



HK2/4-006 Insert

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1. INTRODUCTION

This specification contains the regulations for assembly of HK2/4-006 contact inserts and the handling of these inserts.

2. SUPPORTING DOCUMENTS

2.1. Customer drawings

Please refer to the customer drawings of HK2/4-006-M/F inserts.

2.2. Product specification

The product specifications of the used articles are to be taken into account. The product specification describes the technical data as e.g. regulations, approvals, temperature range and rated voltage.

For further reference refer Product spec. 108-137613.

2.3. Application Specification

Connectors shall be assembled as below mentioned application specifications to ensure correct connector assembly.

2.4. Standards

- EN 61984: Connectors - Safety requirements and tests
- IEC 60664-1: Insulation coordination for equipment within low-voltage systems (Part 1)
- IEC 60999-1: Electrical copper conductors- Safety requirements for the clamping units for conductors

3. DESCRIPTION

This application specification describes the male insert and the female insert of the HK2/4-006-M/F series.

The listed terms are used in the specification as shown HK2/4-006-M with AWG8 power contact and HK2/4-006-F with AWG8 power contact as example in Figure 1.

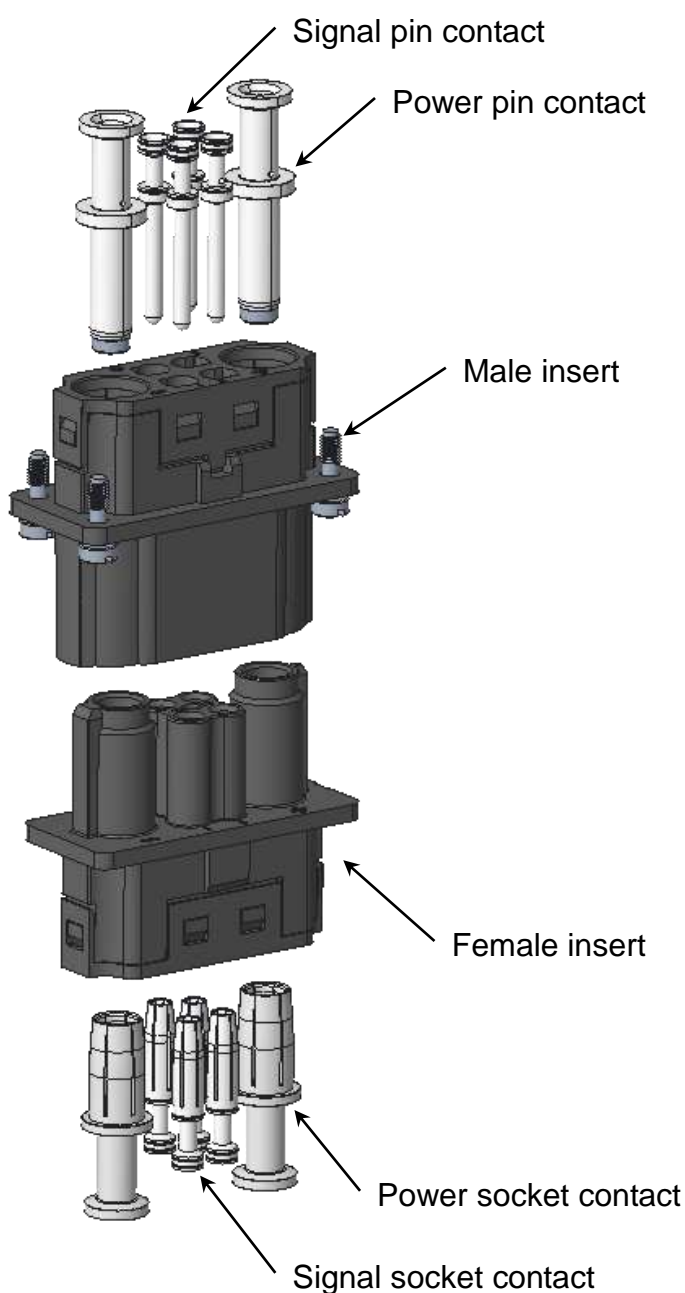


Figure: 1

4. REQUIREMENTS

4.1. Wire selection and preparation

4.1.1. Stripping length L

Use proper tooling to strip the wire.

