



## HQ4/2 Insert

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## 1. INTRODUCTION

This specification contains the regulations for assembly of HQ4/2 contact inserts and the handling of these inserts.

## 2. SUPPORTING DOCUMENTS

### 2.1. Customer drawings

Please refer to the customer drawings of HQ4/2 insert.

### 2.2. Product specification

The product specifications of the used articles are to be taken into account. The product specification describes the technical data as e.g. regulations, approvals, temperature range and rated voltage.

For further reference refer Product spec. 108-137117.

### 2.3. Application Specification

Connectors shall be assembled as below mentioned application specifications to ensure correct connector assembly.

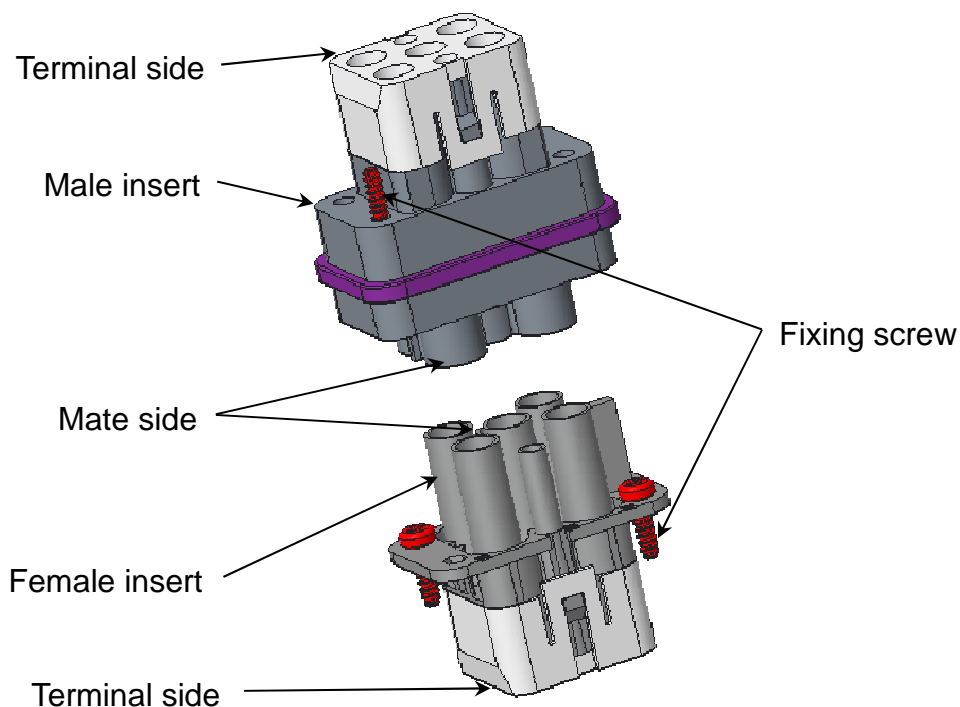
### 2.4. Standards

- EN 61984: Connectors - Safety requirements and tests
- IEC 60664-1: Insulation coordination for equipment within low-voltage systems (Part 1)
- IEC 60999-1: Electrical copper conductors- Safety requirements for the clamping units for conductors

## 3. DESCRIPTION

This application specification describes the male insert and the female insert of the “HQ4/2” series.

The listed terms are used in the specification as shown HQ4/2 as example in figure 1.



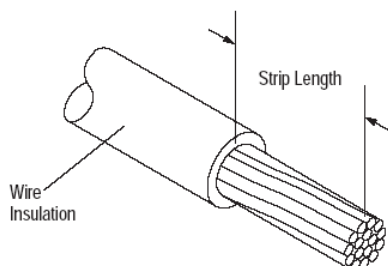
**Figure: 1**

## 4. REQUIREMENTS

### 4.1. Wire selection and preparation

#### 4.1.1. Stripping length L

Use proper tooling to strip the wire.



**Figure: 2**

**NOTE**



When stripping the wire, care must be taken to avoid scraping, nicking, or cutting the conductor. Care must also be used when handling the wire during stripping to prevent cracking or breaking the conductor and insulation.

Depending upon the cross section of the wire or cable, the stripping length has to be selected from the table below. See Table 1.

