


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 ± 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 .

Basic terms and features of this product are provided in Figure 1.

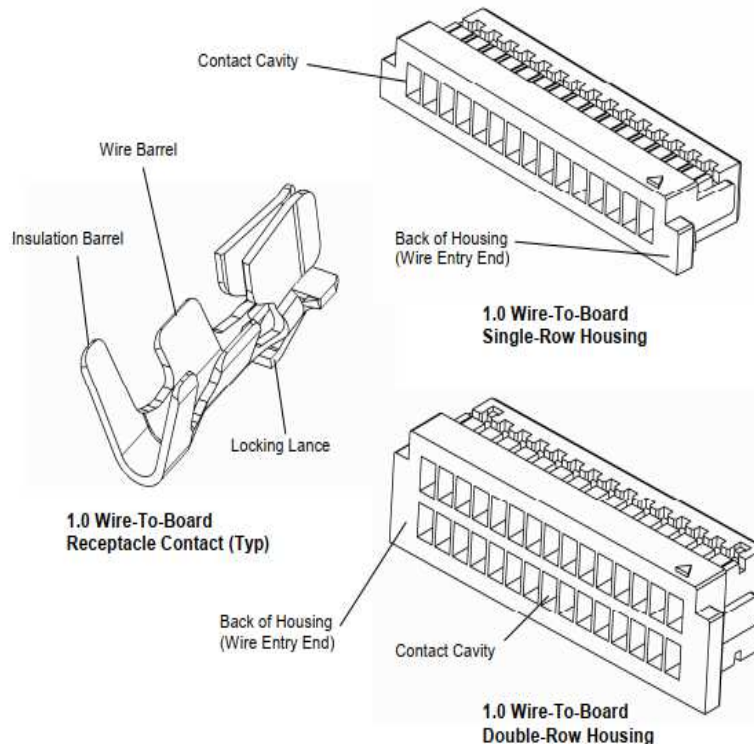


Figure 1

2. REFERENCE MATERIAL

2.1. Revision Summary

Initial release of application specification.

2.2. Customer Assistance

Reference Product Base Part Number and Product Code are representative of . Use of these numbers will identify the product line and help you to obtain product and tooling information when visiting 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. Information contained in the customer drawing takes priority.

2.4. Manuals

Manual 402-40 can be used as a guide to soldering. This manual provides information on various flux types and characteristics with the commercial designation, flux removal procedures, and a checklist for information on soldering problems.

2.5. Specifications

Product Specification 108-161192 provides product performance and test results.

2.6. 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:

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 product material.

B. 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.

C. 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.

4. QUALIFICATION

4.1. Underwriters Laboratories Inc. (UL)

are recognized by Underwriters Laboratories Inc. (UL) in File .

4.2. Canadian Standards Association (CSA)

are certified to CSA International in File .

4.3. Verband der Elektrotechnik (VDE)

are certified by VDE per IEC in Certificate .

5. TOOLING

Tooling information for product part numbers is available from www.te.com or by calling the Product Information Center at the number at the bottom of page 1.

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.

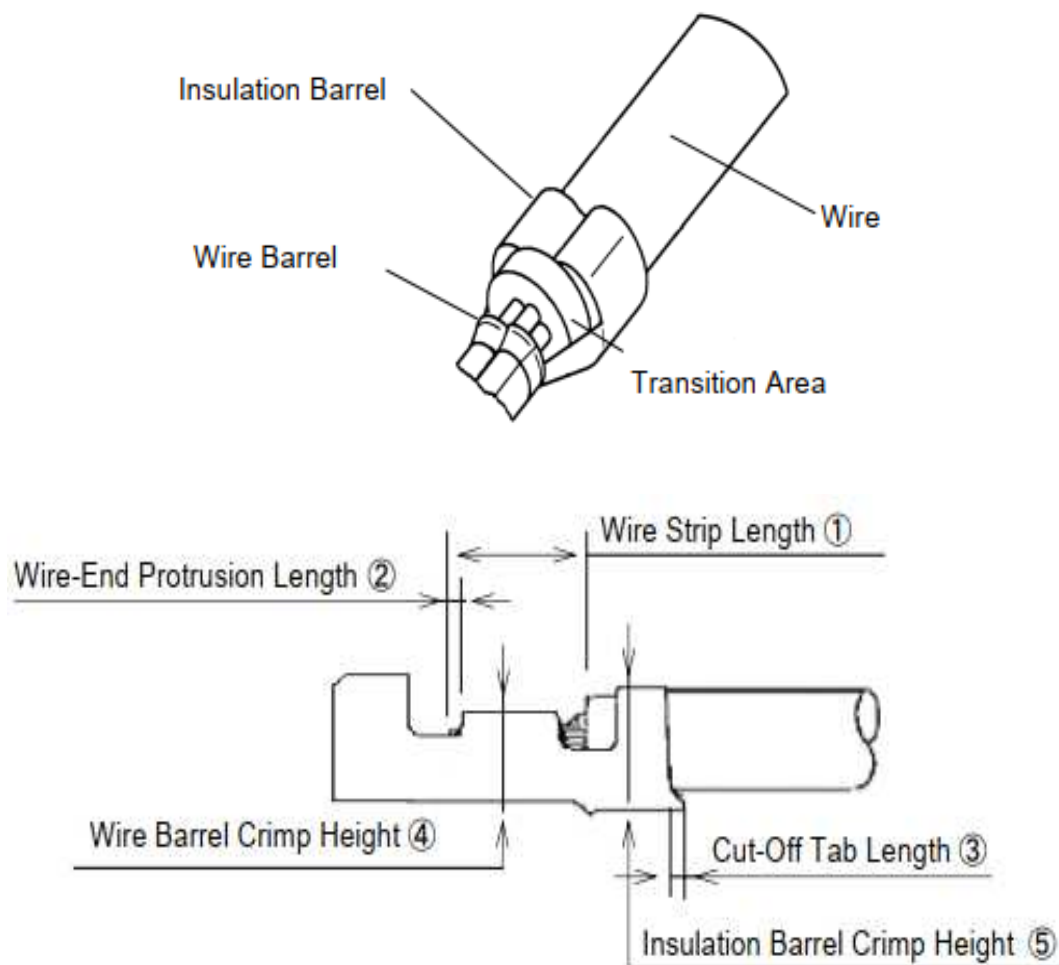
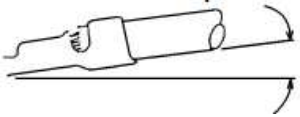
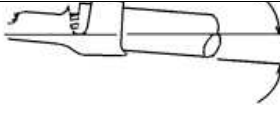
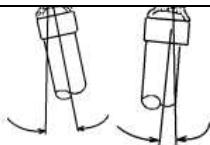
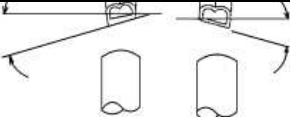


