



**NOTE**

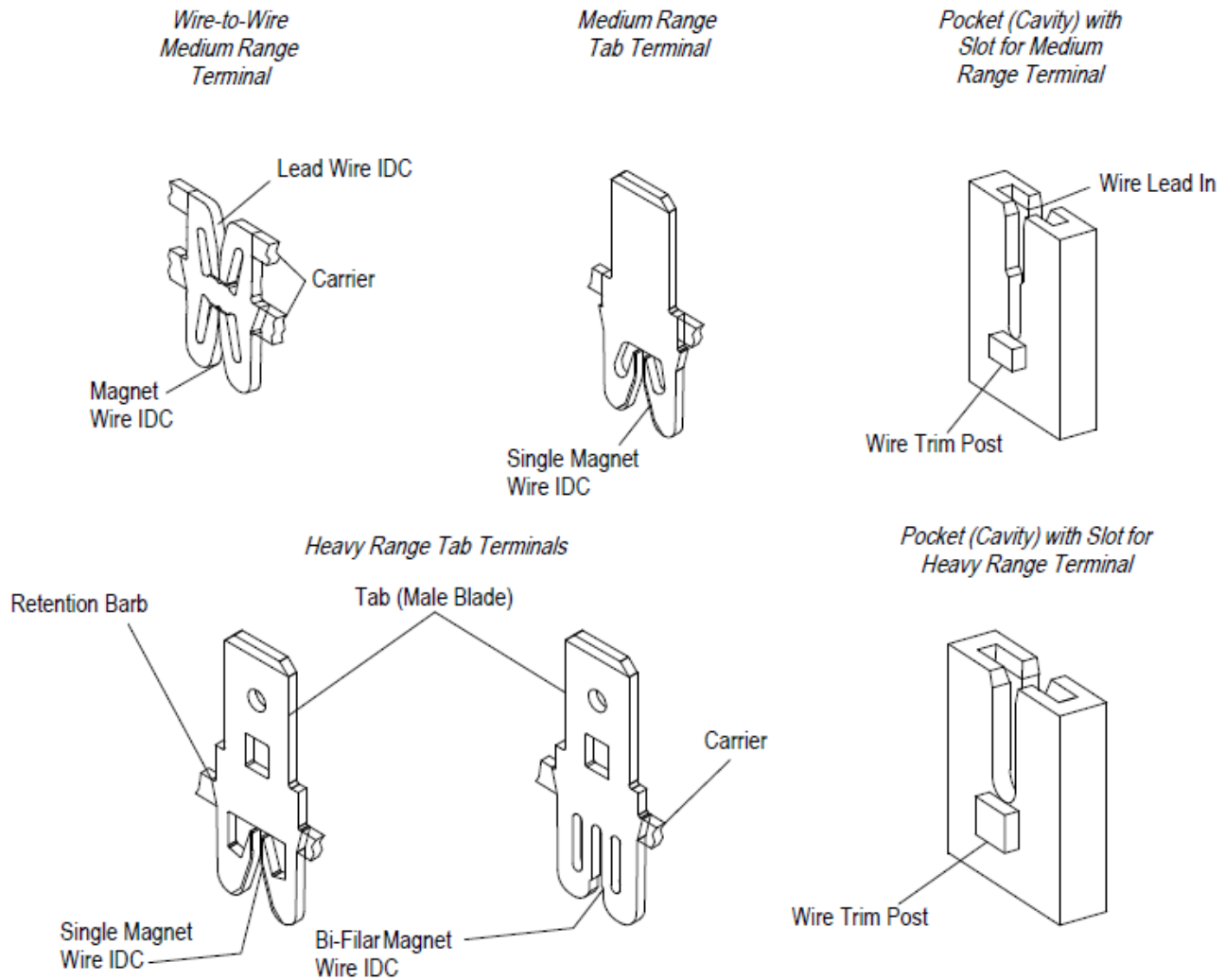
All numerical values are in metric units [with U.S. customary units in brackets]. Dimensions are in millimeters [and inches]. Unless otherwise specified, dimensions have a tolerance of  $\pm 0.13$  [ $\pm .005$ ] and angles have a tolerance of  $\pm 2^\circ$ . Figures and illustrations are for identification only and are not drawn to scale.

**1. INTRODUCTION**

This specification covers the requirements for application of TE Connectivity SIAMEZE\* Medium and Heavy Range Terminals. These terminals have an Insulation Displacement Contact (IDC) moving beam or compliant beam at one end for terminating solid round copper magnet wire in sizes ranging from 0.56 mm diameter [23 AWG] through 2.06 mm [12 AWG]; and from 0.8 mm diameter [20 AWG] through 2.06 mm [12 AWG]. Numerous interface types are available for your production requirements: lead wire, receptacle, pc board posts, 3.3 mm posts and FASTON\* Tabs with 6.35 mm [.250 in.] widths.

TE Engineering can provide assistance in selecting the most compatible wire, terminal, and terminating machines. Requests for assistance should be made as early as possible in the production planning stage.

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

- Added Paragraph 3.2.A and 3.2.B
- Updated document to corporate requirements.

