



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 ± 0.13 [± 0.005] 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 TE Connectivity Type II Screw Machine Pin and Socket Contacts. These requirements are applicable to hand or automatic machine crimping tools. For specific wire and insulation ranges relative to the products covered in this specification, see Figures 2 and 3.

When corresponding with TE Personnel, use the terminology provided in this specification to facilitate your inquiries for information. Basic terms and features of this product are provided in Figure 1.

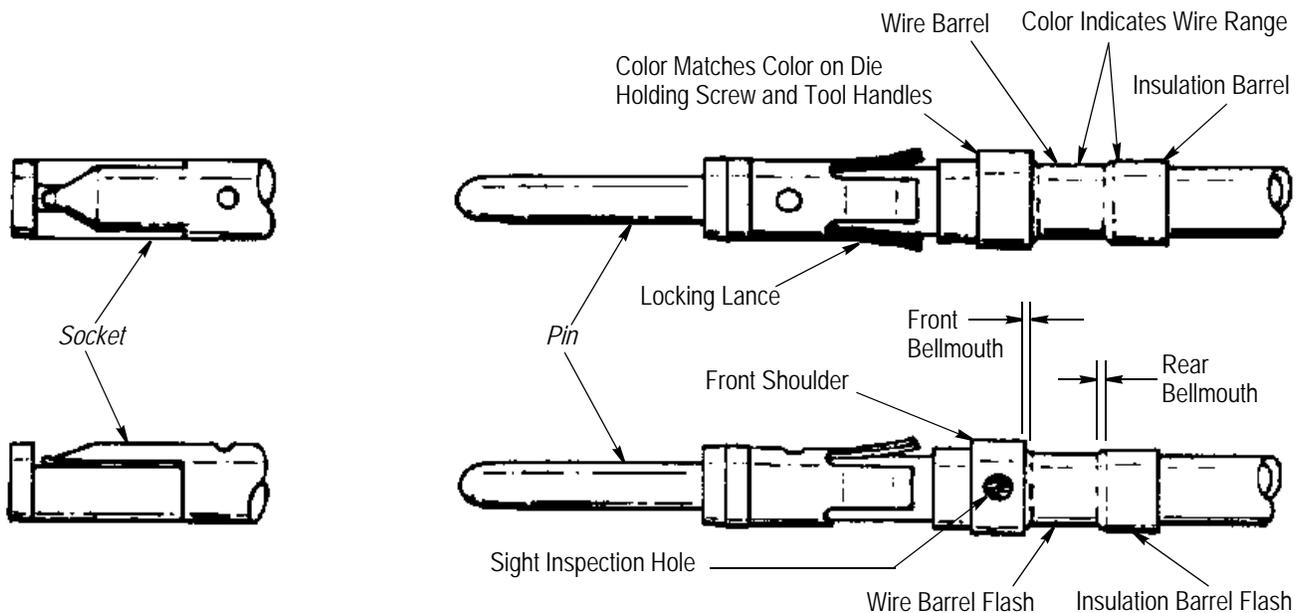


Figure 1

2. REFERENCE MATERIAL

2.1. Revision Summary

- Updated document to corporate requirements
- Corrected information to table in Figure 2

2.2. Customer Assistance

Reference Product Part Numbers 201625 and 201627 and Product Code 5021 are representative of Type II Pin and Socket Contacts. Use of these numbers will identify the product line and expedite your inquiries through a service network established to help you obtain product and tooling information. Such information can be obtained through a local TE Representative or, after purchase, by calling PRODUCT INFORMATION at the number at the bottom of this page.

2.3. Drawings

Customer Drawings for product part numbers are available from the service network. If there is a conflict between the information contained in the Customer Drawings and this specification or with any other technical documentation supplied, call PRODUCT INFORMATION at the number at the bottom of this page.

2.4. Specifications

Refer to Product Specification 108-10039 for product performance and test information.

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 contacts.

B. Shelf Life

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

C. Chemical Exposure

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

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

3.3. Wire Preparation

A. Strip Length

Insulation shall be stripped as indicated in Figures 2 and 3.

B. Workmanship

Reasonable care shall be taken not to nick, scrape, or cut any strands or the solid wire during the stripping process.

3.4. Wire Barrel Crimp

A. Crimp Dimensions

Crimp height and width shall be as shown in Figures 2 and 3.

B. Wire Barrel Flash

Wire barrel flash shall not exceed 0.20 mm [.008 in.].

