

NUMBER: 114 - 5029

SECURITY CLASSIFICATION: Customer Release

114 - 5029

Application Specification

Crimping of Positive Lock Mark-I Receptacle Contacts

(This specification may change without notice, as a result of product evaluation testing.)

1. Scope:

This specification covers the requirements for crimping of Positive Lock Mark-I Receptacle Contacts.

2. Applicable Products:

Part Numbers	Descriptions
154717	Positive Lock Contacts
154718	" " "

3. Nomenclature:

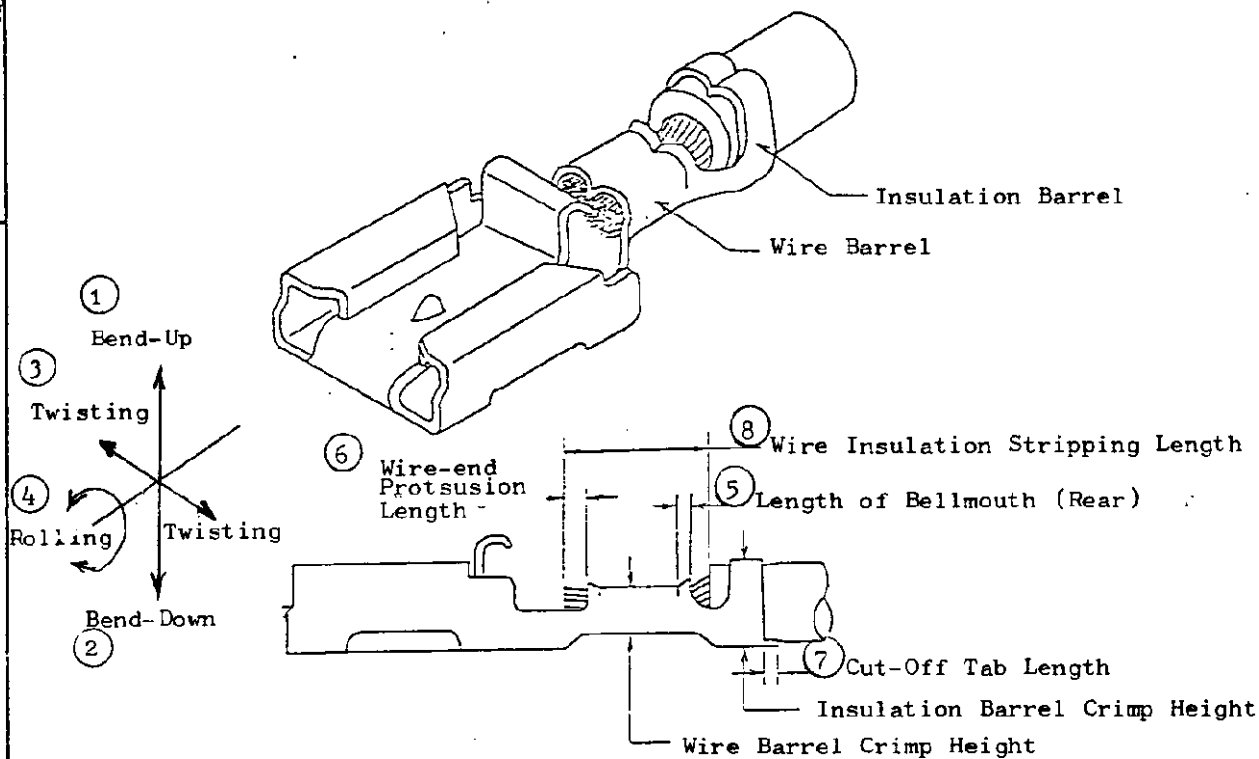


Fig. 1

				DR.	SHEET 1 OF 3			REV.
				CHK. 6-OCT-'94				LOC J
				APP. 10/6 '94	NAME			
				Crimping of Positive Lock Mark-I Receptacle Contacts				
PRINT	O2	REACTIVATE	NK	GH	05MAY2015			
	LTR	REVISION RECORD	DR	CHK	DATE			

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4. Crimping Requirements and Crimp Data:

4.1 Crimping Requirements:

No.	Check Items	Crimping Requirements	Remarks
1	Deformation after Crimping	Bend-Up	8° max. Fig. 1 (1)
		Bend-Down	0° Fig. 1 (2)
		Twisting	5° max. Fig. 1 (3)
		Rolling	20° max. Fig. 1 (4)
2	Length of Bellmouth	0.2mm - 0.7mm	Fig. 1 (5)
3	Wire End Protrusion Length	1.5mm max.	Fig. 1 (6)
4	Cut-Off Tab Length	0.5mm max.	Fig. 1 (7)
5	Insulation Stripping Length	5.5mm - 6.5mm	Fig. 1 (8)


4.2 Crimp Data:

Contact Part No.	Applicator Number	Wire Size (mm <sup>2</sup> )	Wire Barrel Crimp		Insulation Barrel Crimp		
			Width(mm)	Height (mm)	Width(mm)	Height (mm)	
154718	466542-2	0.85	2.79	1.52 ±0.05		3.94	4.2 max.
		1.25		1.64 ±0.05			
		2.0		1.87 ±0.05			
154717	563533	3.0	3.56	2.05 ±0.05		4.57	

5. Crimp Tensile Strength:

Crimped contact shall have crimp tensile strength conforming to the requirements as specified in the following table.

Wire Size (mm <sup>2</sup> )	Crimp Tensile Strength (kg) (min.)
0.85	13.0
1.25	17.0
2.0	25.0
3.0	35.0

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6. Applicable Wires:

Wire Size (mm <sup>2</sup> )	Number of Conductors	Diameter of Conductors	Calculated Cross-sectional Area (mm <sup>2</sup> )	Finished Insulation Diameter (STD) (mm)	Applicable Wire Specification
0.85	11	0.32	0.88	2.4	JIS C 3406 Low-voltage cables for automobiles
1.25	16	0.32	1.29	2.7	
2.0	26	0.32	2.09	3.1	
3.0	41	0.32	3.30	3.8	

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