### 2.2. Customer Assistance

Reference Product Base Part Number 1601136 and Product Code H360 are representative of the SIAMEZE Medium and Heavy Range Terminals. Use of these numbers will identify the product line and help you to obtain product and tooling information when visiting [www.te.com](http://www.te.com) or calling the number at the bottom of page 1.

### 2.3. Drawings

Customer drawings for product part numbers are available from [www.te.com](http://www.te.com). Information contained in the customer drawing takes priority.

### 2.4. Specifications

Design Objectives 108-2239 and 108-2316 are available to provide expected product performance and test information for the SIAMEZE Medium and Heavy Range Terminals.

### 2.5. Instructional Material

Instruction sheets (408-series) provide product assembly instructions or tooling setup and operation procedures and customer manuals (409-series) provide machine setup and operating procedures. Instructional material that pertain to this product are:

- [408-3295](#) Preparing Reel of Contacts For Application Tooling
- [408-7162](#) Adjustment and Repair of CERTI-LOK\* Tap Pin Insertion Tool
- [408-8947](#) Entry-Level Magnet-Wire Terminator (EMT) Assembly
- [408-9816](#) Handling of Reeled Products
- [408-5886](#) Modular Insertion System (MIS) Post/Tab Insertion Head
- [409-10035](#) MPT-5 Terminator Machine Assembly for MAG-MATE\*, SIAMEZE, and Lead Lok Terminals

## 3. REQUIREMENTS

### 3.1. Safety

Do not stack product shipping containers so high that the containers buckle or deform.

### 3.2. Storage

#### A. Storage Temperature and Humidity

Products should be stored at room temperature and low ambient humidity. The temperature and humidity should be in the range as per DIN IEC68 (15-35°C, 25-75% relative humidity). Products should not be exposed to extreme temperatures, intense humidity or damaging mediums (acid or base atmospheres, aggressive agents, etc.)

#### B. Durability of Products

These products have a normally unlimited durability, provided they are stored in their original packing and at normal storage temperature and humidity. Exceptions are solderable products, tubes and cables. Solderable products will be solderable only within 6 months after deliver.

#### C. Ultraviolet Light

Prolonged exposure to ultraviolet light may deteriorate the chemical composition used in the product material.

### D. Shelf Life

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

### E. Chemical Exposure

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

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



**NOTE**

Where the above environmental conditions exist, phosphor-bronze contacts are recommended instead of brass if available.

### 3.3. Wire Selection

The IDC connects to one of three copper magnet wire ranges:

Medium Range – a single wire 0.56 mm [23 AWG] through 2.06 mm [12 AWG]

Heavy Range – a single wire 0.80 mm [20 AWG] through 2.06 mm [12 AWG]

Bifilar Range – one or two wires of the same diameter (size as specified on the customer drawing)

The magnet wire size for each terminal and the lead wire size (where applicable) is listed on the customer drawing.

### 3.4. Cavity Design

Performance of the SIAMEZE terminal is dependent on insertion into a housing pocket (cavity) that is designed to TE guidelines. The customer drawing for each terminal indicated the drawing number for the applicable cavity guideline.

Drawings of the final design must be supplied to TE Engineering for review and approval and for compatibility of insertion equipment. The following items pertain to all applicable cavity designs.

- Recommended material is 30% glass filled nylon or TE Engineering approved equivalent.
- Wall thickness on trim side must be equal on multi-cavity housings to provide wire trim by automatic insertion machine.
- Wire trim support must be on the wire trim side only. The MPT will trim off both wire and wire trim support. Wire trim support is not necessary if the magnet wire is hand trimmed. Consult TE Engineering if trimmed wire end must be concealed within the cavity.
- Coil windings and other assembly components must not extend above the base of the wire slot or obstruct proper seating of the magnet wire in the slot.
- Draft angles must be held within the feature tolerances.
- Slot width may be 0.08±0.03 mm [.003±.001 in.] smaller than the largest magnet wire outside diameter dimension being terminated provided it does not obstruct seating of the wire.

### 3.5. Bussed (Commoned) Terminals (Figure 2)

Two High Carry SIAMEZE Terminals (e.g. 1601136) may be commoned together using the upper carrier between them to connect multiple magnet wire together, or a magnet wire to a component wire (e.g. a thermal protector or a diode). This requires the center-to-center distance of the cavities to be the same as the center-to-center distance of the terminals. In addition, the depth of the wire slot in each pocket must be optimized for the specific wire diameter. For components with insulated or stranded wire, consult TE Engineering.

TE supplies the terminals in loose bussed pairs or triples (refer to the specific customer drawing for the terminal dimensions), or the application system can be designed to separate the continuous reeled terminals into the required configuration.

