

1. Scope :

This specification covers the requirements for crimping of MMC power connector terminals, grounding clip

2. Application terminals, Grounding clip

Contact feature	P/N	Wire sizes	Application cable outer diameter	Remark
Receptacle terminal	2271279-2	AWG 22~AWG18	-	
Plug terminal	2271283-2		-	
Grounding terminal	2271285-1		-	
Grounding clip	2271277-1	-	$\emptyset 9.0 \pm 0.4\text{mm}$	

3. Nomenclature and crimping feature

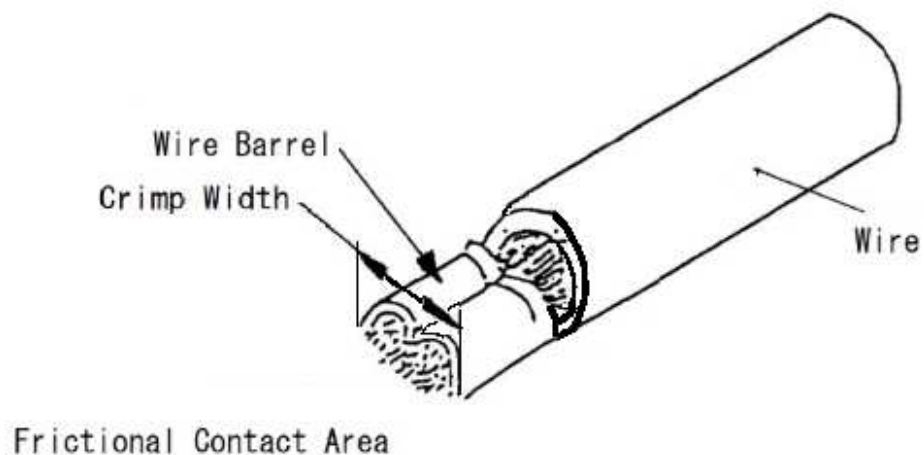


Fig 1

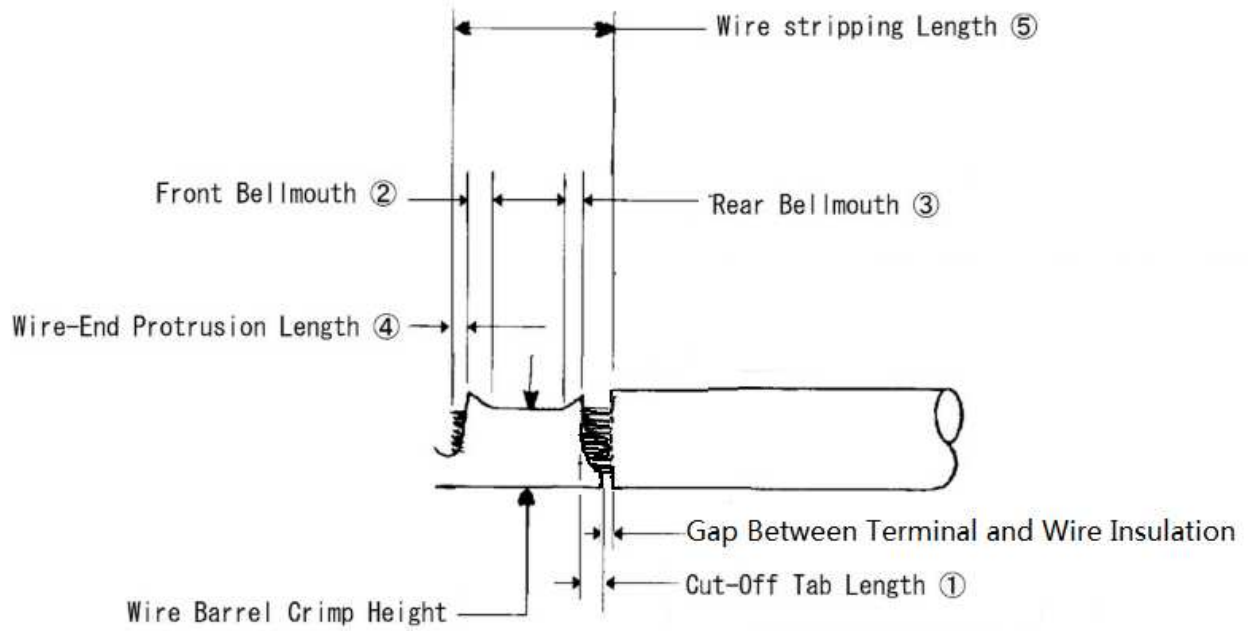


Fig 2

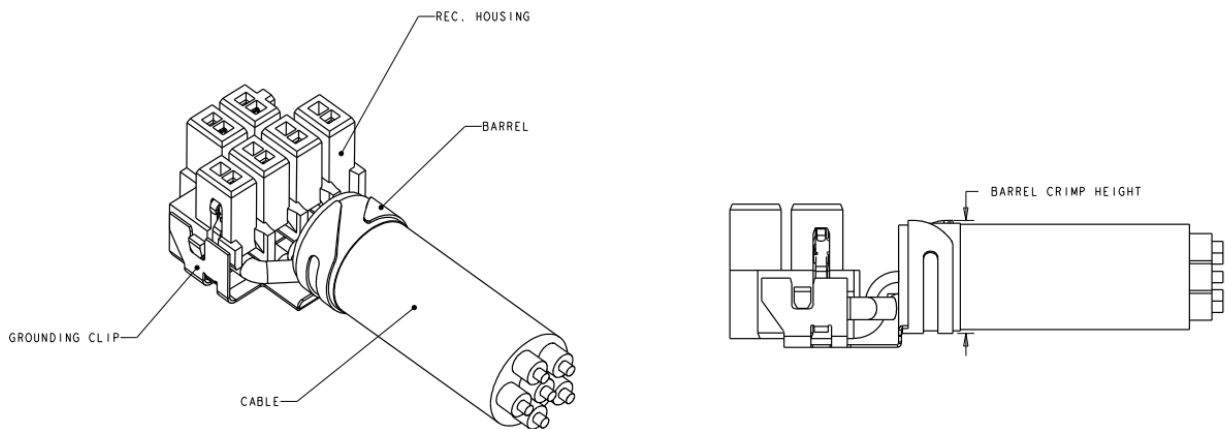
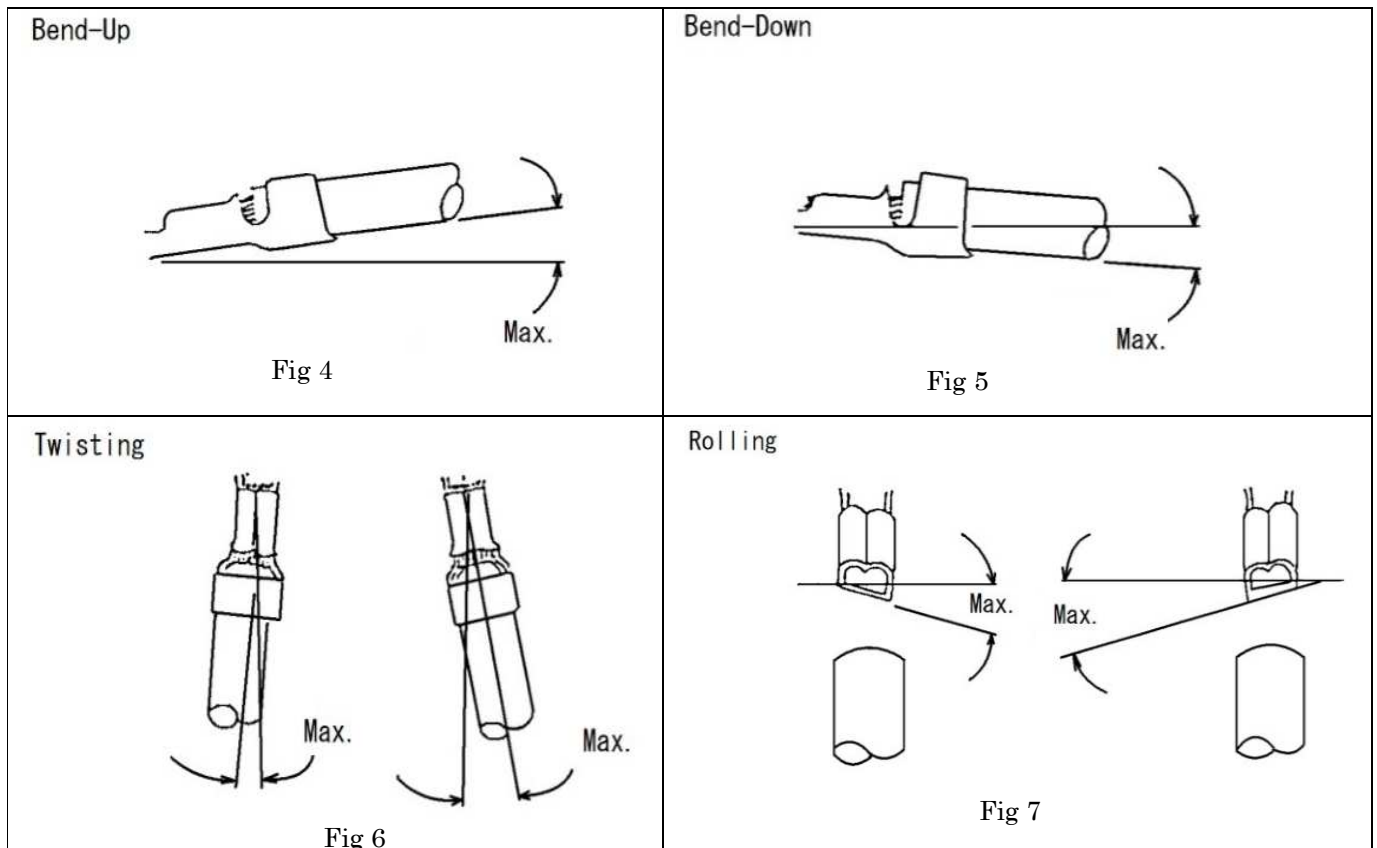