**Table: 1**

Contact Insert	Max. Wire cross section		Strip Length For Reference	Current /Voltage Rating
	[mm <sup>2</sup> ]	AWG	L [mm]	
HQ4/2-M/F Power	≤6.0 mm <sup>2</sup>	10	8	40A / 690V
HQ4/2-M/F Ground	≤6.0 mm <sup>2</sup>	10	8	40A / 400V
HQ4/2-M/F Signal	≤2.5 mm <sup>2</sup>	14	8	10A / 250V

## 4.1.2. Insulation diameter

Any wire that is used for the Electrical purpose is covered with insulating polymer. This insulation on the wires depends upon the wire size and type of application where it is being used. The insulation diameter for various wire sizes is as shown in table 2 only for reference.

**Table: 2**

Contact Insert	Max. Wire cross section		Insulation Diameter in (mm)
	[mm <sup>2</sup> ]	AWG	
HQ4/2-M/F Power	≤6.0 mm <sup>2</sup>	10	5.4 MAX.
HQ4/2-M/F Ground	≤6.0 mm <sup>2</sup>	10	5.4 MAX.
HQ4/2-M/F Signal	≤2.5 mm <sup>2</sup>	14	3.4 MAX.

**NOTE**



The Insulation diameter over the wire specified in the table 2 is for the insulation concentric, with equal thickness layer over the conducting wire.



# Application Specification

**114-137117**  
Oct 10<sup>th</sup>, 2020 Rev. A3

## 4.1.3. Applicable contacts

Please refer Table 3.

**Table: 3**

Series Items	mm <sup>2</sup> (AWG)	Applicable Contact		Crimp Requirements
		PIN CONTACT	SOCKET CONTACT	
		Part Number	Part Number	
HQ4/2-M/F POWER CONTACT (4 POS)	1.0 (18)	T2040001010-000	T2040002010-000	SEE 4.2.1
	1.5 (16)	T2040001015-000	T2040002015-000	
	2.5 (14)	T2040001025-000	T2040002025-000	
	4.0 (12)	T2040001040-000	T2040002040-000	
	6.0 (10)	T2040001060-000	T2040002060-000	
HQ4/2-M/F GROUND CONTACT (PE)	1.0 (18)	T2042001010-000	T2040002010-000	SEE 4.2.1
	1.5 (16)	T2042001015-000	T2040002015-000	
	2.5 (14)	T2042001025-000	T2040002025-000	
	4.0 (12)	T2042001040-000	T2040002040-000	
	6.0 (10)	T2042001060-000	T2040002060-000	
HQ4/2-M/F SIGNAL CONTACT (2 POS)	0.14-0.37 (26-22)	T2020001002-000	T2020002002-000	SEE 4.2.1
	0.5 (20)	T2020001005-000	T2020002005-000	
	0.75 (18)	T2020001008-000	T2020002008-000	
	1.0 (18)	T2020001010-000	T2020002010-000	
	1.5 (16)	T2020001015-000	T2020002015-000	
	2.5 (14)	T2020001025-000	T2020002025-000	
	0.14-0.37 (26-22)	T2020011002-000	T2020012002-000	
	0.5 (20)	T2020011005-000	T2020012005-000	
	0.75 (18)	T2020011008-000	T2020012008-000	
	1.0 (18)	T2020011010-000	T2020012010-000	
	1.5 (16)	T2020011015-000	T2020012015-000	
	2.5 (14)	T2020011025-000	T2020012025-000	

## 4.2. Assemble wires to inserts

### 4.2.1. Inserts of crimp termination

#### a. Assemble stripped wires to contacts (Crimp)

##### ➤ Crimping tool

Crimping tool is available as below figure 3 & figure 4:



- ♦ Wire range: 26AWG ~ 12AWG ( 0.14 mm<sup>2</sup> ~ 4.0 mm<sup>2</sup> )
- ♦ Type: RPC-M23-T-B
- ♦ Order number: T3100000022-000

**Figure: 3**



- ♦ Wire range: 4.0/6.0/10.0 mm<sup>2</sup>
- ♦ Type: CRIMPBOX-4.0/10.0 (For MM contact, 4.0/6.0/10.0 mm<sup>2</sup>)
- ♦ Order number: T3100001001-000