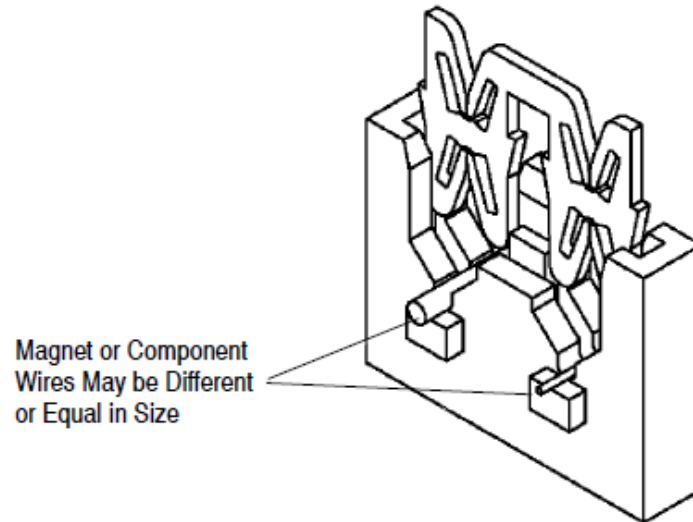


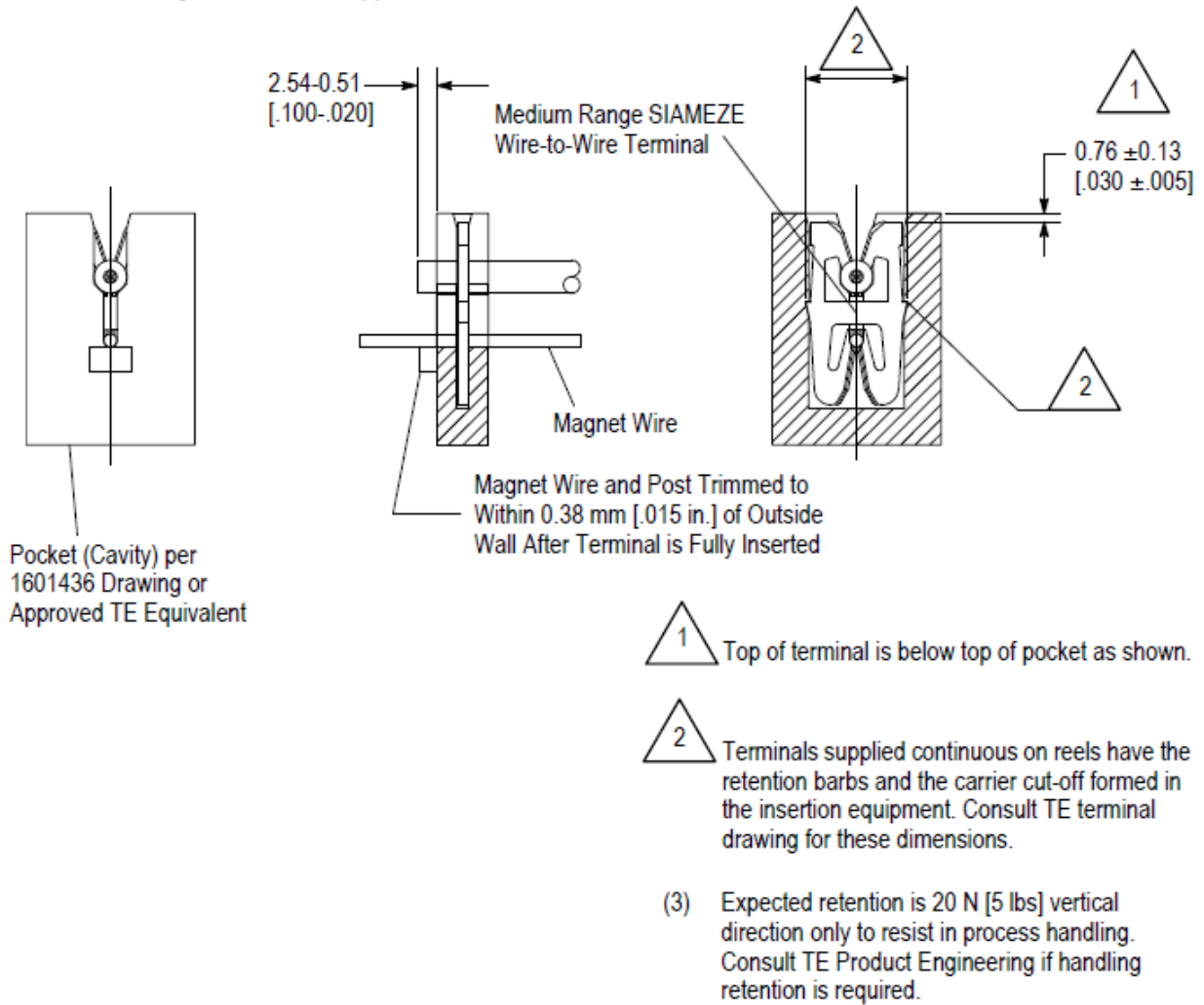
Figure 2

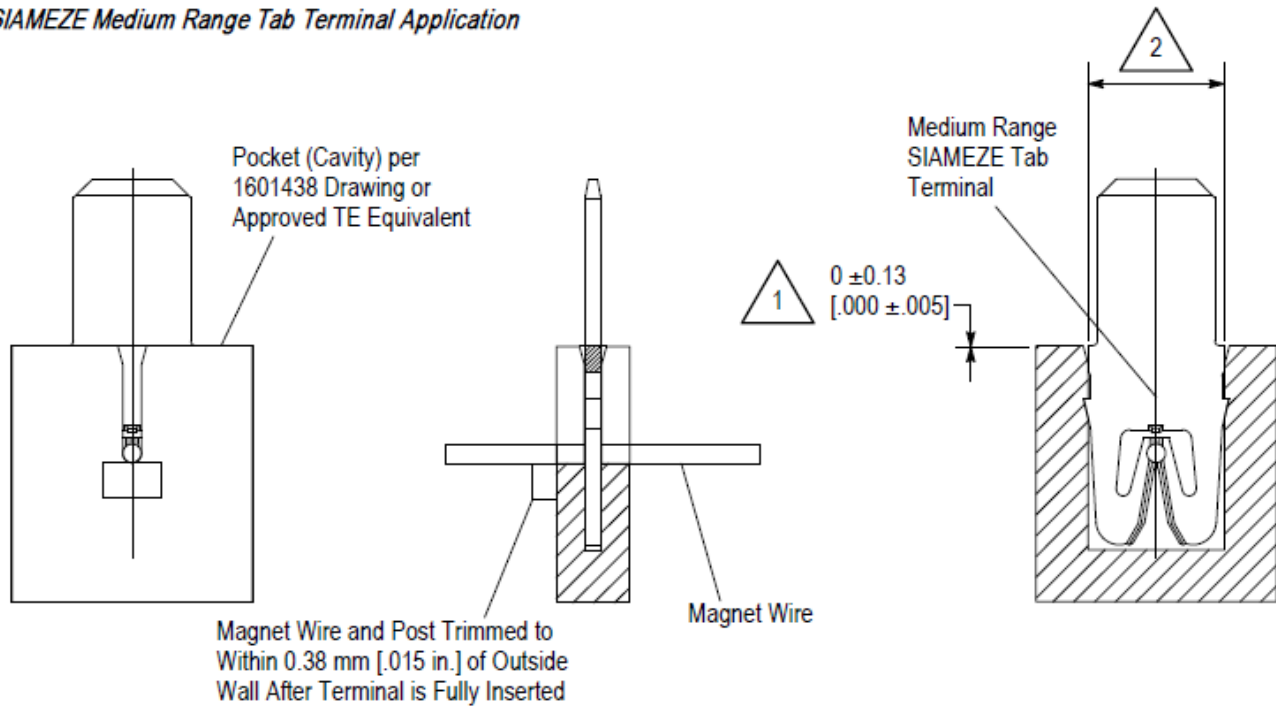
### 3.6. Wire Placement (Pre-Termination)

The magnet wire must be laced into the bottom of the cavity slot prior to terminal insertion. The wire may rebound at the base of the slot, but must remain within the slot. The magnet wire must not rest in the lead-in area of the slot or outside the cavity opening.

