

1. SCOPE

This document provides the instructions for the termination of IDC plugs, 90° wire exit, HE13- HE14 series, meeting the requirements of international standard IEC 603-8.

2. TERMINATION

2.1. The connectors above are to be terminated to discrete wires type KY 30 (7 strands-PVC jacket) per French standard NF C 93-521 or ribbon cable with a 2.54 mm of the same characteristics.

Every family of connectors is dedicated to a single wire gauge (see list on the last page of this document).

The accepted range varies from 0.08 mm² -AWG 28 (KY 30-02) to 0.22 mm² - AWG24 (KY 30-04).

Other usages are not recommended and should be evaluated on a case by case basis.

2.2. Application tooling

The termination can be accomplished by hand-tools or more productive application tooling. It can be done conductor by conductor or simultaneously.

3. TERMINOLOGY

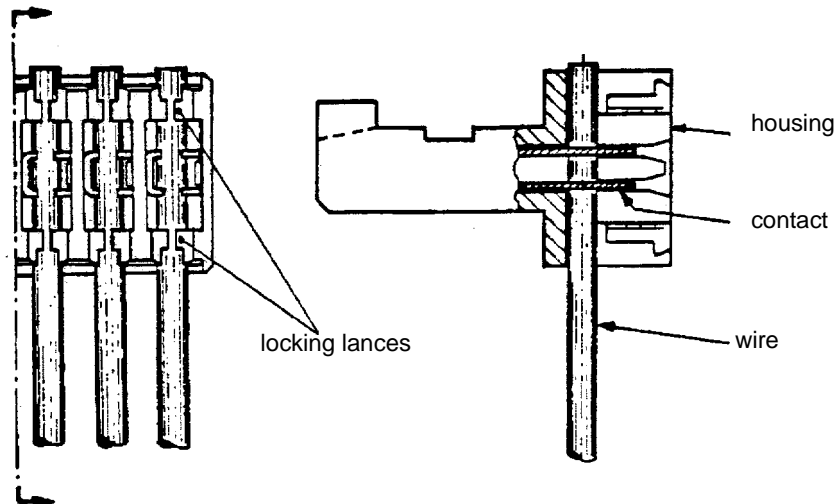


Figure 1

4. WIRING TYPES

The connectors can be placed at the end of the lead or in a daisy chain configuration (see figure 2) .

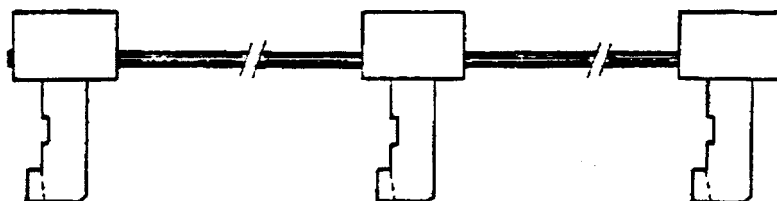


Figure 2

Care should be taken not to stress the connector when the wires are cut.

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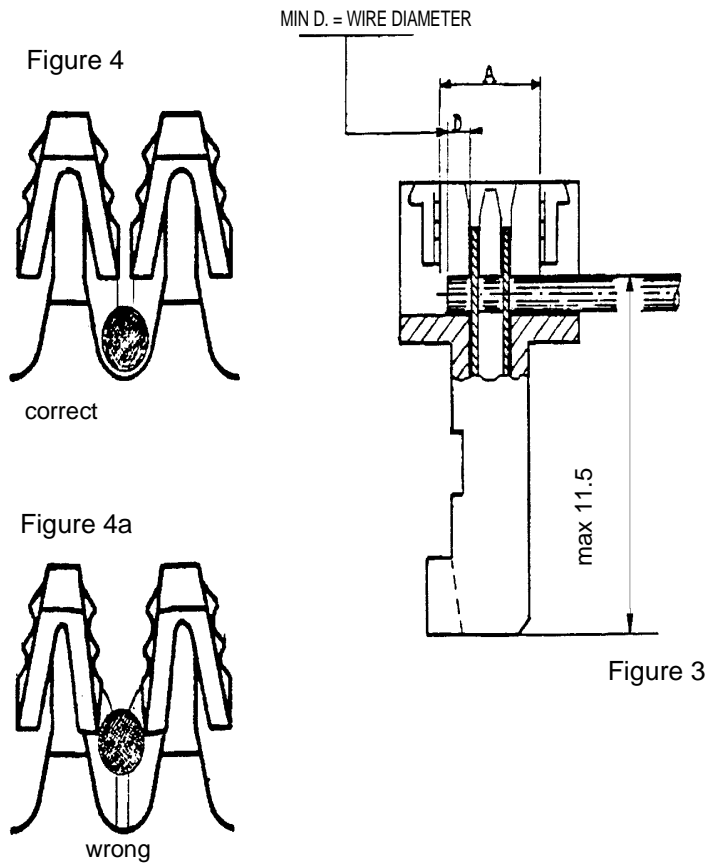
5. INSPECTION

5.1. wire

No strand should be cut after termination. The dimensions of figure 3 must be met.

The wire should be located in a way that allow the housing lances to go back to their initial position (figure 4 and 4a).

If the insulating is stripped, only the area A is to be affected.



5.2. Contacts

No visible deformation should affect the contacts after termination.

5.3. Housing

The housing should not be damaged or craked after termination.

The lances should approximately have returned to their initial position.

Connector part number	Marking code	AWG gage	Conductor section	Max insulation diameter (mm)	Max insulation diameter (inch)	Wires Designation
x-281 714-x	8	28	0.08 mm ²	0.86	0.34	KY 30-02
x-281 715-x	8	28	0.08 mm ²	0.86	0.34	KY 30-02
x-281 711-x	6	26	0.12 mm ²	1.0	0.39	KY 30-03
x-281 712-x	6	26	0.12 mm ²	1.0	0.39	KY 30-03
x-281 708-x	4	24	0.22 mm ²	1.2	0.47	KY 30-04
x-281 709-x	4	24	0.22 mm ²	1.2	0.47	KY 30-04

Table of part numbers