

**Crimping requirements for DYNAMIC 1000 Series contacts**

**1. SCOPE**

This Application specification covers the crimping requirements for DYNAMIC 1000 Series contacts

**2. APPLICABLE PRODUCT PART NUMBER**

See Fig.1.

Contact Type	Size	Contact Part number L/P: Loose Piece	Plating Finish	Wire Size (AWG# REF) [mm <sup>2</sup> ]	Insulation Diameter [mm]
Receptacle Contact	S	1827569-2/ *- 2367817-1 <b>[b]</b> : Reel	Gold Plating	0.05~0.10 (#30~#28)	φ 0.60~ φ 1.20
		1827586-2/ *-2367818-1 <b>[b]</b> : L/P			
	M	1827570-2/ *-2367817-2 <b>[b]</b> : Reel	Gold Plating	0.08~0.37 (#28~#22)	φ 1.08~ φ 1.60
		1827587-2/ *-2367818-2 <b>[b]</b> : L/P			
		1939991-2 : Reel	Gold 0.76Plating		
		1939992-2 : L/P			
		1871303-1 : Reel			
	1871743-1 : L/P				
	L <b>[a]</b>	1827571-2 : Reel	Gold Plating	0.08~0.37 (#28~#22)	φ 1.08~ φ 1.90
		1827588-2 : L/P	Tin Plating		
		1871304-1 : Reel			
	2L <b>[a]</b>	1871744-1 : L/P			
		1827572-2 : Reel	Gold Plating	0.34~0.87 (#22~#18)	φ 1.40~ φ 2.20
		1827589-2 : L/P	Tin Plating		
		1871731-1 : Reel			
	1871745-1 : L/P				
	S	1903111-2/ *-2367819-1 <b>[b]</b> : Reel	Gold Plating	0.05~0.10 (#30~#28)	φ 0.60~ φ 1.20
		1903115-2/ *-2367820-1 <b>[b]</b> : L/P			
	M	1903112-2/ *-2367819-2 <b>[b]</b> : Reel	Gold Plating	0.08~0.37 (#28~#22)	φ 1.08~ φ 1.60
		1903116-2/ *-2367820-2 <b>[b]</b> : L/P	Tin Plating		
		1903120-1 : Reel			
	L <b>[a]</b>	1903124-1 : L/P			
		1903113-2 : Reel	Gold Plating	0.08~0.37 (#28~#22)	φ 1.08~ φ 1.90
		1903117-2 : L/P	Tin Plating		
		1903121-1 : Reel			
	1903125-1 : L/P				
	2L <b>[a]</b>	1903114-2 : Reel	Gold Plating	0.34~0.87 (#22~#18)	φ 1.40~ φ 2.20
		1903118-2 : L/P	Tin Plating		
		1903122-1 : Reel			
		1903126-1 : L/P			

Fig.1

**[a].** L and 2L size are not applicable for D1100 (2.0mm Pitch) housings.

**[b].** D1000 Slim Contact. It is applicable for D1000 slim housings.

### 3. Crimping REQUIREMENTS

See Fig.2 and Fig.3

NO.	Check Item	Specified Requirements	NO.	Check Item	Specified Requirements
①	Wire Stripping Length	2mm±0.3	⑥	Twisting	3° Max
②	Cut-Off Tab Length	0.25mm Max	⑦	Rolling	5° Max
③	Rear Bell mouth Length	0.1~0.3mm	⑧	Wire-End Protrusion Length	0.1~0.65mm
④	Bend-Up	3° Max	⑨ 【c】	Insulation Barrel Width	See Fig.4, 5
⑤	Bend-Down	3° Max	⑩ 【c】	Insulation Barrel Height	See Fig.4, 5

【c】. Insulation barrel crimping dimension ⑨ and ⑩ should be controlled under Fig.5 and Fig.6 not to interfere housings.