### 3.7. Terminal Insertion Depth (Figure 3 through Figure 6)

Refer to TE Customer Drawing for the application reference figure for each terminal. For terminals not shown in that document, contact the Product Information number at the bottom of page 1.

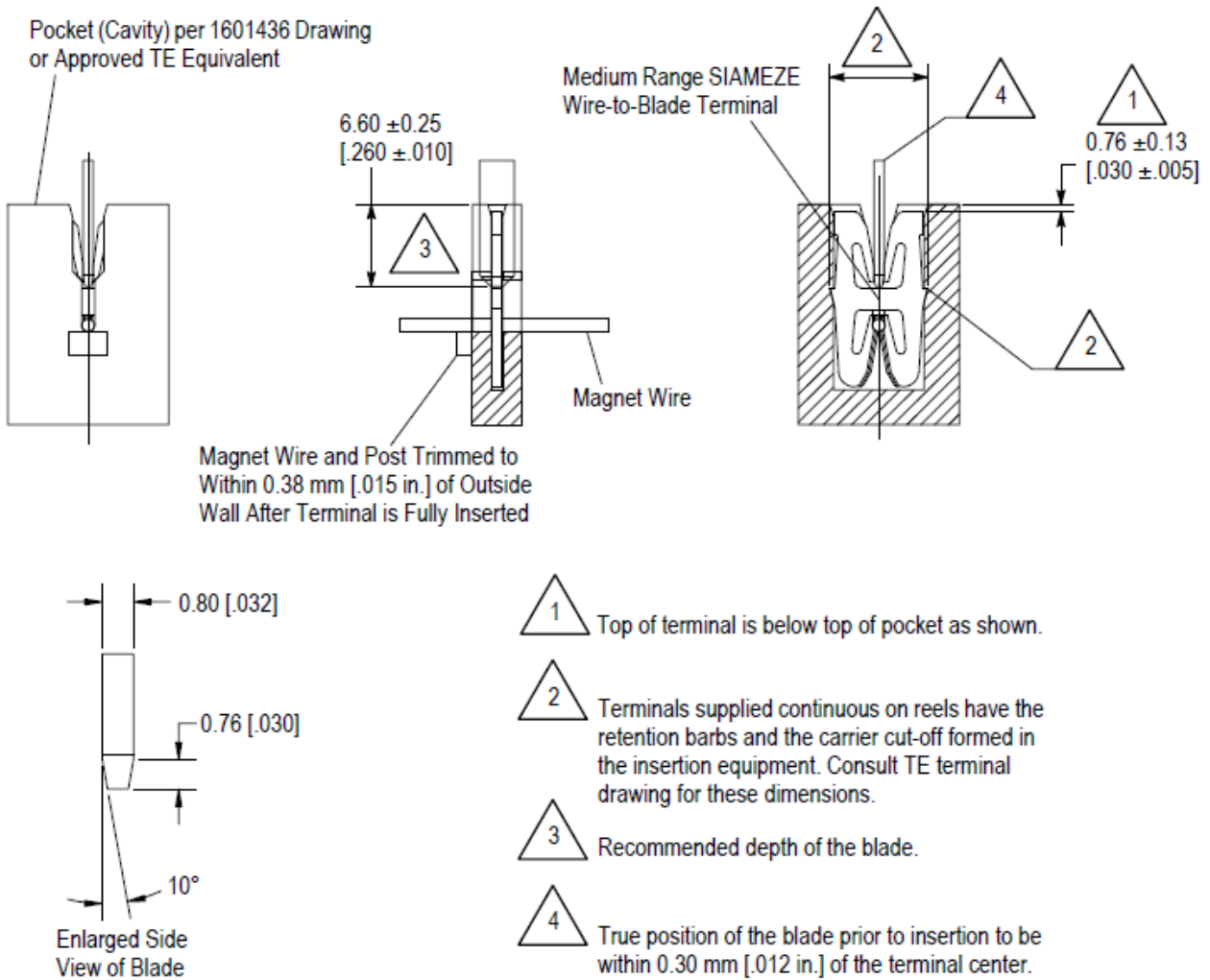
**SIAMEZE Medium Range Wire-to-Wire Application**