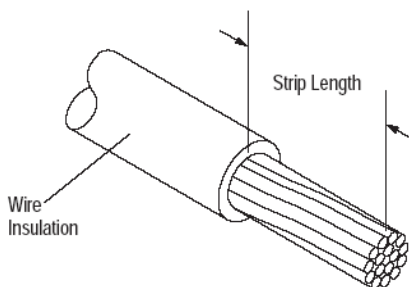


Figure: 2

NOTE When stripping the wire, care must be taken to avoid scraping, nicking, or cutting the conductor. Care must also be used when handling the wire during stripping to prevent cracking or breaking the conductor and insulation.

Depending upon the cross section of the wire or cable, the stripping length has to be selected from the table below. See Table 1.

Table: 1

Contact Insert	Max. Wire cross section		Strip Length For Reference	Current /Voltage Rating
	[mm ²]	AWG	L [mm]	
HEM/HEF	0.14-0.37 mm ²	26-22	7.5	3A / 60V
HEM/HEF (Signal)	2.5 mm ²	14	7.5	10A / 60V
HSM/HSF	10 mm ²	8	13.0	55A / 250V
HSM/HSF	16 mm ²	6	13.0	80A / 250V

4.1.2. Insulation diameter

Any wire that is used for the Electrical purpose is covered with insulating polymer.

This insulation on the wires depends upon the wire size and type of application where it is being used. The insulation diameter for various wire sizes is as shown in Table 2 only for reference.

Table: 2

Contact Insert	Max. Wire cross section		Insulation Diameter in (mm)
	[mm ²]	AWG	
HK2/4-006-M/F, Power	16 mm ²	6	9.5 MAX.
HK2/4-006-M/F, Signal	2.5 mm ²	14	3.5 MAX.
HK2/4-006-M/F, Signal	0.14-0.37 mm ²	26-22	2.5 MAX.



The Insulation diameter over the wire specified in the Table 2 is for the insulation concentric, with equal thickness layer over the conducting wire.

4.2. Assemble wires to inserts

- Assemble stripped wires to contacts (Crimp)

- Crimping tool

Crimping tool is available as below Figure 3 & 4:



- ♦ Wire range: AWG26 ~ AWG12 (0.14 mm² ~ 4.0 mm²)
- ♦ Type: CRIMP TOOL AWG26 ~ AWG12
- ♦ Order number: T3100000022-000 (refer 114-137329)

Figure: 3



- ♦ Wire range: 10.0/ 16.0 mm²
- ♦ Type: CRIMPBOX-E-60kN
- ♦ Order number: T3100000032-100 (refer 114-137597)
- ♦ Crimp die need to be ordered separately refer 114-137597