**Figure: 4**

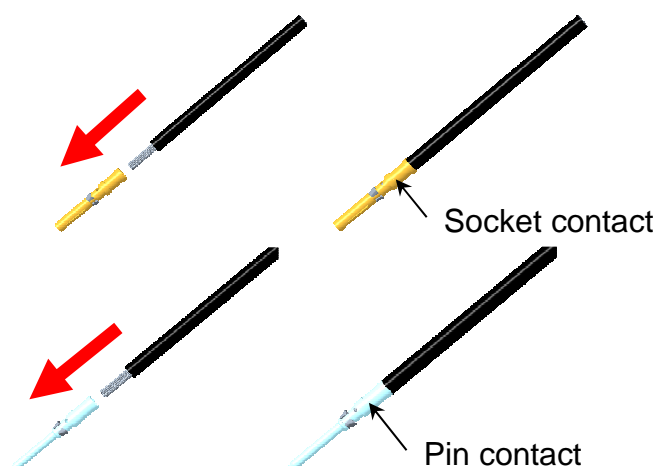
## ➤ Crimp

Insert the cable - stripped according to table 1 - into the wire barrel of the contact. The wire strands must be visible in the reference hole of the contact. Afterwards, crimp the contact in the crimp area, using the correct tool for this type of contact. During the termination process make sure that the contact in the contact zone is not damaged or deformed.

When using manual crimp tools the following points must be followed:

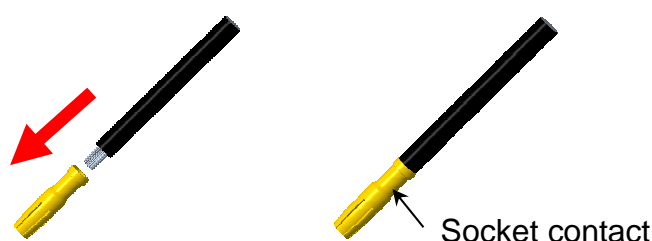
- 1). Equip manual crimp tool with the correct locator or positioning ferrule.
- 2). When using different manual crimping tools the pliers have to be adjusted by plug gauge to fit the crimp area.
- 3). Fully insert contacts into the locator.
- 4). Clamp the wire with help of crimp tool. Note that to press the crimp tool till the stopper is reached a positive crimp.

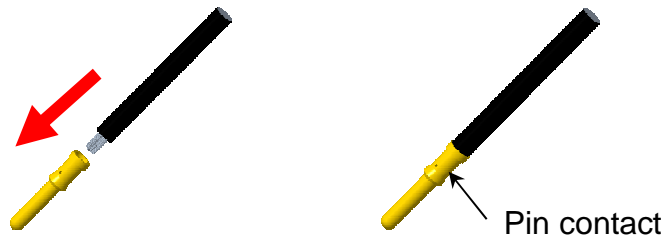
Signal contact (DD contact as below)



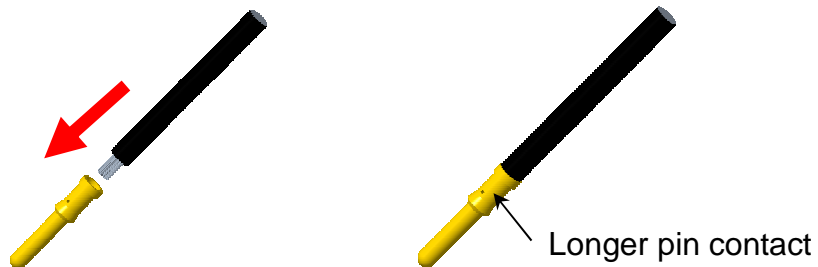
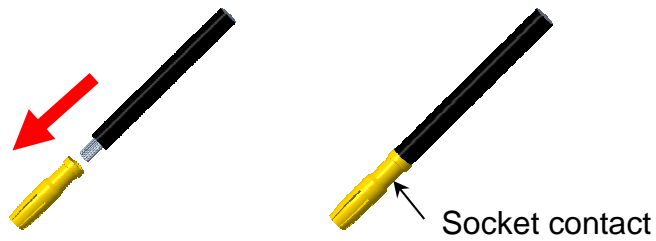
**Figure: 5**

Power contact (Standard MM pin contact & socket contact as below)





GROUND PE contact ( Longer MM pin contact & standard socket contact as below)