Figure 2: Visual Aid

CRIMPING REQUIREMENT

No.	Check Items	Requirements		Remarks	
		Applicator	Hand Tool		
1	Wire Strip Length	0.9 ~ 1.3 mm		Fig.1 - ①	
2	Wire-End Protrusion Length	0.1 ~ 1.3 mm		Fig.1 - ②	
3	Cut-Off Tab Length	0.0 ~ 0.2 mm		Fig.1 - ③	
4	Wire Barrel Crimp	Refer Table.1		Fig.1 - ④	
5	Insulation Barrel Crimp Height	Refer Table.1		Fig.1 - ⑤	
6	Allowable Deviation after Crimping		6° Max.	6° Max.	
7			6° Max.	6° Max.	
8			5° Max.	5° Max.	
9			7° Max.	7° Max.	

CRIMPING DATA

Table.1

Contact Part Number	Applicator Part Number	Wire Size		Insulation Barrel Crimp Width	Wire Barrel	
		Number of Wire	Size		Crimp Height (C)	Crimp Width (D)
X-2473275-X	N/A	1	0.08mm ² (#28)	0.8-0.9	0.45-0.50	0.70-0.75
		1	0.05mm ² (#30)	0.8-0.9	0.45-0.50	0.65-0.70
		1	0.03mm ² (#32)	0.8-0.9	0.45-0.50	0.65-0.70

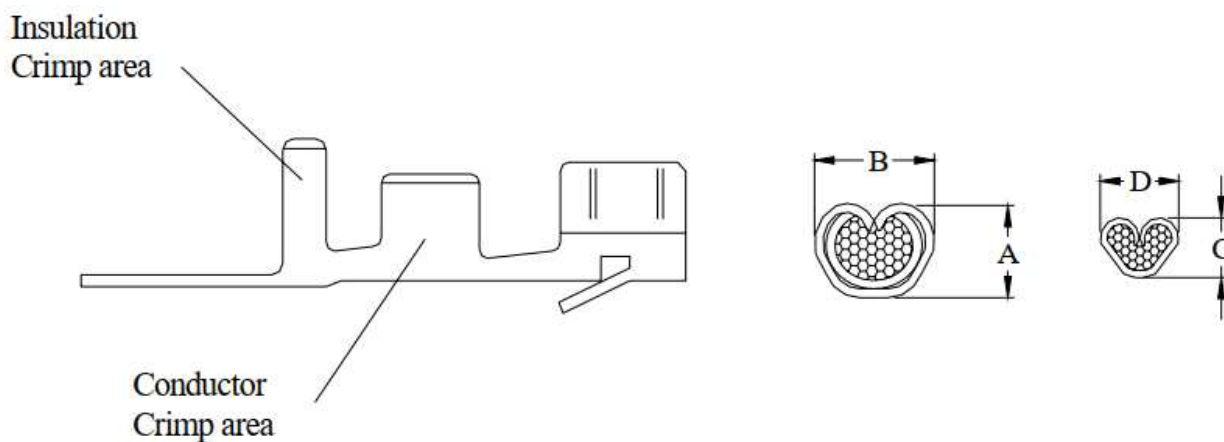


Table.2

Wire Size		Crimp Tensile Strength
MM ²	AWG#	N (kgf) Min.
0.08	28	14.7 (1.5)
0.05	30	9.80(1.0)
0.03	32	4.90(0.5)

- NOTE** (a) Tool mark is allowable at crimped areas and transition areas only.
 (b) The dimensions of crimp width of wire barrel and insulation barrel are the dimensions of crimping tool.