



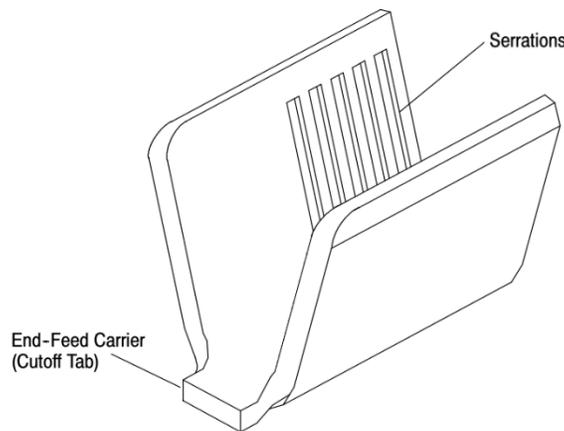
**NOTE**

All numerical values are in metric units [with U.S. customary units in brackets]. Dimensions are in millimeters [and inches]. Unless otherwise specified, dimensions have a tolerance of  $\pm 0.13$  [ $\pm .005$ ] and angles have a tolerance of  $\pm 2^\circ$ . Figures and illustrations are for identification only and are not drawn to scale.

**1. INTRODUCTION**

This specification covers the requirements for application of fine magnet wire open barrel pigtail splices. These splices will accept copper or aluminum magnet wire sizes from 0.14mm (AWG 35) to 0.32mm (AWG 28) in combinations within the range of 400 to 1500 circular mill area (CMA) along with stranded lead wires. All are designed to be crimped with precision dies and various power assist units.

When corresponding with TE Connectivity Personnel, use the terminology provided on this specification to help facilitate your inquiry for information. Basic terms and features of connectors are provided in Figure 1.



**Figure 1**

**2. REFERENCE MATERIAL**

**2.1. Revision Summary**

This paragraph is reserved for a revision summary of the most recent additions and changes made to this specification which include the following:

Revision	Description of Change
B	Initial Release of application specification
C	Extending the application to copper magnet wires

**2.2. Customer Assistance**

Reference Product Base Part Number 2825180 and Product Code 1040 are representative of fine magnet wire open barrel pigtail splices. Use of these numbers will identify the product line and help you to obtain product and tooling information when visiting [www.te.com](http://www.te.com) or calling the number at the bottom of page 1.

**2.3. Drawings**

Customer drawings for product part numbers are available from [www.te.com](http://www.te.com). Information contained in the customer drawing takes priority.

## 2.4. Specifications

Product Specification 108-64051 provides product performance and test results.

## 2.5. Instructional Material

Instruction sheets (408-series) provide product assembly instructions or tooling setup and operation procedures and customer manuals (409-series) provide machine setup and operating procedures. Instructional material that pertain to this product are:

<u>Document Number</u>	<u>Document Title</u>
408--4357	AMP--O--LECTRIC* Model "G" Splice Terminating Machine 356462--[ ]
408--7424	Checking Terminal Crimp Height or Gaging Die Closure
408--8014	Standard--Type End--Feed Applicators
408--8024	Miniature Quick--Change Applicators (End--Feed Type)
408--8039	Heavy Duty Miniature Quick--Change Applicators (End--Feed Type)
408--8053	Miniature (Mini) Quick--Change Applicators
408--8059	General Preventative Maintenance for Applicators
408--9816	Handling of Reeled Products
409--5128	AMP--O--LECTRIC Model "K" Terminating Machines 1--471273--3 and 565435--5
409--5841	AMPLIVAR Product Terminators (115 or 230V AC Operation)
409--5842	AMP--O--LECTRIC Model "G" Terminating Machine 354500--1
409--5876	AMPLIVAR Direct Connect Product Terminator (120 or 240 AC Operation)

## 3. REQUIREMENTS

### 3.1. Safety

Do not stack product shipping containers so high that the containers buckle or deform.

### 3.2. Storage

#### A. Ultraviolet Light

Prolonged exposure to ultraviolet light may deteriorate the chemical composition used in the product material.

#### B. Shelf Life

The product should remain in the shipping containers until ready for use to prevent deformation to components. The product should be used on a first in, first out basis to avoid storage contamination that could adversely affect performance.

#### C. Reeled Splices

Care must be taken to prevent twisting, bending, or other distortion that would prevent smooth feeding of the reeled product through automatic machine feed mechanisms. Store coil wound reels horizontally and traverse wound reels vertically. Review reel tag data to determine if breaks in the strip are present within the reel.

#### D. Chemical Exposure

Do not store product near any chemical listed below as they may cause stress corrosion cracking in the material.