Figure: 4

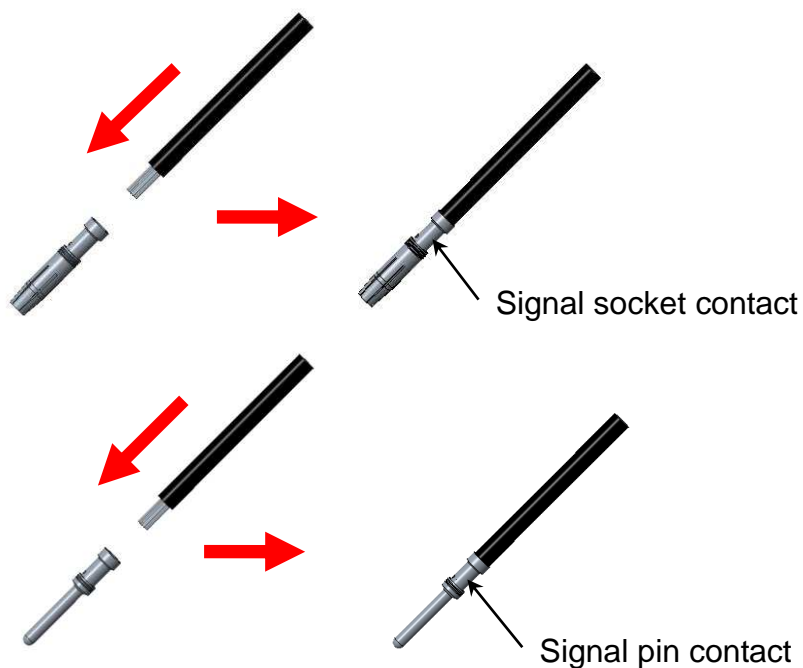
➤ **Crimp**

Insert the cable - stripped according to Table 1 - into the wire barrel of the contact. The wire strands must be visible in the reference hole of the contact. Afterwards, crimp the contact in the crimp area, using the correct tool for this type of contact. During the termination process make sure that the contact in the contact zone is not damaged or deformed.

When using manual crimp tools the following points must be followed:

- 1). Equip manual crimp tool with the correct locator or positioning ferrule.
- 2). When using different manual crimping tools the pliers have to be adjusted by plug gauge to fit the crimp area.
- 3). Fully insert contacts into the locator.
- 4). Clamp the wire with help of crimp tool. Note that to press the crimp tool till the stopper is reached a positive crimp.

HEM/HEF contact as below:



HSM/HSF contact as below:

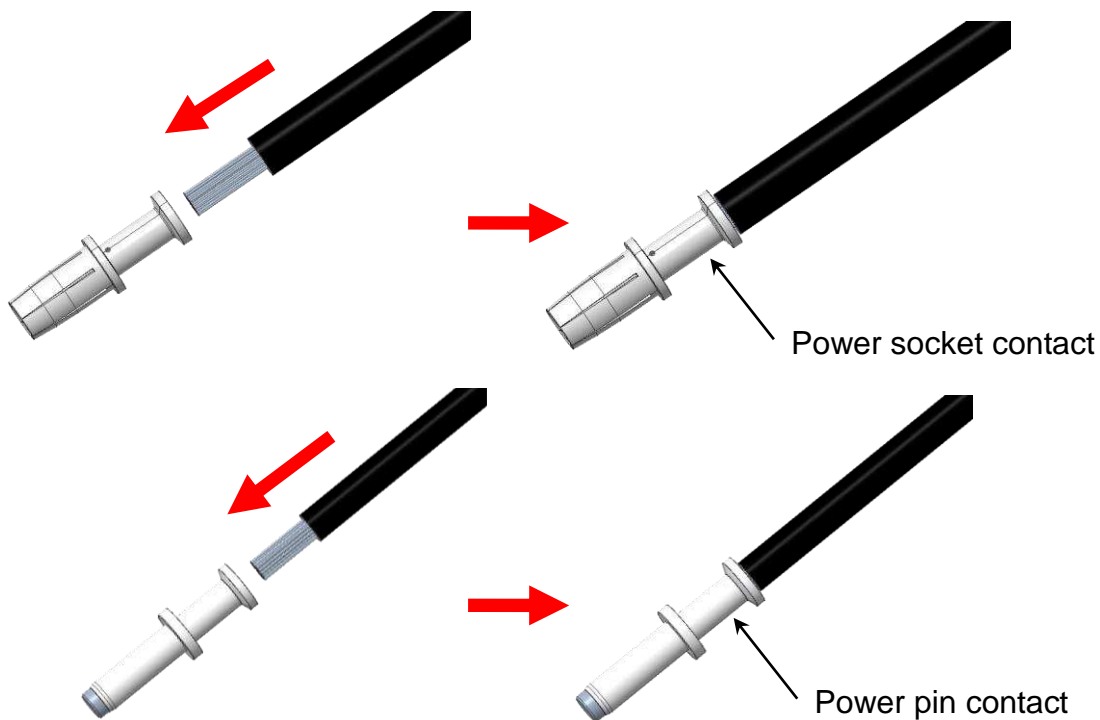


Figure: 5



For more detailed information, please refer to related contacts application specifications.

