

## 1.Scope

This standard applies to the crimping of the 250 series Tab and Receptacle Contacts

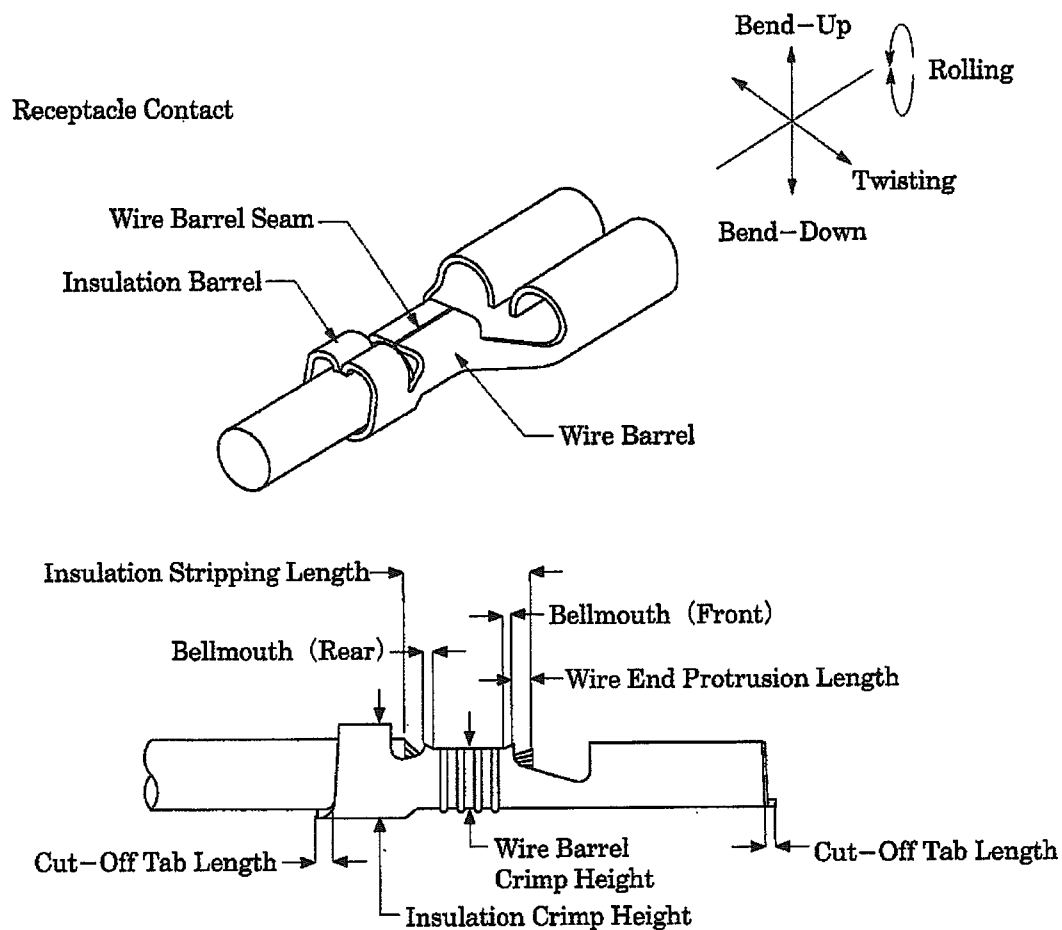
## 2.Applicable Contacts

| Contact Part No. | Descriptions        |
|------------------|---------------------|
| 170342           | Receptacle Contacts |
| 1376071          |                     |
| 170350           |                     |
| 170054           |                     |
| 170368           |                     |
| 170384           |                     |
| 170032           |                     |
| 170031           |                     |
| 170089           |                     |
| 170258           |                     |
| 179461           |                     |
| 170340           | Tab Contacts        |
| 170341           |                     |
| 170349           |                     |
| 170367           |                     |
| 170383           |                     |
| 170030           |                     |
| 170088           |                     |
| 170051           |                     |
| 179462           |                     |
| 170302           |                     |