C. Bellmouth

Front and rear bellmouth length shall be 0.64 mm [.025 in.] minimum.

D. Conductor Location

Conductor shall be visible through the sight inspection hole.

E. Workmanship

Front shoulder shall not be deformed during the crimping operation.

3.5. Insulation Barrel Crimp

A. Crimp Dimensions

Crimp width shall be as shown in Figures 2 and 3.

B. Insulation Barrel Flash

Insulation barrel flash shall not exceed 0.25 mm [.010 in.].

C. Workmanship

Reasonable care shall be taken not to cut or break the insulation during the crimping operation.

3.6. Locking Lance

Locking lance shall not be deformed.

3.7. Alignment

The axial concentricity of the crimped product shall fall into an area defined by a 3.40 mm [.134 in.] diameter circle whose center is the centerline of the contact.

HAN D TOOL WIRE CRIMP DIMENSIONS																				
PART NO.		COLOR BAND		WIRE		INSULATION DIAMETER	STRIP LENGTH	WIRE BARREL CRIMP		INSUL BARREL CRIMP WIDTH	HAND TOOL									
PIN	SKT	BARREL	SHOULDER	QTY	SIZE			WIDTH +0.13/-0.03 [+.005/-0.001]	HEIGHT ±0.05 [.002]		PART NO.	HANDLE COLOR								
201625	201627	White		1	32-30	0.76-1.22 [.030-.048]														
201555	201554																			
201607	201609	Red	Red	1	28-24	0.89-1.40 [.035-.055]	5.16 [.203]	1.88 [.074]	1.09 [.043]	2.29 [.090]	45099 or 90118†	Red								
201649	201613																			
201611																				
204189																				
201354	201353																			
201334	201332																			
202189	202190	---	Green‡	1		2.41-2.79 [.095-.110]	5.16 [.203]	1.09 [.043]	1.09 [.043]	2.64 [.104]	90093	Green								
202410	202411																			
201582	201584	Yellow	Red	1	24-20	1.02-1.57 [.040-.062]							5.16 [.203]	1.09 [.043]	1.09 [.043]	2.29 [.090]	45099 or 90118†	Red		
201647	201580																			
201578																				
200334	200331																			
200679	201328																			
201330																				
204188																				
---	201751 130743-1	Green‡	Blue	1	22-18	---	6.35 [.250]	2.51 [.099]	1.60 [.063]	---	91539-1	Blue								
202725	202726	---		2	18															
201591	201589	Blue‡		Blue	1								18-16	---	6.35 [.250]	2.51 [.099]	1.60 [.063]	---	91539-1	Blue
200335	200333																			
200681																				
200336																				
204274																				
204219																				
201645	201568	Violet‡		1	14															
201570																				
206029																				

†Hand tool 90118 does not crimp insulation barrel. ‡No insulation crimp.

Figure 2

AUTOMATIC MACHINE WIRE CIRMP DIMENSIONS												
PART NO.		COLOR BAND		WIRE		INSULATION DIAMETER	STRIP LENGTH	WIRE BARREL CRIMP		INSUL BARREL CRIMP WIDTH	CRIMPING DIE	
PIN	SKT	BARREL	SHOULDER	QTY	SIZE			WIDTH +0.13/-0.03 [+.005/-0.01]	HEIGHT ±0.05 [.002]		ASSY. NO.	SCREW COLOR
201334	201332	Red		1	28-24	1.22-1.65 [.048-.065]	5.16 [.203]	1.88 [.074]	1.09 [.043]	2.54 [.100]	90249-1	Red
201354	201353											
201607	201609											
201611	201613											
201649												
204189												
200334	200331	Yellow	Red	1	24-20	1.40-1.90 [.055-.075]	5.16 [.203]	1.88 [.074]	1.09 [.043]	2.54 [.100]	90249-1	Red
200679	201328											
201330												
204188												
201582												
201578												
201647	201580	1.22-1.57 [.040-.062]										
200335	200333	Blue†		1	18-16	---	6.35 [.250]	2.51 [.099]	1.60 [.063]	---	90250-1	Blue
200336												
200681												
204274												
201591	201589	Blue		2	18	---	6.35 [.250]	2.51 [.099]	1.60 [.063]	---	90250-1	Blue
202725	202726											
201570	201568											
201645		Violet†	1	14								
206029												
204219	---	Blue†		1	18-16						90250-3	

†No insulation crimp.

Figure 3