b. Insert crimped terminals into inserts

The crimped terminals are plugged into the insert by gently pushing it into the required position until the contact is locked by the inserts, a click should be heard normally. If needed, an auxiliary tool can be used.

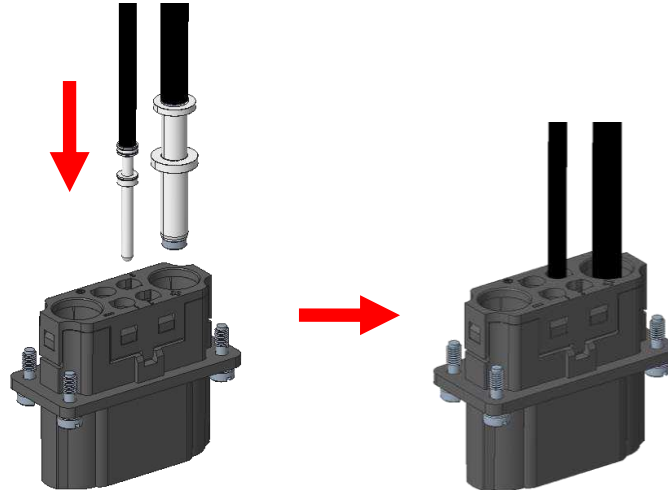


Figure: 6

c. Repeat till wires are fully assembled.

4.3. Tooling for contacts removal

- 1). Insert the extraction tool along the crimped contact into the special space on the cover
- 2). Insert the tool till it touch the contact end face.
- 3). Now, pull out crimped contact holding cable and also the tool together to unplug the contact.



- ♦ Type: REMOV-EE
- ♦ Order number: T3100000002-000



- ♦ Type: REMOV-HK2/4-006
- ♦ Order number: T3100000037-000

Figure: 7

5. ASSEMBLY

Assembling the contact inserts for both Male & Female connector has to be carried out with proper tools with customer housing.

5.1. Grounding contact

Grounding contacts are assembled into contact inserts.

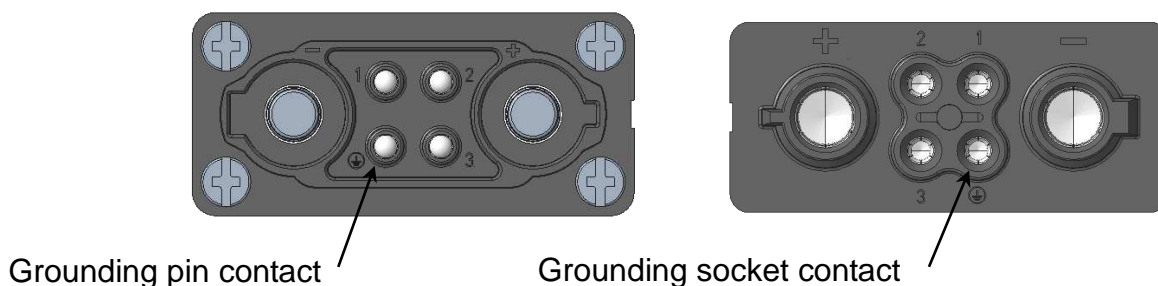


Figure: 8

This grounding contact is suitable for connection of a cable with a nominal cross section of up to 0.14-2.5 mm² (AWG 26 - AWG 14). Assembly process may refer to 4.1 & 4.2.

Earthing is to be executed according to IEC 61984.