## Crimping of 250 Series Tab and Receptacle Contacts

114-5052

### 3. Name of Parts



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114-5052

### 4. Crimp Conditions and Data :

#### 4.1 Crimp Conditions :

\* The values in parentheses indicate the limits for hand tool crimp.

| No |                               |           | Crimping Requirements                                                                                                  |                                                                        | Remarks |
|----|-------------------------------|-----------|------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------|---------|
|    |                               |           | Receptacle                                                                                                             | Tab                                                                    |         |
|    |                               |           | 170342,1376071,170350,<br>170368,170384,170032,<br>170031,170258,170054,<br>179461                                     | 170340,170341,170349,<br>170367,170383.170030,<br>170088,170051,179462 |         |
| 1  | Cut-off Tab Length            |           | 0.5mm Max.                                                                                                             |                                                                        |         |
| 2  | Bellmouth                     | Front     | 0.5mm Max * (0.9mm Max.)                                                                                               |                                                                        |         |
|    |                               | Rear      | 0.15~0.65mm * (0.15-1.0mm)                                                                                             |                                                                        |         |
| 3  | Deformation<br>after Crimping | Bend-Up   | 5° Max * (6° Max.)                                                                                                     | 4° Max * (5° Max.)                                                     |         |
|    |                               | Bend-Down | 3° Max * (3° Max.)                                                                                                     | 3° Max * (3° Max.)                                                     |         |
|    |                               | Twisting  | 10° Max * (10° Max.)                                                                                                   | 5° Max * (8° Max.)                                                     |         |
|    |                               | Rolling   | 8° Max * (8° Max.)                                                                                                     | 5° Max * (8° Max.)                                                     |         |
| 4  | Wire End Protrusion Length    |           | 0~2mm *1                                                                                                               |                                                                        |         |
| 5  | Wire Barrel Seam              |           | Seam to be closed ; a slight opening of seam can be permissible, on condition that no strands stray out of the barrel. |                                                                        |         |

\*1 ; 0~1.5mm : THIS SPEC APPLY TO 250 DOUBLE LOCK CONNECTOR SERIES.

#### 4.2 Crimp Data :

##### 4.2.1 Hand Tool Crimp

| Hand Tool<br>Part Numbers | Contact<br>Part Numbers | Wire Size<br>mm <sup>2</sup> (AWG) | Wire Barrel Crimp    |                  | Crimp Tensile<br>Strength (kg)<br>(Min.) |
|---------------------------|-------------------------|------------------------------------|----------------------|------------------|------------------------------------------|
|                           |                         |                                    | Crimp Height<br>(mm) | Crimp<br>Symbols |                                          |
| 934677-1                  | 170051<br>179462        | 0.5(#20)                           | 1.18-1.37            | 20-18            | 6.0                                      |
|                           |                         | 0.85(#18)                          | 1.18-1.45            |                  | 8.0                                      |
|                           |                         | 1.25(#16)                          | 1.34-1.61            | 16-14            | 18.0                                     |
|                           |                         | 2.0(#14)                           | 1.34-1.83            |                  | 23.0                                     |
| 934678-1                  | 170054<br>179461        | 0.5(#20)                           | 1.05-1.23            | 20-18            | 6.0                                      |
|                           |                         | 0.85(#18)                          | 1.05-1.23            |                  | 8.0                                      |
|                           |                         | 1.25(#16)                          | 1.21-1.48            | 16-14            | 18.0                                     |
|                           |                         | 2.0(#14)                           | 1.21-1.73            |                  | 23.0                                     |