Alkalies	Ammonia	Citrates	Phosphates	Citrates	Sulfur Compounds
Amines	Carbonates	Nitrites	Sulfur	Nitrites	Tartrates

**NOTE**

Where the above environmental conditions exist, phosphor-bronze splices are recommended instead of brass if available.



**3.3. Wire Size and Preparation**

Fine magnet wire open barrel pigtail splices accept magnet wire (3 magnet wires max) in combination with stranded copper wire of various sizes. Stranded wire strip length, as shown in Figure 2, shall be 1.14--2.16 [.045--.085] longer than the splice or as needed to ensure that all conductors are laced completely through the splice without any insulation extending into the crimp area. Magnet wire leads do not require pre-stripping of the insulation film.

**CAUTION**



Reasonable care must be taken not to nick, scrape, or cut any strands during the stripping operation. All magnet wires must lay side-by-side in the bottom of the splice. Other wire, splice, and crimp parameters must be considered as specified in the General Application Guidelines listed in TE product catalog 82221, Magnet Wire Terminals and Termination Systems.

**NOTE**

Do not twist multiple wires together prior to crimping.

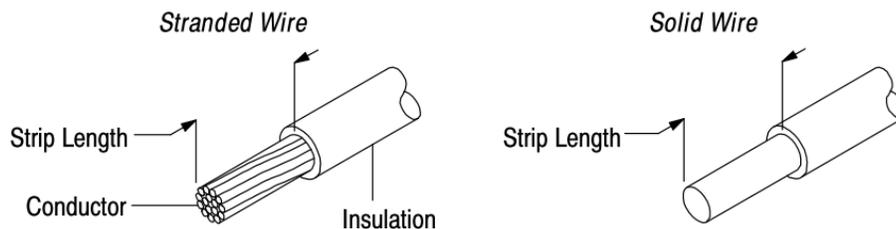


Figure 2

**3.4. Crimped Splice Requirements**

Figure 3 illustrates the crimp features required as they apply to typical pigtail and thru type splices after termination.

**A. Crimp Width and Crimp Height**

Optimum electrical and mechanical performance is achieved by reducing the cross-sectional area of the wires and splice by a pre-determined percentage. Crimp width is fixed in the application tooling. Crimp height must be set and maintained as determined from the crimp height formula provided on the splice Customer Drawing. See Figure 3.

**B. Crimp Length**

For optimum crimp length effectiveness, the crimp must be within the area shown and must meet the crimp dimensions provided in Figure 3. Effective crimp length shall be defined as that portion of the splice, excluding tapers, fully formed by the crimping tool. Instructions for adjusting, repairing, and inspecting tools are packaged with the tools. See Sections 2.4, Instructional Material and Section 5, TOOLING.

### C. Crimp Tapers

Top and bottom crimp tapers shall conform to the dimensions given in Figure 3. Crimp tapers contribute to crimp effectiveness and reduce the risk of nicked and/or broken conductor strands due to sharp material edges at the ends of the splice.

### D. Cutoff Tabs

Cutoff tabs shall not exceed the dimension shown in View A, Figure 3.

### E. Cutoff Burrs

Cutoff Burrs shall not exceed the dimension shown in View A, Figure 3.

### F. Wire Barrel Flash

Wire barrel flash, which can be caused by incorrect set-up and/or worn and broken crimp tooling, shall not exceed the dimension shown in Section X-X, Figure 3.

### G. Conductor Extension

Conductors must extend completely through the splice. Excess magnet wire and lead wire strands will be trimmed off by the application equipment as shown in Figure 3.

### H. Splice Seam

The splice seam must be closed with no evidence of loose wire strands visible in the seam as shown in Figure 3.

### I. Tensile Strength

Crimp quality shall be judged solely on proper crimp width, crimp height, and conformance to the requirements shown in Figure 3.

