

SOCKET CONTACT FOR AK-II SQUIB CONNECTOR

1. Scope:

1.1 Contents

This specification covers the requirements for crimping Socket Contact for Squib Connector AK-II.

본 시방서는 스퀴브 커넥터의 단자 크림프를 위해 요구되는 것이다.

2. Application Contacts:

Contact Features	Contact P/N	L/P P/N	Wire Sizes (mm ²)	Remarks
Socket Contact	2005939-3	2005939-1 / 2005939-2	0.3(0.35) / 0.5	

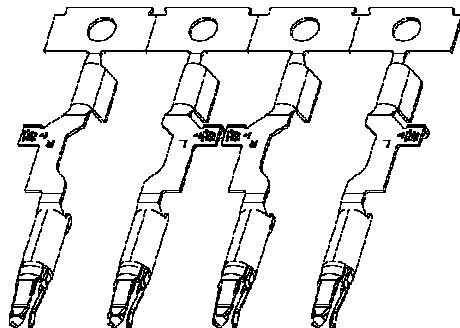
3. Terminal Bend Resistance

*** Caution:** Do not bend with all directional contact except bending process.

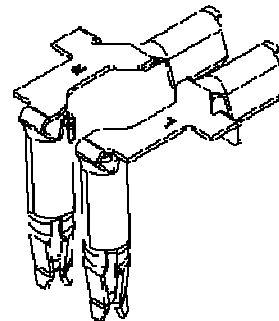
주의: 굽힘 공정을 제외하고 모든 방향으로 단자를 굽히지 말 것.

Note: The terminals require additional bending after stamping

이 단자들은 스탬핑 이후 추가 굽힘이 요구된다.



Delivery Condition



90°Bending Condition

4. Nomenclature and Crimping Features:

Fig. 1

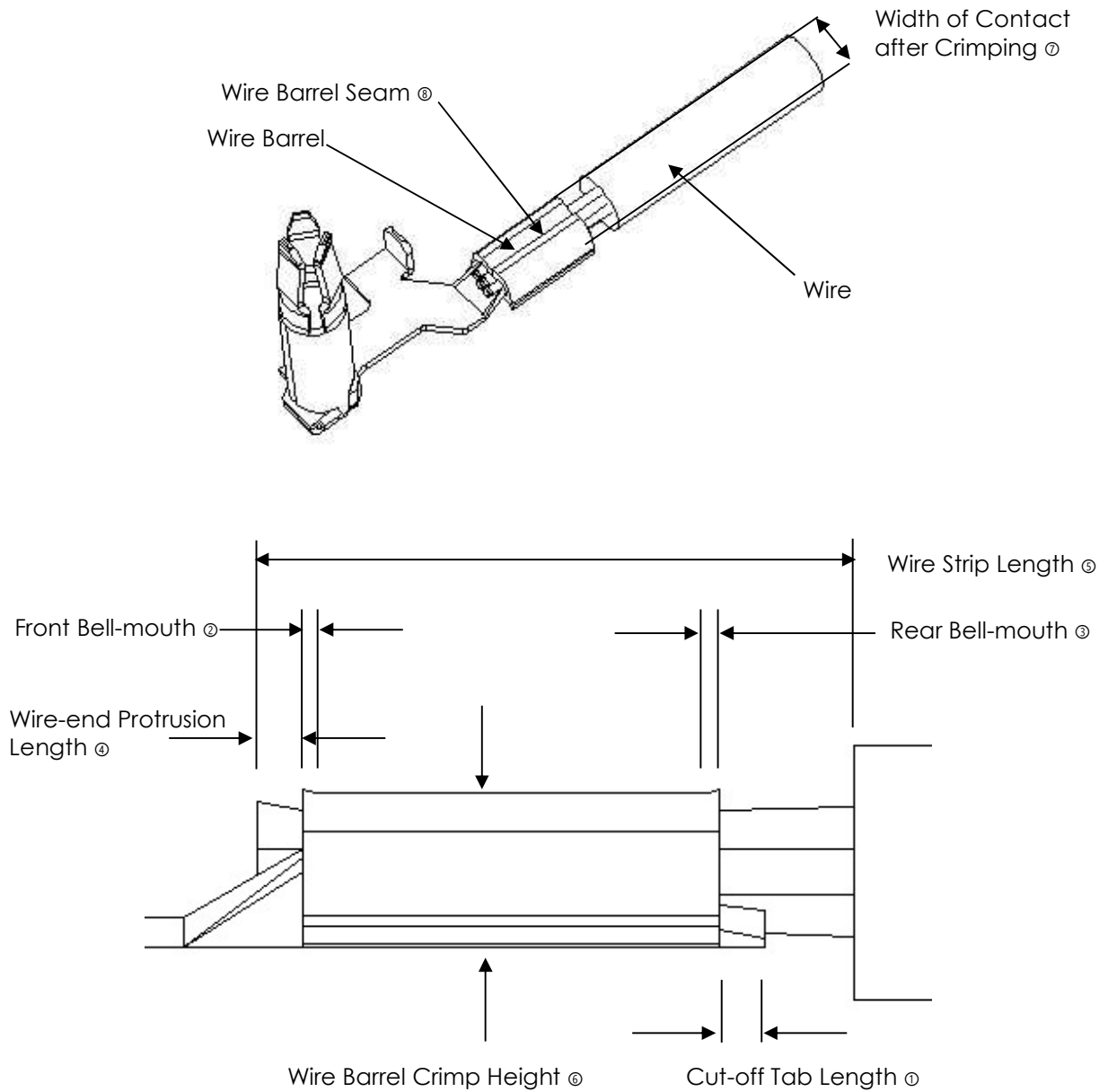
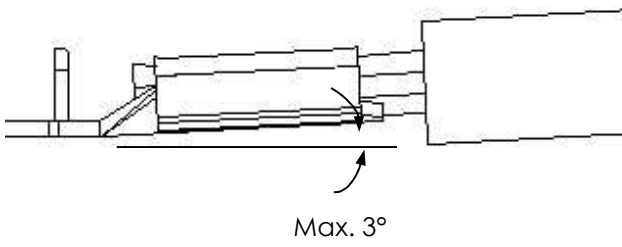
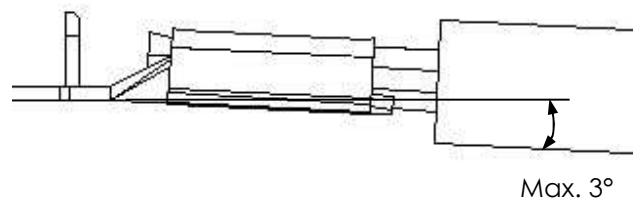