Fig 3

4. Crimping condition and crimping data

4.1 Crimping conditions

No.	Checking items		requirements	Remark
1	Allowable Deviation after crimping	Bend-up	3° Max.	Fig 4
		Bend-down	3° Max.	Fig 5
		Twisting	5° Max.	Fig 6
		Rolling	6° Max.	Fig 7
2	Cut-off tab length		0.10max.	Fig 2
3	Bell Mouth	Front	none	Fig 2
		Rear	0~0.15mm	Fig 2
4	Wire-End Protrusion Length		0~0.7mm	Fig 2
5	Wire stripping Length		1.2~1.8mm	Fig 2
6	Gap between terminal and wire insulation		0.10mm max.	Fig 2



4.2 Crimping data

4.2.1 Terminal crimping data

Terminal Part No.	Wire Size	Wire Barrel crimp		Crimp tensile strength (kgf min.)
	Cross section	Width(mm)	Height(mm)	
2271279-2 2271283-2 2271285-1	22AWG	1.40	0.85±0.05	4.5
	20AWG		1.00±0.05	6.5
	18AWG		1.15±0.05	6.5

4.2.2 Grounding clip crimping data

Grounding clip Part No.	Application Cable Outer Diameter(mm)	Barrel Crimp Height (mm)	Crimp tensile strength (kgf min.)
2271277-1	∅ 9.0±0.4mm	∅ 8.0±0.4mm	2.0