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### 4.2 Crimping Data

#### 4.2.2 Crimping by Applicator

| Contact No.<br>(Strip)               | Applicator No.    | Wire Size<br>(Nominal) | Wire Barrel Crimp |        |      | Insulation Barrel Crimp |             | Crimp Tensile Strength<br>(kg) |
|--------------------------------------|-------------------|------------------------|-------------------|--------|------|-------------------------|-------------|--------------------------------|
|                                      |                   |                        | Width             | Height | Disc | Width                   | Height      |                                |
| 170340                               | 722798            | 0.5                    | 2.79<br>"F"       | 1.35   | D    | 4.57<br>"F"             | 3.1<br>Max. | 9 Min.                         |
|                                      |                   | 0.85                   |                   | 1.42   | C    |                         |             | 13 Min.                        |
|                                      |                   | 1.25                   |                   | 1.55   | B    |                         |             | 18 Min.                        |
|                                      |                   | 2.0                    |                   | 1.68   | A    |                         |             | 27 Min.                        |
| 170030<br>Note(4)                    | 721300<br>Note(3) | 0.5                    | 2.79<br>"F"       | 1.35   | D    | 5.33<br>"Oval"          |             | 9 Min.                         |
|                                      |                   | 0.85                   |                   | 1.42   | C    |                         |             | 13 Min.                        |
|                                      |                   | 1.25                   |                   | 1.55   | B    |                         |             | 18 Min.                        |
|                                      |                   | 2.0                    |                   | 1.68   | A    |                         |             | 27 Min.                        |
|                                      | 722798            | 0.5                    | 2.79<br>"F"       | 1.35   | D    | 4.57<br>"F"             |             | 9 Min.                         |
|                                      |                   | 0.85                   |                   | 1.42   | C    |                         |             | 13 Min.                        |
|                                      |                   | 1.25                   |                   | 1.55   | B    |                         |             | 18 Min.                        |
|                                      |                   | 2.0                    |                   | 1.68   | A    |                         |             | 27 Min.                        |
| 170341                               | 722799            | 2.0                    | 3.30<br>"F"       | 1.73   | B    | 4.57<br>"F"             | 3.3<br>Max. | 27 Min.                        |
|                                      |                   | 3.0                    |                   | 2.03   | A    |                         |             | 30 Min.                        |
| 170088                               | 721305            | 2.0                    | 3.30<br>"F"       | 1.73   | B    | 4.57<br>"F"             | 3.3<br>Max. | 27 Min.                        |
|                                      |                   | 3.0                    |                   | 2.03   | A    |                         |             | 30 Min.                        |
| 170342<br>170371<br>170032<br>170031 | 721160            | 0.5                    | 2.79<br>"F"       | 1.12   | D    | 4.57<br>"F"             | 3.1<br>Max. | 9 Min.                         |
|                                      |                   | 0.85                   |                   | 1.19   | C    |                         |             | 13 Min.                        |
|                                      |                   | 1.25                   |                   | 1.35   | B    |                         |             | 18 Min.                        |
|                                      |                   | 2.0                    |                   | 1.45   | A    |                         |             | 21 Min.                        |
| 170089<br>170258<br>1376071          | 721306            | 2.0                    | 3.30<br>"F"       | 1.47   | B    | 4.57<br>"F"             | 3.3<br>Max. | 27 Min.                        |
|                                      |                   | 3.0                    |                   | 1.78   | A    |                         |             | 30 Min.                        |
| 170349<br>170367<br>170383           | 722787            | 0.3                    | 1.78<br>"F"       | 1.22   | B    | 3.05<br>"O"             |             | 8 Min.                         |
|                                      |                   | 0.5                    |                   | 1.30   | A    |                         |             | 9 Min.                         |
| 170350<br>170368<br>170384           | 722788            | 0.3                    | 1.52<br>"F"       | 1.10   | B    | 2.79<br>"O"             |             | 8 Min.                         |
|                                      |                   | 0.5                    |                   | 1.20   | A    |                         |             | 9 Min.                         |
| 170302                               | 722766            | 0.3                    | 2.29<br>"F"       | 1.25   | C    | 5.33<br>"O"             |             | 8 Min.                         |
|                                      |                   | 0.5                    |                   | 1.33   | B    |                         |             | 9 Min.                         |
|                                      |                   | 0.85                   |                   | 1.44   | A    |                         |             | 13 Min.                        |

Notes :

- (1) The tolerance of wire barrel shall be within  $\pm 0.05$
- (2) Unless otherwise noted, the dimensions shown in Table shall be in mm
- (3) This applicator is of a restricted type, having width of insulation barrel in 5.33mm of oval type crimp.
- (4) When crimping 170030, two kinds of i.e. 4.57mm "F" and 5.33mm "Oval" are available. Select proper type according to the mounting housing.