Fig. 2

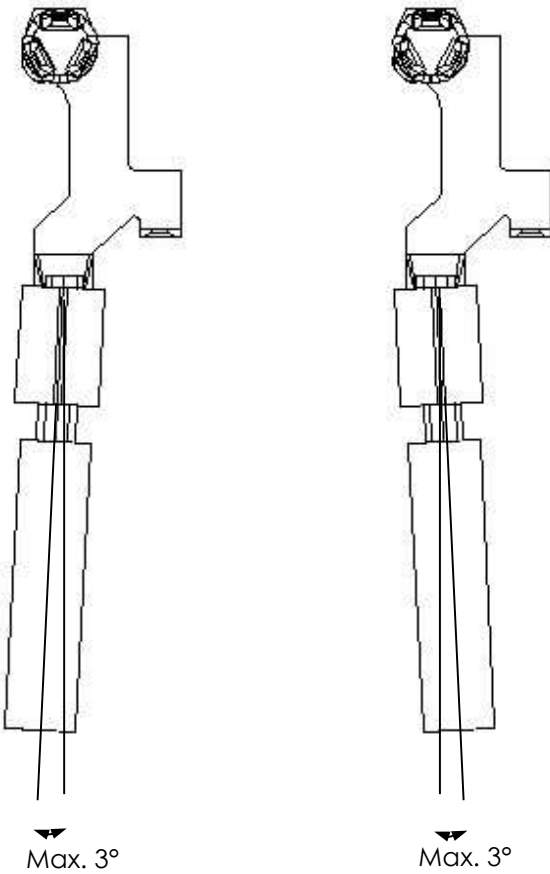
① Bend-up



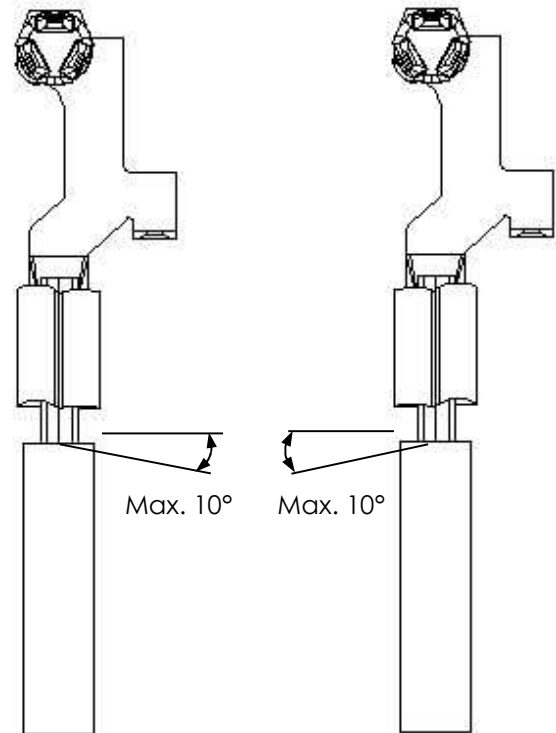
② Bend-down



③ Twisting



④ Rolling





5. Crimping Conditions and Crimp Data:

5.1 Crimping Conditions:

No.	Checking Items		Requirements	Remarks
1	Allowable Deviation after Crimping	Bend-up	3 ° Max.	Fig. 2 ①
		Bend-down	3 ° Max.	Fig. 2 ②
		Twisting	3 ° Max.	Fig. 2 ③
		Rolling	10 ° Max.	Fig. 2 ④
2	Cut-off Tab Length		0.5 mm Max.	Fig. 1 ①
3	Bell-mouth	Front	0.35 mm Max.	Fig. 1 ②
		Rear	0.1 ~ 0.6 mm	Fig. 1 ③
4	Width of Contact after Crimping		1.5 mm Max.	Fig. 1 ⑦
5	Wire-end Protrusion Length		Wire-end must protrude beyond the front edge of wire barrel, but shall not exceed 0.5 mm.	Fig. 1 ④
6	Insulation Stripping Length	One-Wire Crimp	3.0 ~ 4.0 mm	Fig. 1 ⑤
7	Wire Barrel Seam		Seam of wire barrel must appear neat and closed without mis-gripped strands sticking out between the barrel	Fig. 1 ⑧



6. Crimp Data:

Application Crimp:

Contact P/N	Wire Size (mm ²)	Wire Barrel Crimp		Applicator supplier
		Width (mm)	Crimp Height (mm)	
2005939-3	0.3 / 0.35	1.4 "F"	0.80 (±0.03)	A&P Machinery (Korea)
	0.5	1.4 "F"	0.90 (±0.05)	
	0.5	1.4 "F"	0.85 (±0.03)	Shanghai Bosile Precision Machinery

