Socket Contact for Φ1mm pin (SQUIB Connector)

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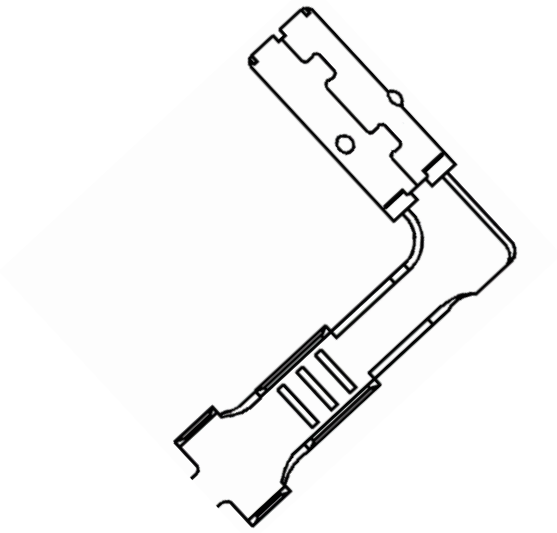


B	Revised of description sentence	H.I	H.H	17.3.2022
A	Revised FJ00-128297	T.H	K.Y	28.8.1998
LTR	**REVISION RECORD**	**DWN**	**APP**	**DATE**

1. Scope

This specification covers the requirements for crimping Socket Contact for Φ1mm Pin.

2. Applicable Contacts

The contacts of the following part numbers shall be governed under this specification.

Contact Feature	Part number *1)	Wire Size mm² (AWG)	Remarks
Socket forΦ1mm Pin	353376	0.3～0.5 (AWG #22～#20)	

*1) The part number consists of the base number in the list and a single digit number with a dash. Refer to the customer drawing or catalog for details of the dash type number for each base number.
If the prefix number is zero, zeros and dashes are omitted.

3. Product Description

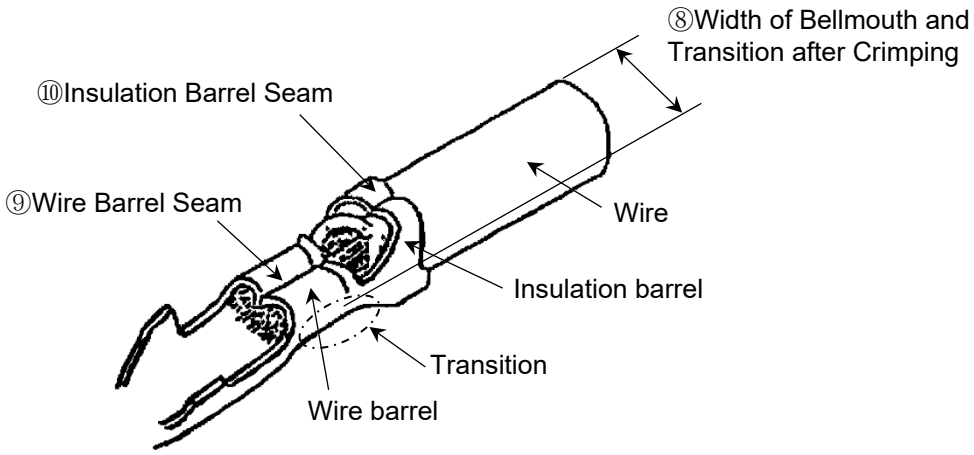


Fig.1

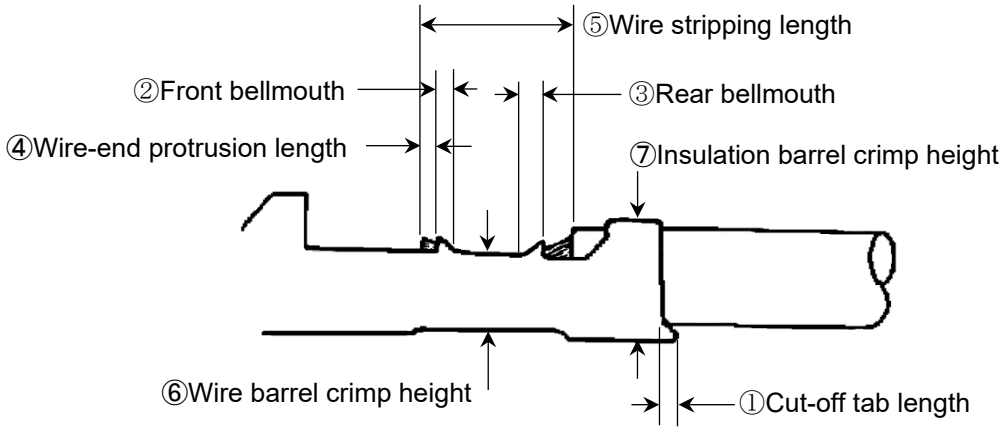


Fig.2

4. Crimping Conditions

No.	Checking Items \ Part number		Crimping Condition 353376	Remarks
1	Allowable Deviation after Crimping	Bend-up	3° Max.	See Fig.3 ⑪
		Bend-down	3° Max.	See Fig.3 ⑫
		Twisting	3° Max.	See Fig.3 ⑭
		Rolling	10° Max.	See Fig.3 ⑮
2	Cut-Off Tab length		0～0.5mm	See Fig.2 ①
3	Bellmouth	Front	0.35mm Max.	See Fig.2 ②
		Rear	0.6mm Max.	See Fig.2 ③
4	Width of Bellmouth and Transition after Crimping		2.15mm Max.	See Fig.1 ⑧
5	Wire-end Protrusion Length		Wire-end should protrude beyond the front edge of wire barrel. However, it should not exceed 1mm.	See Fig.2 ④
6	Wire Stripping Length	One-wire Crimp	4.0～4.5mm	See Fig.2 ⑤
7	Wire Barrel Seam		Wire barrel seam should appear neat and closed without mis-gripped strands sticking out between the barrel.	See Fig.1 ⑨
8	Insulation Barrel		The insulation barrel seam should be closed and the insulation flanks piercing into the insulation. One or both of the insulation flanks piercing into the wire strands is acceptable as long as there is no damage or deformation to the individual strands.”	See Fig.1 ⑩