5.2. Marking

The connector type, rating and the number of position etc. refer to the corresponding HK2/4-006-M/F insert customer drawings.

5.3. Polarization function

The process of assembling the male and female inserts without any mismatch and difficulty calls for polarization. This is done with the help of inserts form. As shown in Figure 9.

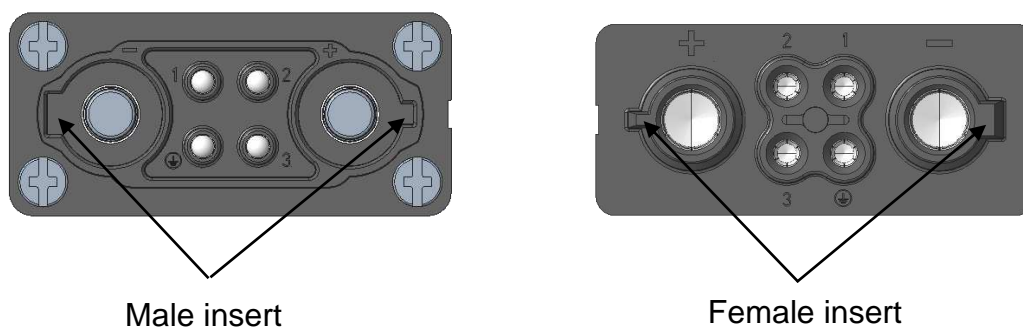
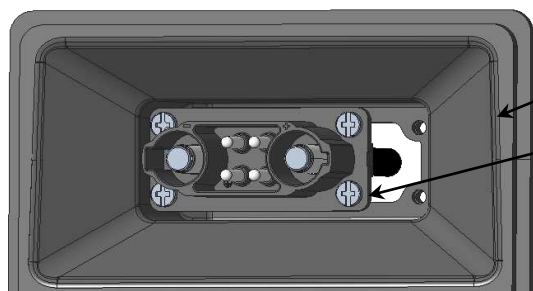


Figure: 9

5.4. Application for reference

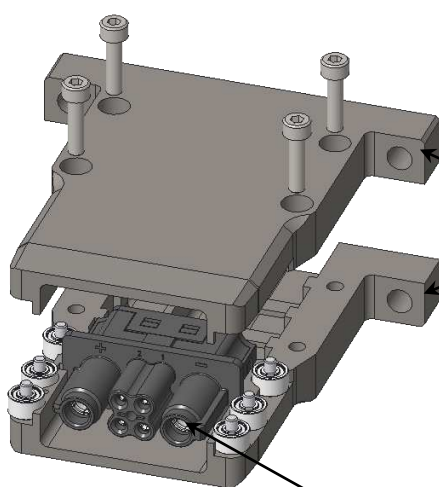


Panel for reference

Male side, not including the cable,
refer customer drawing

After completing the cable assembly,
screw the male insert into the panel together

Note: Other installation methods can also be used according to the customer's actual situation.



Panel for reference

After completing the cable assembly,
put the female insert into the panel
screw the two-half panel together

0.5mm floating between female insert and panel

Female side, not including the cable, refer customer drawing

6. STORAGE

6.1. Chemical exposure

Do not store the connectors near any chemical listed below as they may cause corrosion stress the connector contacts:

Alkalies, Ammonia, Citrates, Phosphates, Citrates, Sulfur, Amines, Carbonates, Nitrites, Sulfides, Nitrites, Tart rates.

6.2. Storage condition

The connectors should be stored in the air ventilation, no corrosive gas, no rain and no snow in the warehouse. Relative humidity: less than 85% RH (For connectors which include insert and contacts or contacts only, the preferred storage temperature is 10° C~27° C, Relative humidity: 25%~60%). The connectors should remain in the shipping containers until ready for use to prevent deformation to the contacts. The connectors should be used on a first in, first out basis to avoid storage contamination that could adversely affect



Application Specification

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electrical functions.

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