**Figure 3**

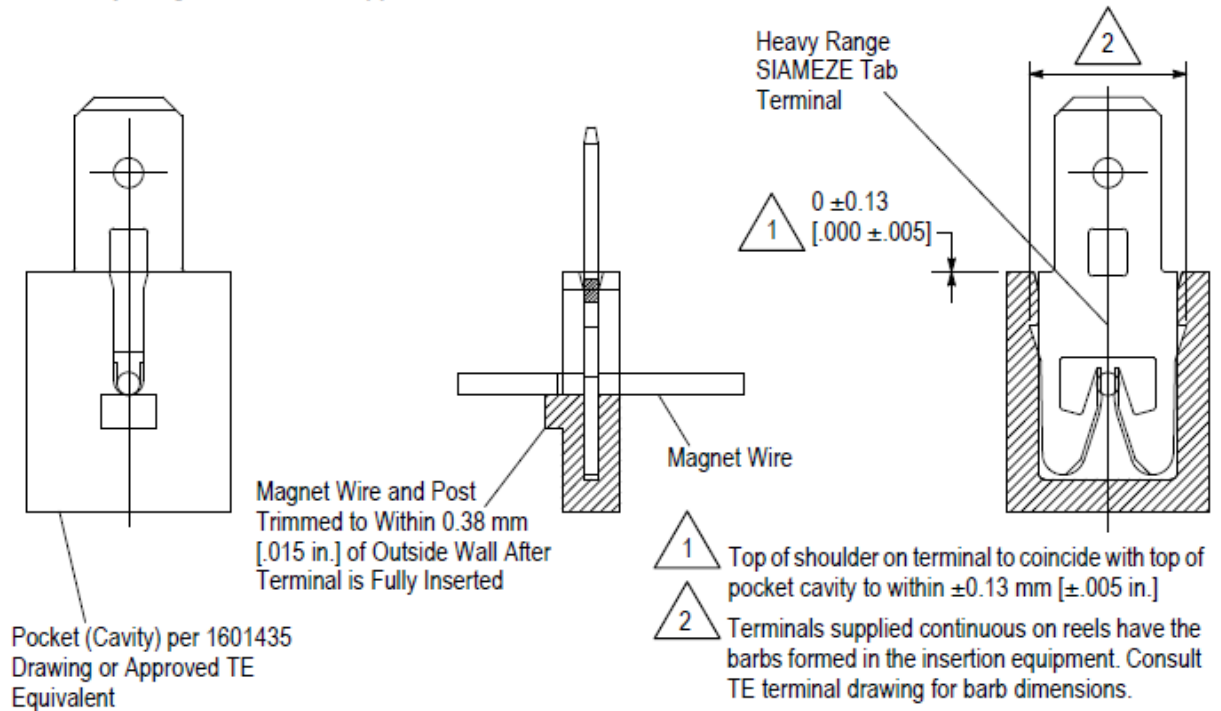
**SIAMEZE Medium Range Tab Terminal Application**