**Figure: 6**

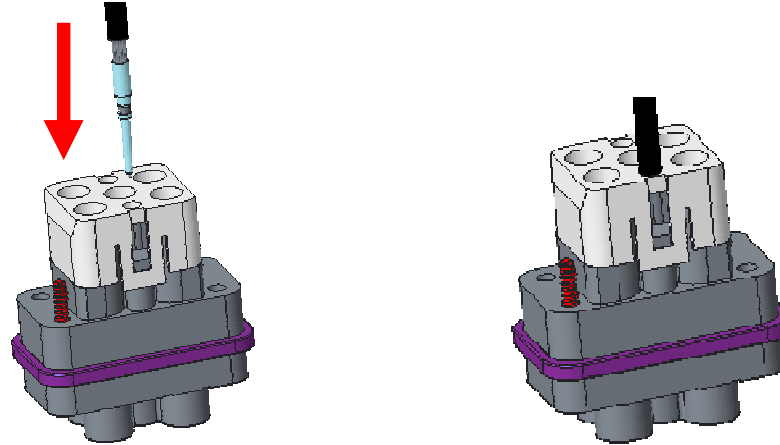
**NOTE** For more detailed information, please refer to related contacts application specifications.





b. Insert crimped terminals into inserts

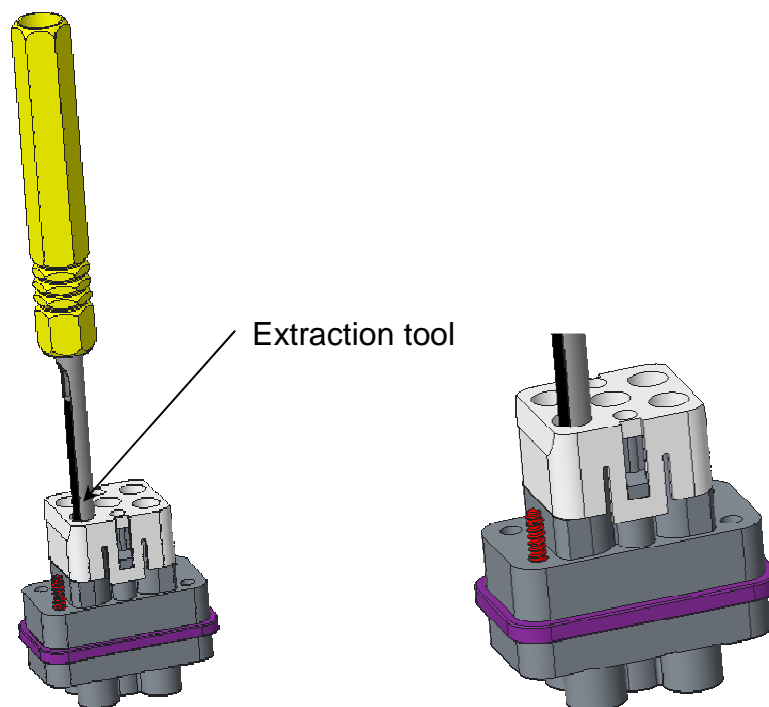
The crimped terminals are plugged into the insert by gently pushing it into the required position until the contact is locked by the inserts, a click should be heard normally.



**Figure: 7**

c. Repeat till wires are fully assembled.

Tooling for power contacts and grounding contacts removal



**Figure: 8**

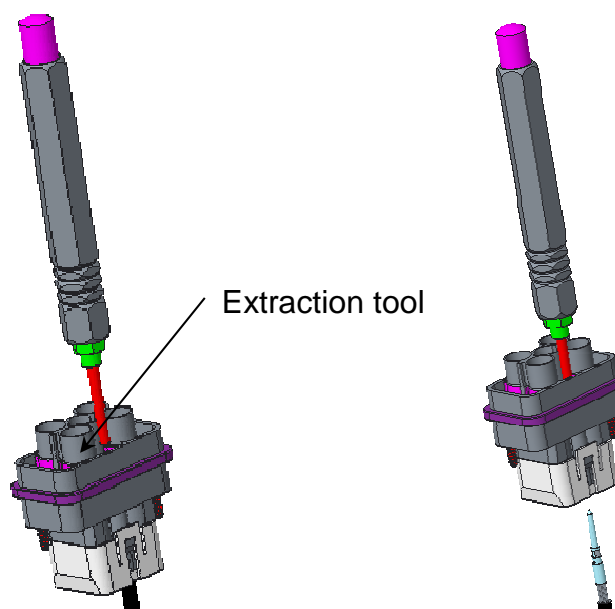
- 1). Insert the extraction tool along the crimped contact into the special space on the cover
- 2). Insert the tool till it touch the contact end face.
- 3). Now, pull out crimped contact holding cable and also the tool together to unplug the contact.