Note: (1) The width of wire barrel is not the actual width, but the width of wire crimper slot.

(2) See "7. Applicable Wire Data" about applicable wire.

(3) Control the width of wire barrel within 1.5mm after crimp.

(1) 와이어 바렐의 폭은 실제 폭이 아니고, 와이어 압착기의 폭을 나타낸다.

(2) 적용 와이어는 "7. Applicable Wire Data"를 참조하라.

(3) 압착 이후에 1.5mm 이내에서 와이어 바렐의 폭을 관리하라.

*** Caution: Do not bundles and wrap up contact after crimp over 100pieces.**

주의: 압착 이후에 100 개 이상 단자를 다발로 만들거나 감싸지 말 것.

7. Applicable Wire Data:

Nominal Size	Number of Strands / Diameter of Strand (mm)	Calculated Cross Section Area (mm ²)	Overall Outside Diameter	
			Standard	Maximum
FLRY-A 0.35SQ	7 / 0.26	0.3717	1.2	1.3
FLRY-B 0.35SQ	12 / 0.21	0.4156	1.2	1.4
AVSS 0.5SQ	7 / 0.32	0.5630	1.6	1.7
AVSSXF 0.5SQ	19 / 0.19	0.5387	1.6	1.7
FLRY-B 0.5SQ	16 / 0.21	0.5542	1.4	1.6

Note: Overall outside diameter is permissible 1.8mm Max.

전체 외경은 최대 1.8mm 까지 허용한다.



8. Revision History

D	REVISED (Add new crimping spec for Shanghai Bosile Crimper/Anvil)	11.OCT.'18
C	REVISED (Crimp Height)	07.JAN.'14
B	REVISED (Applicable wire added): FLRY-A/B 0.35SQ	20.OCT.'10
A2	REVISED (Applicable wire added): FLRY-B 0.5SQ	23.JUL.'10
A1	REVISED (Applicable wire added): AVSSXF 0.5SQ	12.FEB.'10
A	RELEASED	25.NOV.'08
REV.	REVISION RECORD	DATE