1 Top of shoulder on terminal to coincide with top of pocket cavity to within  $\pm 0.13$  mm [ $\pm 0.005$  in.]

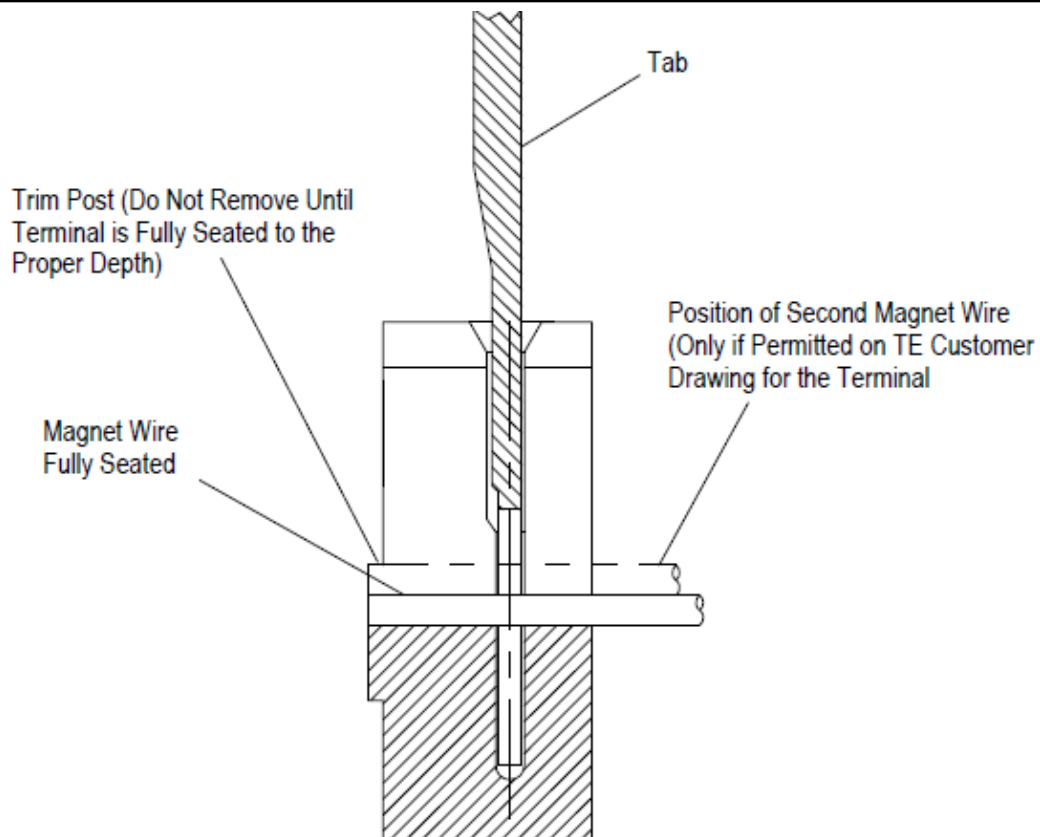
2 Terminals supplied continuous on reels have this dimension formed in the insertion equipment. Consult TE terminal drawing for the cutoff width.

**Figure 4**

**SIAMEZE Medium Range Wire-to-Blade Terminal Application**

**Figure 5**

**SIAMEZE Heavy Range Tab Terminal Application**

**Figure 6**
**3.8. Wire Position (Terminated)**

Removal of the trim post and any excess wire must not take place until the terminal is fully inserted to the position recommended in this specification. See Figure 7.


**Figure 7**



### 3.9. Carrier Cutoff and Burr Allowances

Continuous terminals (i.e. terminals supplied on a reel) need to be cut from the carrier strip prior to insertion. For some terminals, the carrier is cut at 90° while for others it is cut at a 10° - 15° angle forming a retention barb that holds the terminal in the pocket. Unless otherwise approved by TE Product Engineering, the cutoff is to be formed as indicated on the specific customer drawing. This information can be found in the loose piece insert box on the drawing. The burr which remains at the bottom of the cut edge should not exceed the indicated limit. Refer to Figure 8.

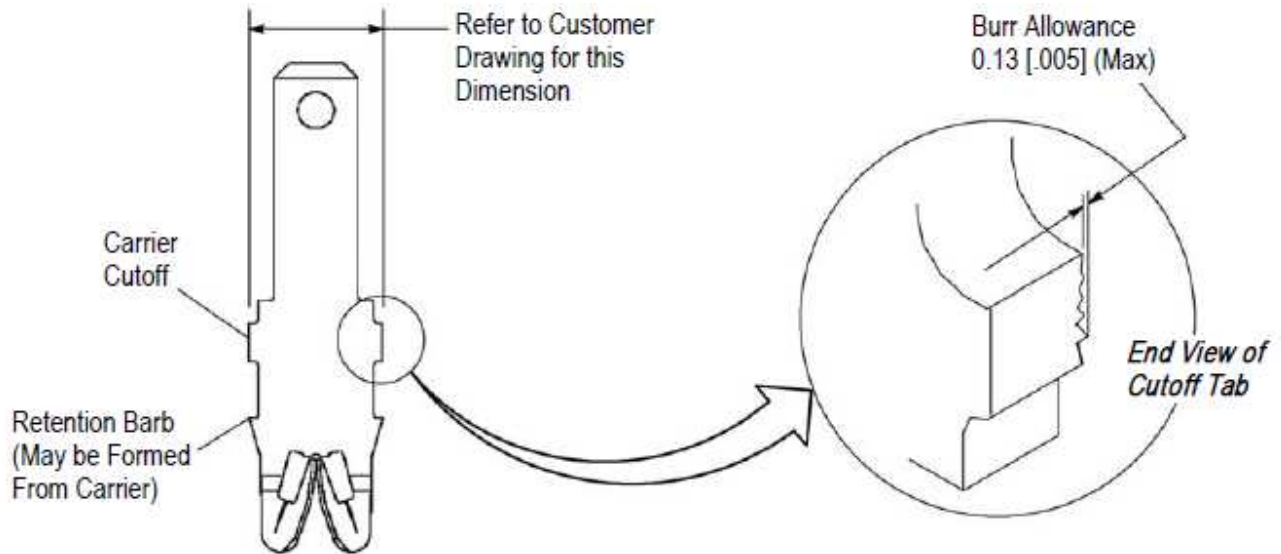


Figure 8

### 3.10. Bending Tab and Posted Terminals

Many tab and posted SIAMEZE terminals can be bent at an angle 90° or less provided the bend is accomplished in a controlled manner using a support tool to control the radius. Refer to Figure 9. The minimum radius is a function of the temper of the terminal at the bend point. Consequently, TE Product Engineering should be consulted during the design phase.