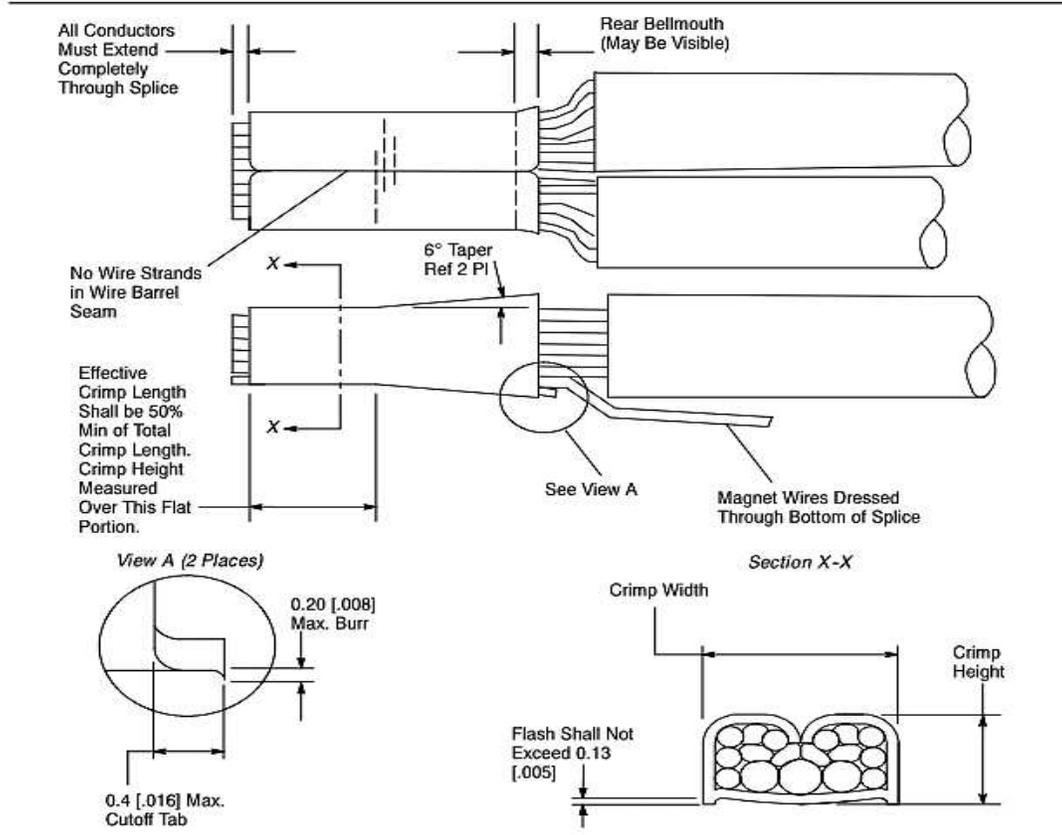


Figure 3

**NOTE**

When crimped as specified, crimp tensile strength will be approximately 70% of the tensile strength of the smallest wire in the splice.

### 3.5. Splice Repair

If a splice is not crimped correctly or it has been damaged, it cannot be repaired or reterminated. It must be cut from the wires and replaced with a new splice.

## 4. QUALIFICATION

Due to numerous wire sizes and combinations, Underwriters Laboratories Inc. (UL) and CSA International will not grant blanket approval for splice part numbers. Customers must submit their end product to these agencies for application evaluation.

## 5. TOOLING

This section provides a selection of tools for various application requirements. They include semi-automatic and automatic machines for power-assisted application of strip form contacts. Modified designs and additional tooling concepts may be available to meet other application requirements. See Figure 4.

**NOTE**

*TE Tool Engineers have designed machines for a variety of application requirements. For assistance in setting up prototype and production line equipment, contact TE Tool Engineering through your local TE Representative or call the Tooling Assistance Center number at the bottom of page 1.*

- **Applicator**

Applicators are designed for the full wire size range of strip-fed, precision formed contacts, and provide for high volume, heavy duty, production requirements. The applicators can be used in bench or floor model power units.

**NOTE**

*Each applicator is shipped with a metal identification tag attached. DO NOT remove this tag or disregard the information on it. Also, a packet of associated paperwork is included in each applicator shipment. This information should be read before using the applicator; then it should be stored in a clean, dry area near the applicator for future reference. Some changes may have to be made to the applicators to run in all related power units. Contact the Tooling Assistance Center number at the bottom of page 1 for specific changes.*

- **Power Units**

A power unit is an automatic or semi-automatic device used to assist in the application of a product. Power unit includes the power source used to supply the force or power to an applicator.

**NOTE**

*The Model "K" AMP-O-ELECTRIC Terminating Machine PN 565435-5 has been superseded by the Model "G" Terminating Machine PN 354500-1 (409-5842) for new applications. For existing applications, the Model "K" is still supported because of the large number of installed machines.*