**Figure: 9**

- ♦ Type: REMOV-MM
- ♦ Order number: T3100000013-000

## Tooling for signal contacts removal



**Figure: 10**

- 1) Using the extraction tool push the head position of crimped contact,
- 2) Push the tool till the contact is pushed out.

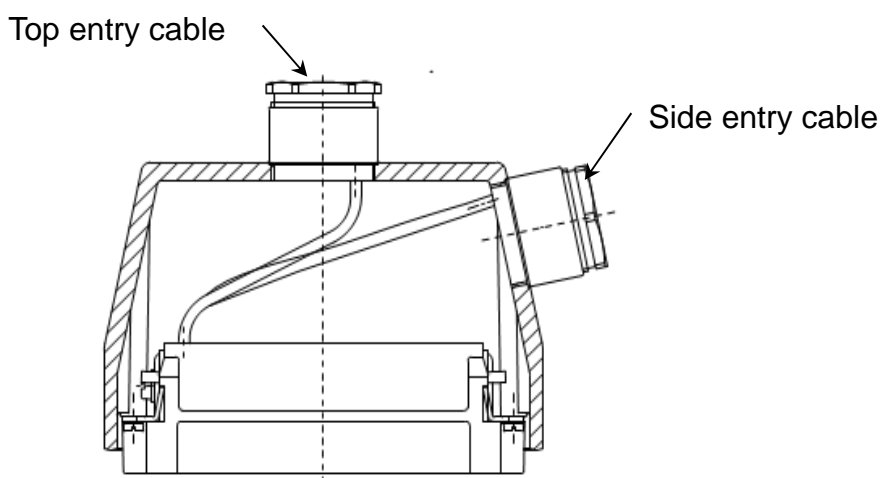


**Figure: 11**

- ♦ Type: REMOV-HD
- ♦ Order number: T3100000003-000

## 4.3. Cable length inside the housing

For the optimal cable lay inside the housing it is necessary to make sure that the striped length is fit to used cable type; is fit to permitted bending radius of the cable and make sure that the contact insert is fit to the type of hood. For recommended cable lengths (cable entry: TOP, SIDE), please refer to the table 4. In accordance with the application it is proposed the cable length is selective to shorten (e.g., shorter cable near the cable gland longer cable at the turned off side).



**Figure: 12**

**Table: 4**

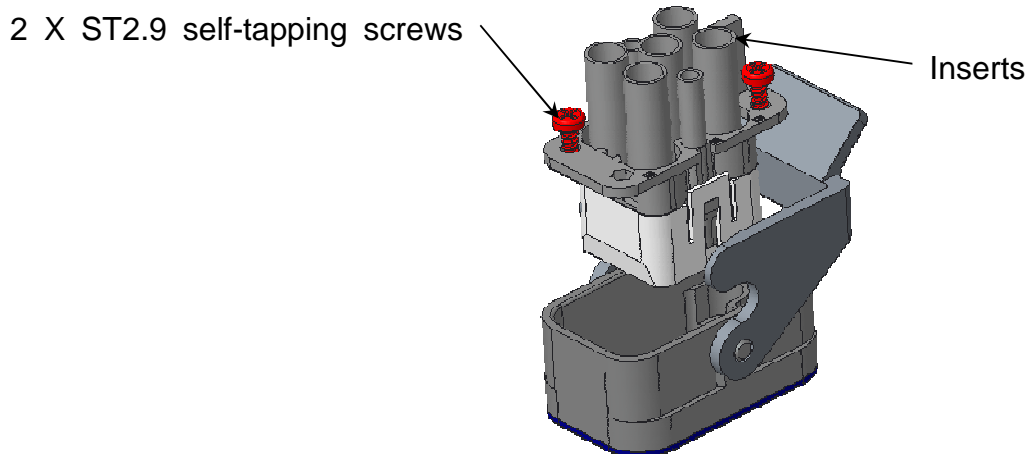
Insert size	Hood Size	Type of hood	Cable length (mm)		Note
			Top entry cable	Side entry cable	
HQ4/2	H8A	H8A	30	30	For reference only

## 5. ASSEMBLY

Assembling the contact inserts for both Male & Female connector has to be carried out with proper tools.