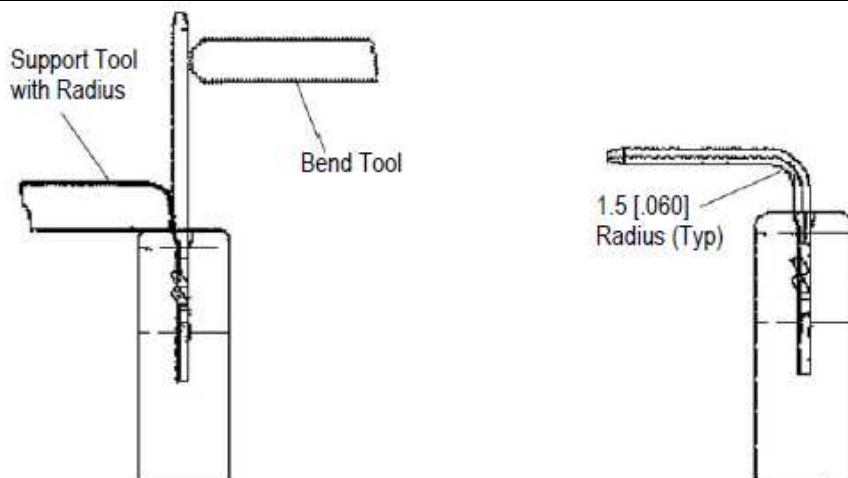


Figure 9

### 3.11. Lead Wire Retention

When connecting a lead wire or other component in the top contact of a SIAMEZE wire-to-wire terminal (e.g. 1601136-1, etc.) consideration should always be given to the force that will be exerted on the wire during the life of the product. If the wire can potentially be subjected to a force that will disrupt the connection, a strain relief is needed to secure the wire and provide mechanical isolation.

### 3.12. Repair/Replacement



**CAUTION**

Damaged product should not be used. If a damaged terminal or housing is evident, it must be replaced with a new one. Insulation Displacement Contacts are single use only. Terminals are NOT to be re-terminated.

### 4. QUALIFICATION

Magnet wire terminations using SIAMEZE Medium and Heavy Range Terminals, cavities, and assembly requirements outlined in this specification will conform to the design objectives provided in 108-2239 and 108-2316.

### 5. TOOLING

Loose piece terminals can be inserted with Hand Insertion Tools, Manual Arbor Press, or Entry-Level Magnet Wire Terminator (EMT) equipment. Strip terminals can be inserted with a variety of tools and machines designed for specific applications. Since the exterior design of the housing must meet the requirements of the equipment in which the housing is going to be used, tooling must be designed for each specific application. Customer manuals are available for any machine produced by TE. Typical tooling and reference documentation for each are provided in Figure 10.

Tooling information for product part numbers is available from [www.te.com](http://www.te.com) or by calling the Product Information Center at the number at the bottom of page 1.