Fig 2

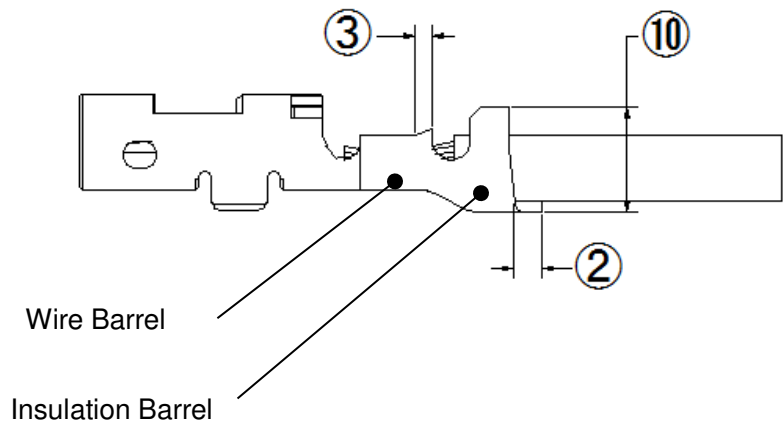
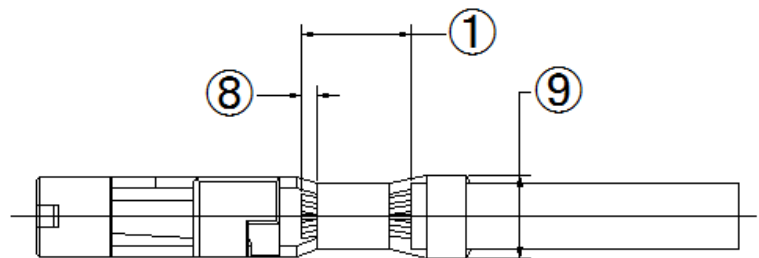