### 5.1. Contact inserts

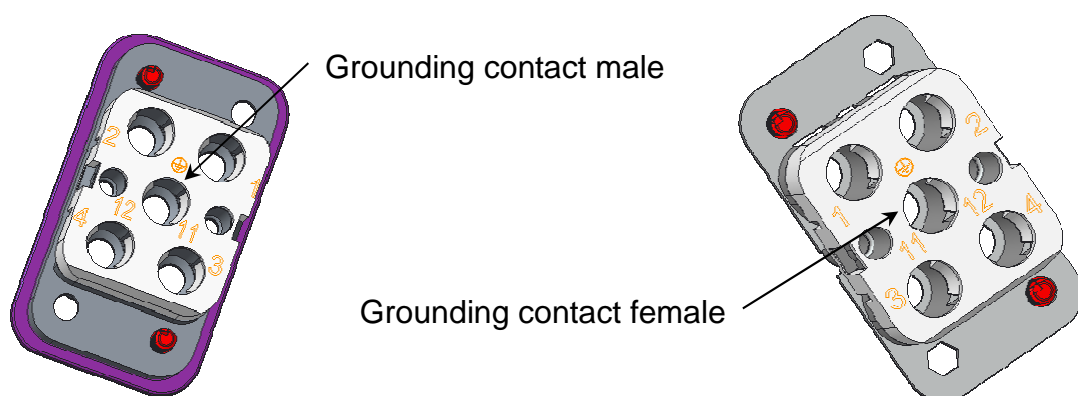
The inserts are fixed into the hood/housing with 2 x ST2.9 self-tapping screws. And these S T2.9 self-tapping screws are components on inserts. Tightening torque refer to spec of insert drawing. For example as shown in Figure 13.



**Figure: 13**

## 5.2. Grounding

Grounding contacts are assembled into contact inserts. The cable can be locked on the earth potential with crimp terminal method. The grounding contact in an assembly is the only part that will be having press contact with corresponding grounding contact on the other assembly near the interfacing portion of the housings. As shown in figure 14.



**Figure: 14**

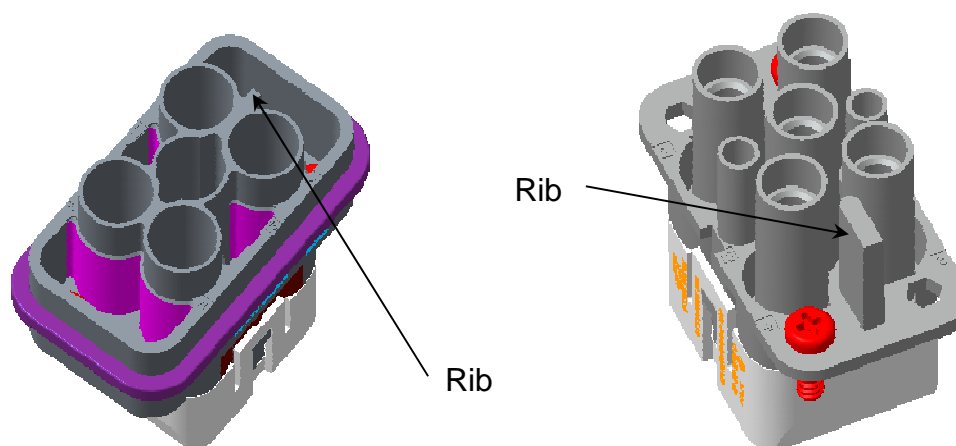
This grounding contact is suitable for connection of a cable with a nominal cross section of up to 6 mm<sup>2</sup>. Assembly process may refer to 4.2.1. Earthing is to be executed according to IEC 61984.

## 5.3. Marking

The connector type, rating and the number of position etc. refer to the corresponding HQ4/2 insert customer drawings.

## 5.4. Polarization function

The process of assembling the male and female inserts without any mismatch and difficulty calls for polarization. This is done with the help of ribs and which are present on both the male insert as well as the female insert. As shown in figure 15.



**Figure: 15**

## 6. STORAGE

### 6.1. Chemical exposure

Do not store the connectors near any chemical listed below as they may cause corrosion stress the connector contacts:

Alkalies, Ammonia, Citrates, Phosphates, Citrates, Sulfur, Amines, Carbonates, Nitrites, Sulfides, Nitrites, Tart rates.

### 6.2. Storage condition

The connectors should be stored in the air ventilation, no corrosive gas, no rain and no snow in the warehouse. Relative humidity: less than 85% RH. The connectors should remain in the shipping containers until ready for use to prevent deformation to the contacts. The connectors should be used on a first in, first out basis to avoid storage contamination that could adversely affect electrical functions.

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