.1	5	50Min.
			0.5		0.86(1)	A				70Min.
		CHFUS	0.35	1.4 "F"	0.76(1)	B	1.4 "O"	1.5 ±0.1	-	50Min.
			0.5		0.82(1)	-		1.7 ±0.1	-	70Min.
		HFSS	0.35f	1.4 "F"	0.76(1)	B	1.4 "O"	1.7 ±0.1	-	50Min.
			0.5f		0.82(1)	-		1.85 ±0.1	-	70Min.

NOTE (1) Wire Barrel Crimp Height to be within ±0.05mm.

(2) Crimp Width dimensions are not the product width after crimping, but given by the width of crimper slot for reference.

6. APPLICABLE WIRE DATA

1) JASO WIRE

Wire Size (Nominal)	Number /Diameter (mm) of Conductor	Calculated Cross sectional Area (mm^2)	Insulation Diameter (mm)					
			AVSS/AVSSH		CAVS		CAVUS	
			STD.	Max.	STD.	Max.	STD.	Max.
0.3	7/0.26	0.3716	1.4	1.5	1.4	1.5	1.1	1.2
0.3f	19/0.16	0.3821	1.4	1.5	-	-	-	-
0.5	7/0.32	0.5629	1.6	1.7	1.6	1.7	-	-
0.5f	19/0.19	0.5387	1.6	1.7	-	-	-	-

2) ISO WIRE

Wire Size (Nominal)	Number /Diameter (mm) of Conductor	Calculated Cross sectional Area (mm^2)	Perimeter of conductor (mm)	Insulation Diameter (mm)			
				CHFUS		HFSS	
				STD.	Max.	STD.	Max.
0.22	7/ circular compression	0.2199	0.55	0.95	1.05	-	-
0.35	7/ circular compression	0.3436	0.7	1.1	1.2	-	-
0.35f	19/0.155	0.3585	0.8	-	-	1.3	1.4
0.5	7/ circular compression	0.4948	0.85	1.25	1.4	-	-
0.5f	19/0.185	0.5107	0.95	-	-	1.5	1.7