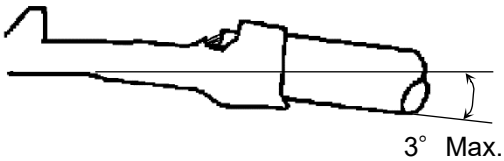
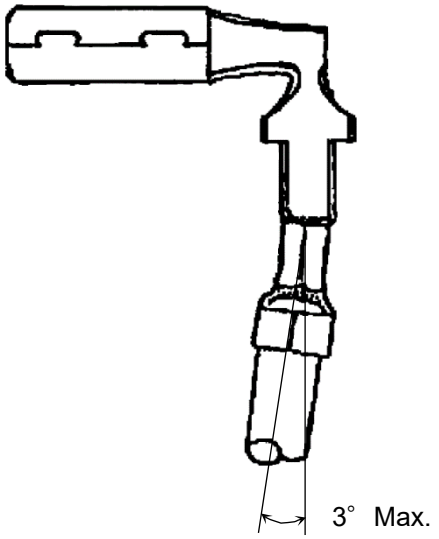
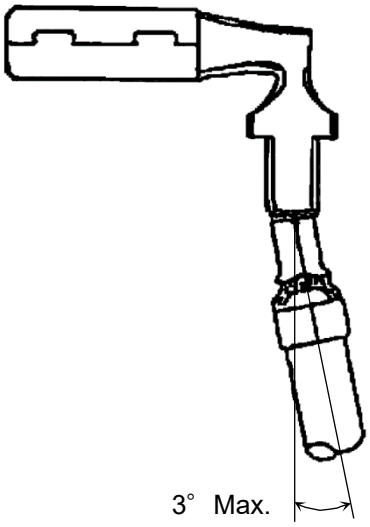
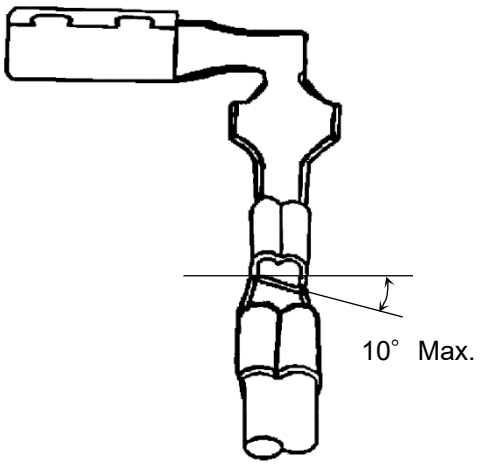
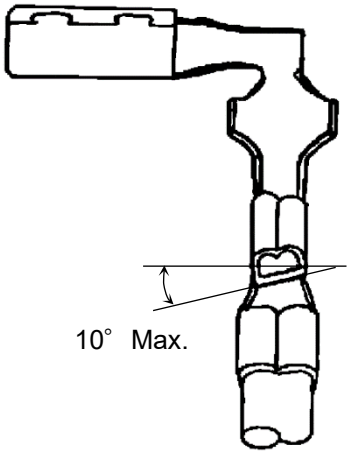
⑪Bend Up  	⑫Bend-Down 
⑭Twisting  	⑭Twisting 
⑮Rolling  	⑮Rolling 

Fig.3

5. Crimp Data

Application Crimp:

Contact Part Number (Strip Form)	Applicator Number	Wire Size mm^2 (AWG)	Wire Barrel Crimp			Insulation Barrel Crimp			Crimp Tensile Strength (N)
			Width (mm)	Height (mm)	Disc. Ltr.	Width (mm)	Height (mm)	Disc. Ltr.	
353376	409644-2 or 2151198-1	0.3 (#22)	1.78 ”F”	0.94	C or 7.2	1.78 ”F”	2.29	3 / -	59 Min.
		0.5 (#20)		1.03	B or 8.2		2.37	3 / -	88 Min.

Note:

(1) Tolerance of wire barrel crimp height should be within ±0.05

(2) Tolerance of insulation barrel crimp height should be within ±0.1

(3) Crimp tensile strength include the strength of insulation support.

(4) The width of wire barrel and insulation barrel should not be the actual width but the width of wire and insulation crimper slot.

(5) See “6. Applicable Wire Data” about applicable wire.

(6) Control the width of wire and insulation barrel within 2mm after crimp.

6. Applicable Wires

Nominal Wire Size	Number of Conductors / Diameter of Conductor (mm)	Calculated Cross-sectional Area (mm^2)	Overall Outside Diameter AVSS/CAVS *2)	
			Standard	Maximum
0.3	7 / 0.26	0.37	1.4	1.5
0.5	7 / 0.32	0.56	1.6	1.7

*2) Refer to see JASO D625-3