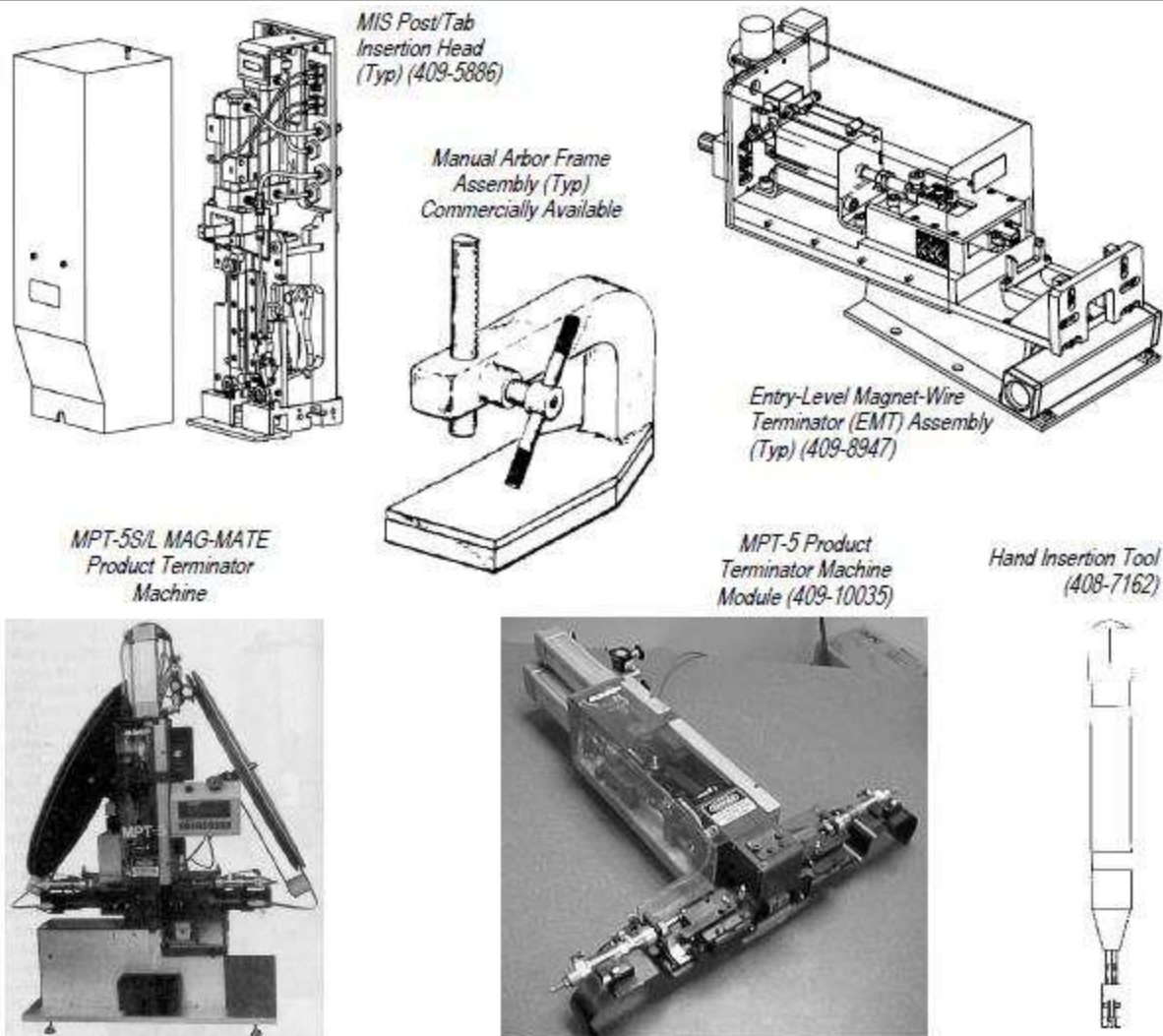


Figure 10

## 6. VISUAL AID

The illustration below shows a typical application of this product. This illustration should be used by production personnel to ensure a correctly applied product. Applications which do not appear correct should be inspected using the information in the preceding pages of this specification and in the instructional material shipped with the product or tooling.

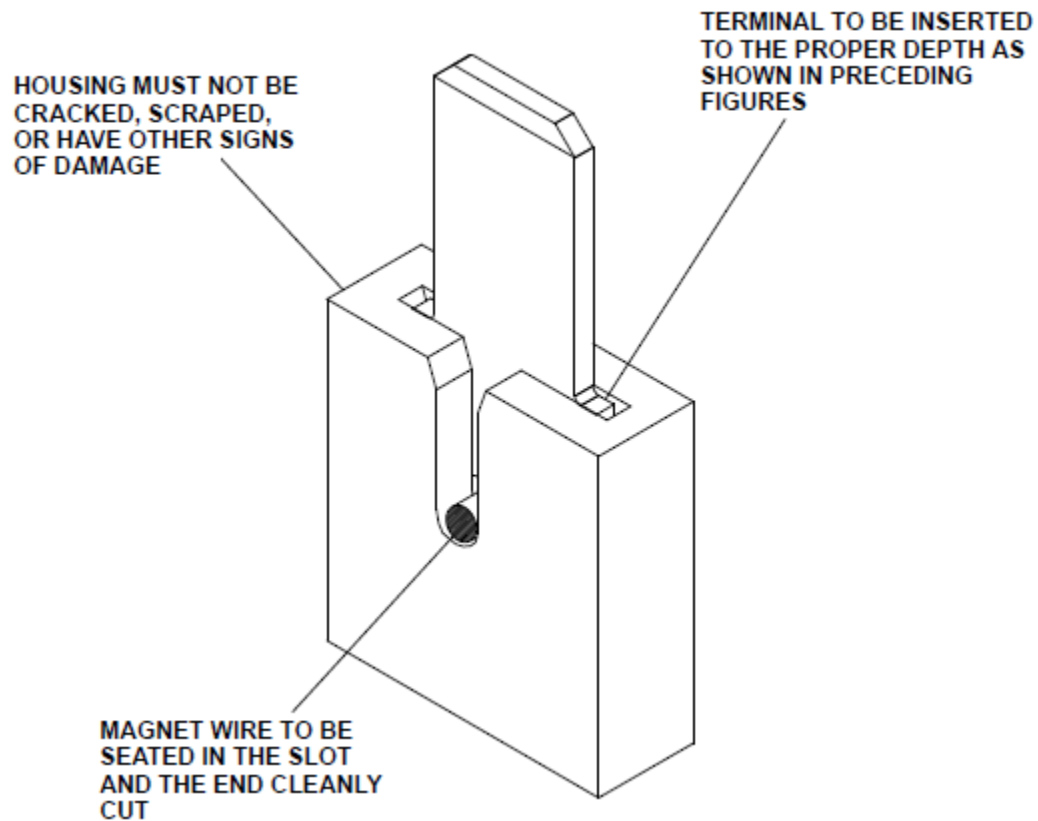


Figure 11: Visual Aid