Crimping of Sealed 0.50/1.0 Receptacle Contact

The performance of applicable product is guaranteed only when processed by proper application tooling and condition described in this specification and/or TE recognized ones.
No product is guaranteed when processed with the other tool or condition

1. Scope

This specification covers the requirements for crimping of Sealed 0.50/1.0 Receptacle Contact.

2. Applicable Contacts

TE Part numbers *	Name	Applicable Wires	Finish
1939349	0.50 Receptacle Contact	AVSS/AVSSH / AESSX 0.3 mm^2	Pre-Tin
1939350			Selective Gold
1939349	0.50 Receptacle Contact	AVSS/AVSSH / AESSX 0.5 mm^2	Pre-Tin
2069401			Selective Gold
1981878	0.50 Receptacle Contact	CAN 0.22 mm^2	Pre-Tin
1939351	1.0 Receptacle Contact	AVSSH / AESSX 0.75～1.25 mm^2 AVSS 0.85～1.25mm^2	Pre-Tin

NOTE ＊Note: Parts number is consisted from listed base number and 1 digit numeric prefix and suffix with dash. Refer to catalog or customer drawing for specific part numbers for each base number. When prefix is zero, zero and dash are omitted.

3. Nomenclature

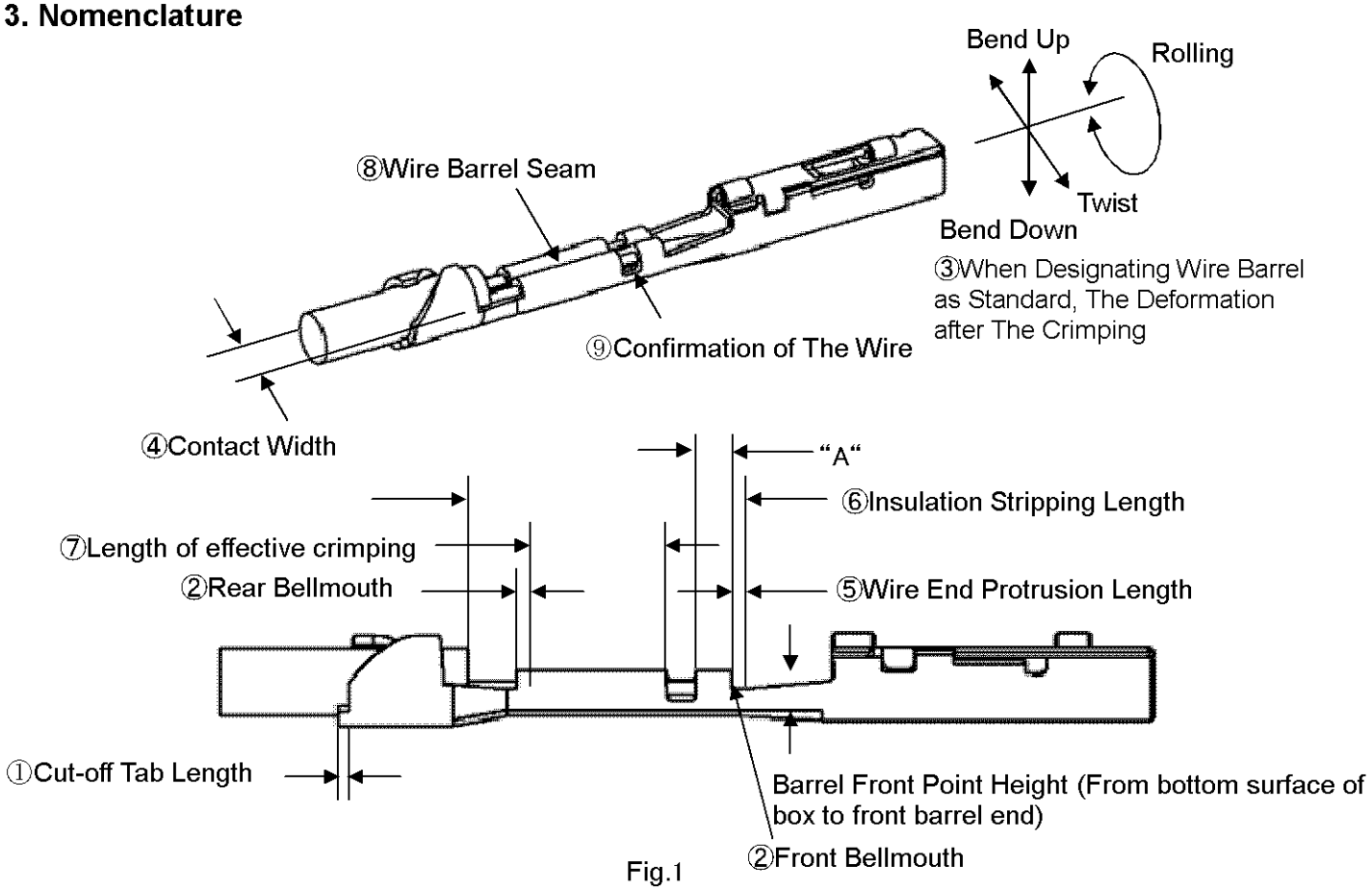

Fig.1

4. Crimping Condition

Applicator Crimp

Applicator Crimp \ Applicable Contacts			0.50 Receptacle Contact				1.0 Receptacle Contact	Remarks
			1939349	1939350	1981878	2069401	1939351	
1	Cut-off Tab Length		0.25mm Max.					Fig.1-①
2	Bellmouth	Front	0mm Max.					Fig.1-②
		Rear	0.2～1.0mm					
3	When Designating Wire Barrel as Standard, The Deformation after The Crimping	Bend	±3° Max.					Fig.1-③
		Twist	±4° Max.					
		Rolling	±10° Max.					
4	Contact Width after Crimping		1.95mm Max.				2.35mm Max.	Fig.1-④
5	Wire End Protrusion Length		Thing that 0mm or less and wire end is put in "A" area of Fig.1.					Fig.1-⑤
6	Insulation Stripping Length (Before the Crimping) (2)		4.8～5.3mm					Fig.1-⑥
7	Length of effective crimping(1)		2.0mm					Fig.1-⑦
8	Wire Barrel Seam		Seam must be closed. (No strand looses out of the seam)					Fig.1-⑧
9	Insulated coating advanced position		You can verify the wire with visual inspection the wire barrel.					Fig.1-⑨

NOTE (1) Crimping height has gone into standard in the designated range