Fig 3

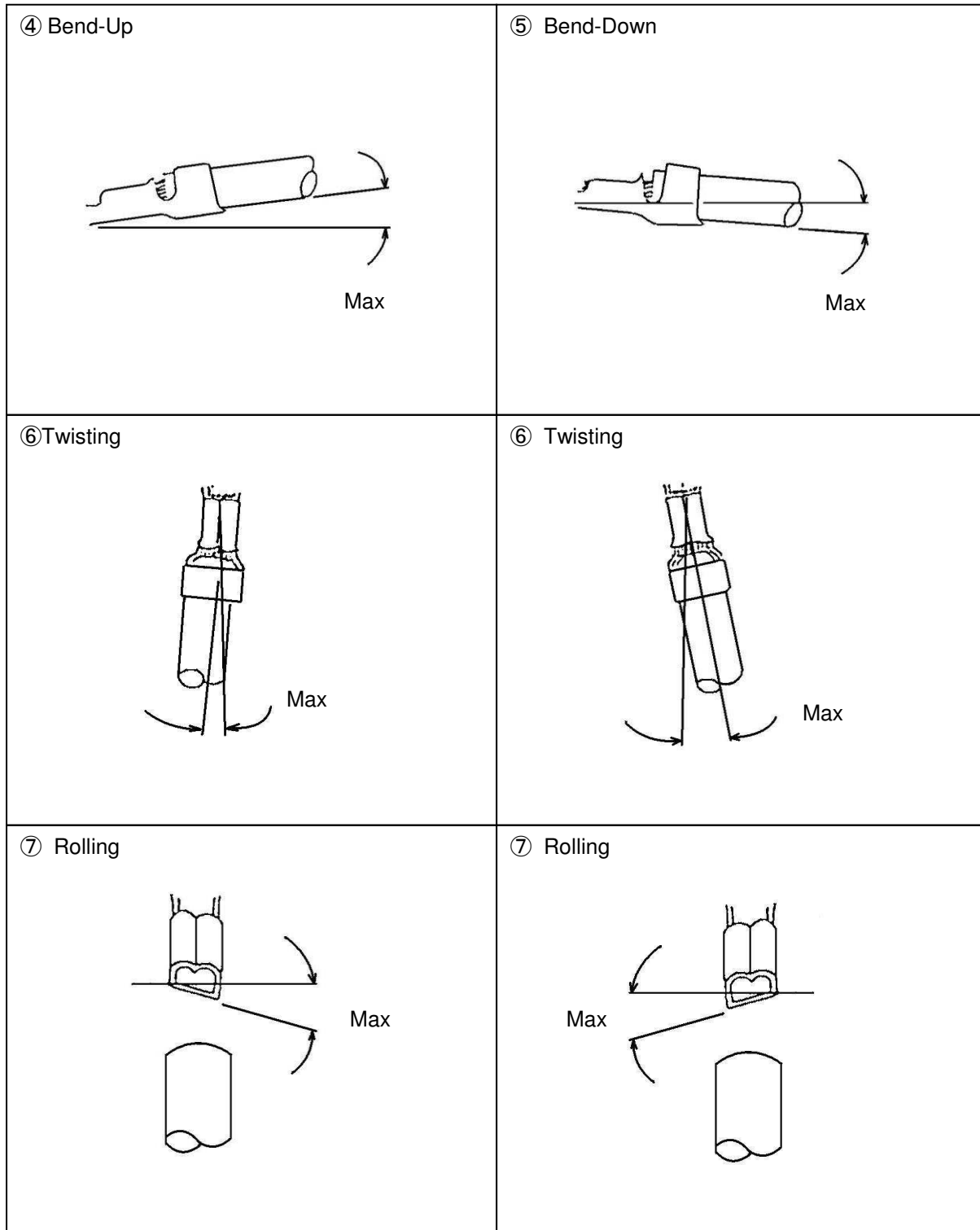


Fig.4

## 4. CRIMPING DATA

### 4.1 Applicator

See Fig.5

Reel Contact Part No	Applicator Number	Wire Size		Insulation Stripping Length [mm]	Wire Crimp		Insulation		Finished Insulation Diameter [mm]	Crimp Tensile Strength [Kg MIN]	
		No. of Conductor <b>[e]</b>	Cross Section [mm <sup>2</sup> ] (AWG) <b>[f]</b>		Width [mm]	Crimp Height [mm]	⑨ Barrel Width [mm]	⑩ Crimp Height [mm]			
<b>D1000 contact [g]</b>											
S	1827569-2 1903111-2	2151110-1	1	0.05~ 0.06(#30)	2.0±0.3	0.90 (REF)	0.54±0.03	1.5MAX " F "	1.4~ 1.8MAX	φ0.60~ φ1.20	0.5
			1	0.08~ 0.10(#28)			0.57±0.03				1.0
M	1827570-2 1871303-1 1903112-2 1903120-1 1939991-2	2151082-1	1	0.08~ 0.10(#28)	2.0±0.3	1.16 (REF)	0.64±0.03	1.5MAX " F "	1.6~ 2.2MAX	φ1.08~ φ1.60	1.0
			1	0.12~ 0.15(#26)			0.67±0.03				2.0
			1	0.21~ 0.23(#24)			0.73±0.03				3.0
			1	0.34~ 0.37(#22)			0.80±0.03				4.5
L <b>[d]</b>	1827571-2 1871304-1 1903113-2 1903121-1	2151111-1	1	0.08 0.10(#28)	2.0±0.3	1.16 (REF)	0.64±0.03	2.1MAX " F "	1.6~ 2.4MAX	φ1.08~ φ1.90	1.0
			1	0.12~ 0.15(#26)			0.67±0.03				2.0
			1	0.21~ 0.23(#24)			0.73±0.03				3.0
			1	0.34~ 0.37(#22)			0.80±0.03				4.5
2L <b>[d]</b>	1827572-2 1871731-1 1903114-2 1903122-1	2151083-1	1	0.34~ 0.37(#22)	2.0±0.3	1.40 (REF)	0.85±0.03	2.1MAX " F "	2.0~ 2.4MAX	φ1.40~ φ2.20	4.5
			1	0.51~ 0.53(#20)			1.00±0.03				6.5
			1	0.85~ 0.87(#18)			1.15±0.03				6.5
<b>D1000 Slim contact [g]</b>											
S	*-2367817-1 *-2367819-1	2151110-1	1	0.05~ 0.06(#30)	2.0±0.3	0.90 (REF)	0.49-0.55	1.5MAX " F "	1.4~ 1.8MAX	φ0.60~ φ1.20	0.5
			1	0.08~ 0.10(#28)			0.52-0.57				1.0
M	*-2367817-2 *-2367819-2	2151082-1	1	0.08~ 0.10(#28)	2.0±0.3	1.16 (REF)	0.64±0.03	1.5MAX " F "	1.6~ 2.2MAX	φ1.08~ φ1.60	1.0
			1	0.12~ 0.15(#26)			0.67±0.03				2.0
			1	0.21~ 0.23(#24)			0.73±0.03				3.0
			1	0.34~ 0.37(#22)			0.80±0.03				4.5