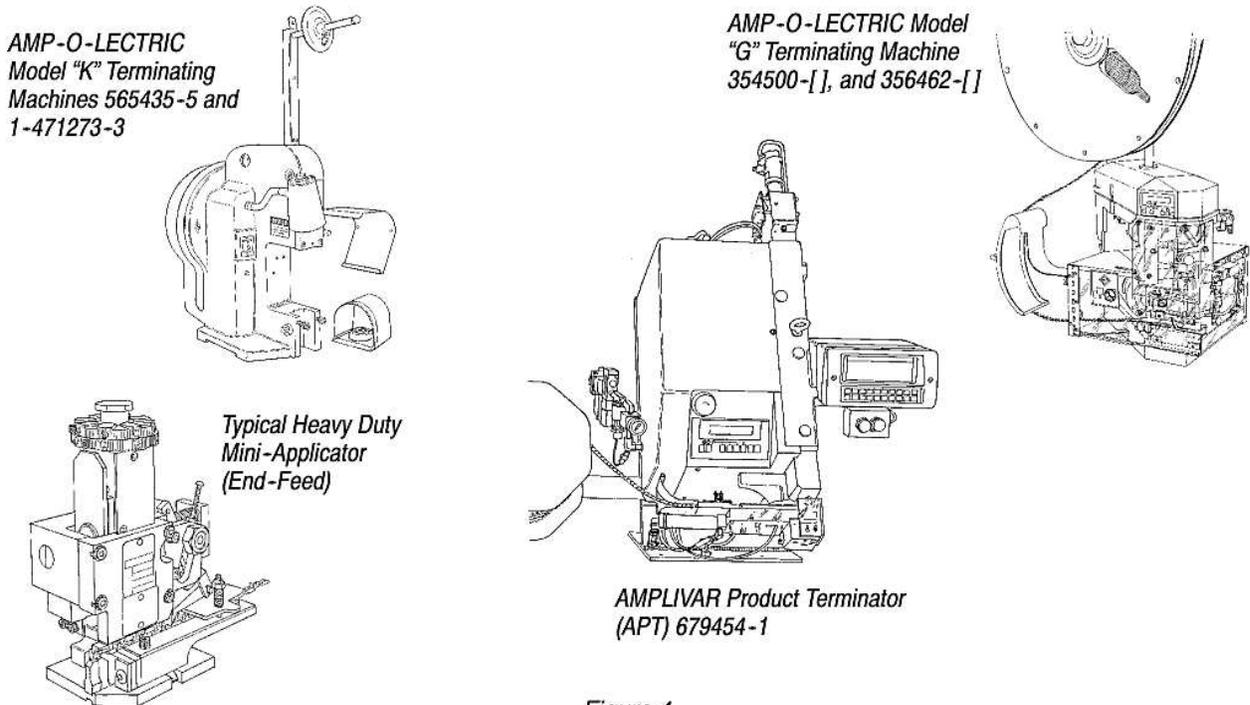


Figure 4

## 6. VISUAL AID

The illustration below shows a typical application of this product. This illustration should be used by production personnel to ensure a correctly applied product. Applications which do not appear correct should be inspected using the information in the preceding pages of this specification and in the instructional material shipped with the product or tooling.

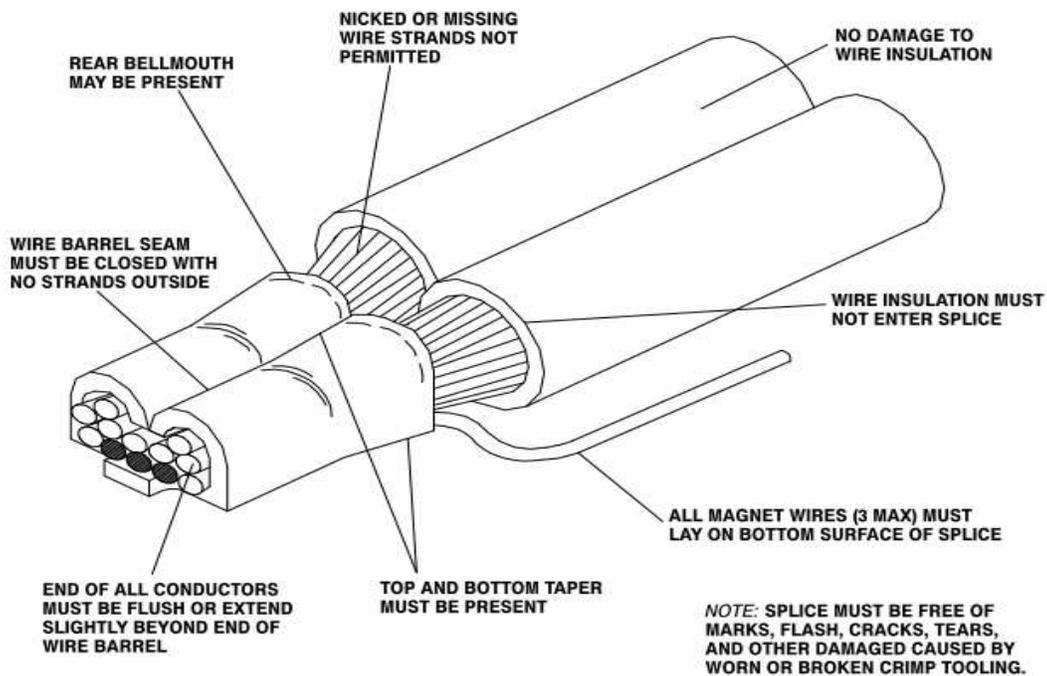


Figure 5. VISUAL AID