(2) Insulation coating of the wire which you use is smooth. When crimping do not use any which have the damage and deformation on the insulated coating surface

5. Crimp Data

Applicator Crimp

Contact Part Number	Wire Size (Nominal)	Applicator Part Number	Wire Barrel Crimp (mm)				Insulation Barrel Crimp (mm)		Crimp Tensile Strength (N)Min. (4)
			Width (3)	Height	Barrel Front Point Height	Disk Ltr.	Width(3)	Height	
1939349 1939350	0.3 0.3f	1891707-2	1.4 "F"	0.79 (2)	1.09 MAX	B	1.78 "O"	Refer to Section 6	50
1939349 2069401	0.5 0.5f			0.88 (2) 0.91 (2)		A			80
1981878	CAN 0.22	1999136-2	1.16 "F"	0.73 (2)	1.09 MAX	A	1.78 "O"	Refer to Section 6	30
1939351	0.75f	1891706-2	1.78 "F"	1.09 (1)	1.45 MAX	C	2.19 "O"	Refer to Section 6	100
	0.85			1.12 (1)		B			130
	1.25 1.25f			1.20 (1)		A			175

NOTE (1) Wire Barrel Crimp Height to be within ±0.05mm.

(2) Wire Barrel Crimp Height to be within ±0.03mm.

(3) Crimp Width dimensions are not the product width after crimping, but given by the width of crimper slot for reference.

(4) The wire grip of insulation barrel crimp.

6. Crimp Data of Insulation Barrel

Contact Part Number	Wire Size (Nominal)	AVSSH/AESSX Height (mm) (1)	CAN Height (mm) (1)	AVSS Height (mm) (1)
1939349	0.3	—	—	1.7
1939350	0.3f	1.7	—	—
1939349	0.5	—	—	1.85
2069401	0.5f	1.85	—	—
1981878	CAN 0.22	—	1.7	—
1939351	0.75f	2.15	—	—
	0.85	—	—	2.15
	1.25	—	—	2.4
	1.25f	2.4	—	—

NOTE (1) Insulation Barrel Crimp Height to be within ±0.1mm

7. Applicable Wire Data

Wire Size		Number /Diameter (mm) of Conductor (mm)	Calculated Cross sectional Area (mm^2)	Insulation Diameter (mm)	
Nominal	Classification			STD.	Max.
CAN 0.22	CAN	7/ Compressed	0.2199	1.4	1.5
0.3	AVSS	7/0.26	0.3716	1.4	1.5
0.3f	AVSSH/AESSX	19/0.16	0.3821	1.4	1.5
0.5	AVSS	7/0.32	0.5629	1.6	1.7
0.5f	AVSSH/AESSX	19/0.19	0.5387	1.6	1.7
0.75f	AVSSH/AESSX	19/0.23	0.7894	1.8	1.9
0.85	AVSS	19/0.24	0.8595	1.8	1.9
1.25	AVSS	19/0.29	1.255	2.1	2.2
1.25f	AVSSH/AESSX	37/0.21	1.2815	2.1	2.2

NOTE (1) Each applicable wire of the contact refer to section 6

(2) Because there are times when the application applicable wire is restricted by the connector which is used, follow the specification of each connector or the indication of the instruction manual.