See Fig.5

**[d].** L and 2L size are not applicable for D1100 (2.0mm Pitch) housings

**[e].** The contacts are not applicable for crimping multi wires. The strand diameter should be over  $\phi$ 0.1mm.

**[f].** Solid wire is not applied.

**[g].** After crimped, check that the crimped sample can be inserted into the housing.

## 2 Hand Tool

See Fig.6

Loose Piece Contact Part No	Hand Tool Number	Wire Size		Insulation Stripping Length [mm]	Wire Crimp		Insulation		Finished Insulation Diameter [mm]	Crimp Tensile Strength [Kg MIN]	
		No. of Conductor <b>[i]</b>	Cross Section [mm <sup>2</sup> ] (AWG) <b>[j]</b>		Width [mm]	Crimp Height [mm]	⑨ Barrel Width [mm]	⑩ Crimp Height [mm]			
<b>D1000 contact [l]</b>											
S	1827586-2 1903115-2	2119144-1	1	0.05~ 0.06(#30)	2.0±0.3	0.90 (REF)	0.49~0.59	1.5MAX " F "	1.3(REF)	φ0.60~ φ1.00	0.5
			1	0.08~ 0.10(#28)			0.52~0.62		1.5(REF)	φ0.80~ φ1.20	1.0
M	1827587-2 1871743-1 1903116-2 1903124-1 1939992-2	2119141-1	1	0.08~ 0.10(#28)	2.0±0.3	1.16 (REF)	0.59~0.69	1.5MAX " F "	1.95(REF)	φ1.08~ φ1.40	1.0
			1	0.12~ 0.15(#26)			0.59~0.69				
			1	0.21~ 0.23(#24)			0.69~0.79		2.2(REF)	φ1.20~ φ1.90	3.0
			1	0.34~ 0.37(#22)			0.69~0.79				
L <b>[h]</b>	1827588-2 1871744-1 1903117-2 1903125-1	2119143-1	1	0.08~ 0.10(#28)	2.0±0.3	1.16 (REF)	0.59~0.69	2.1MAX " F "	2.05(REF)	φ1.08~ φ1.40	1.0
			1	0.12~ 0.15(#26)			0.59~0.69				
			1	0.21~ 0.23(#24)			0.69~0.79		2.4(REF)	φ1.80~ φ2.20	3.0
			1	0.34~ 0.37(#22)			0.69~0.79				
2L <b>[h]</b>	1827589-2 1871745-1 1903118-2 1903126-1	2119142-1	1	0.34~ 0.37(#22)	2.0±0.3	1.40 (REF)	0.80~0.90	2.1MAX " F "	2.1(REF)	φ1.40~ φ2.00	4.5
			1	0.51~ 0.53(#20)			0.80~0.90				
			1	0.85~ 0.87(#18)			1.10~1.20		2.4(REF)	φ1.80~ φ2.20	6.5
<b>D1000 Slim contact [l]</b>											
S	*-2367818-1 *-2367820-1	-[m]	1	0.05~ 0.06(#30)	2.0±0.3	0.90 (REF)	-[m]	1.5MAX " F "	1.3(REF)	φ0.60~ φ1.00	0.5
		-[n]	1	0.08~ 0.10(#28)			-[n]		1.5(REF)	φ0.80~ φ1.20	1.0
M	*-2367818-2 *-2367820-2	2381748-1 (2119141-1 with 2381710-1) <b>[k]</b>	1	0.08~ 0.10(#28)	2.0±0.3	1.16 (REF)	0.59~0.69	1.5MAX " F "	1.95(REF)	φ1.08~ φ1.40	1.0
			1	0.12~ 0.15(#26)			0.59~0.69				
			1	0.21~ 0.23(#24)			0.69~0.79		2.4(REF)	φ1.80~ φ2.20	3.0
			1	0.34~ 0.37(#22)			0.69~0.79				

Fig.6

**[h]**. L and 2L size are not applicable for D1100 (2.0mm Pitch) housings

**[i]**. The contacts are not applicable for crimping multi wires. The strand diameter should be over φ0.1mm.

**[j]**. Solid wire is not applied.

**[k]**. Apply to use D1000 Hand tool with 2381710-1 by exchange flip locator

**[l]**. After crimped, check that the crimped sample can be inserted into the housing.

**[m]**. 2119144-1 with 2381710-1 can be used for crimping if it can be crimped with crimp height 0.49-0.55 mm

**[n]**. 2119144-1 with 2381710-1 can be used for crimping if it can be crimped with crimp height 0.52-0.57 mm