

**THERMOCOUPLE CONNECTOR CRIMP TYPE****1. SCOPE****1.1. Contents**

This specification covers the requirements for crimping procedure of Thermocouple Connector Series. Crimp-in Type receptacle and tab contacts.

**2. APPLICABLE CONTACTS**

Contact Type	Name	Contact features	Contact Part No.	Wire Sizes (AWG)
Receptacle Contact	THERMOCOUPLE CONNECTOR RECEPTACLE CONTACT ASSY CHROMEL	Loose Piece	1-2304815-1	AWG#25~AWG#22
	THERMOCOUPLE CONNECTOR RECEPTACLE CONTACT ASSY ALUMEL	Loose Piece	2-2304815-1	AWG#25~AWG#22
Tab Contact	THERMOCOUPLE CONNECTOR TAB CONTACT ASSY CHROMEL	Loose Piece	1-2304777-1	AWG#25~AWG#22
	THERMOCOUPLE CONNECTOR TAB CONTACT ASSY ALUMEL	Loose Piece	2-2304777-1	AWG#25~AWG#22

### 3. NOMENCLATURE AND CRIMPING FEATURES

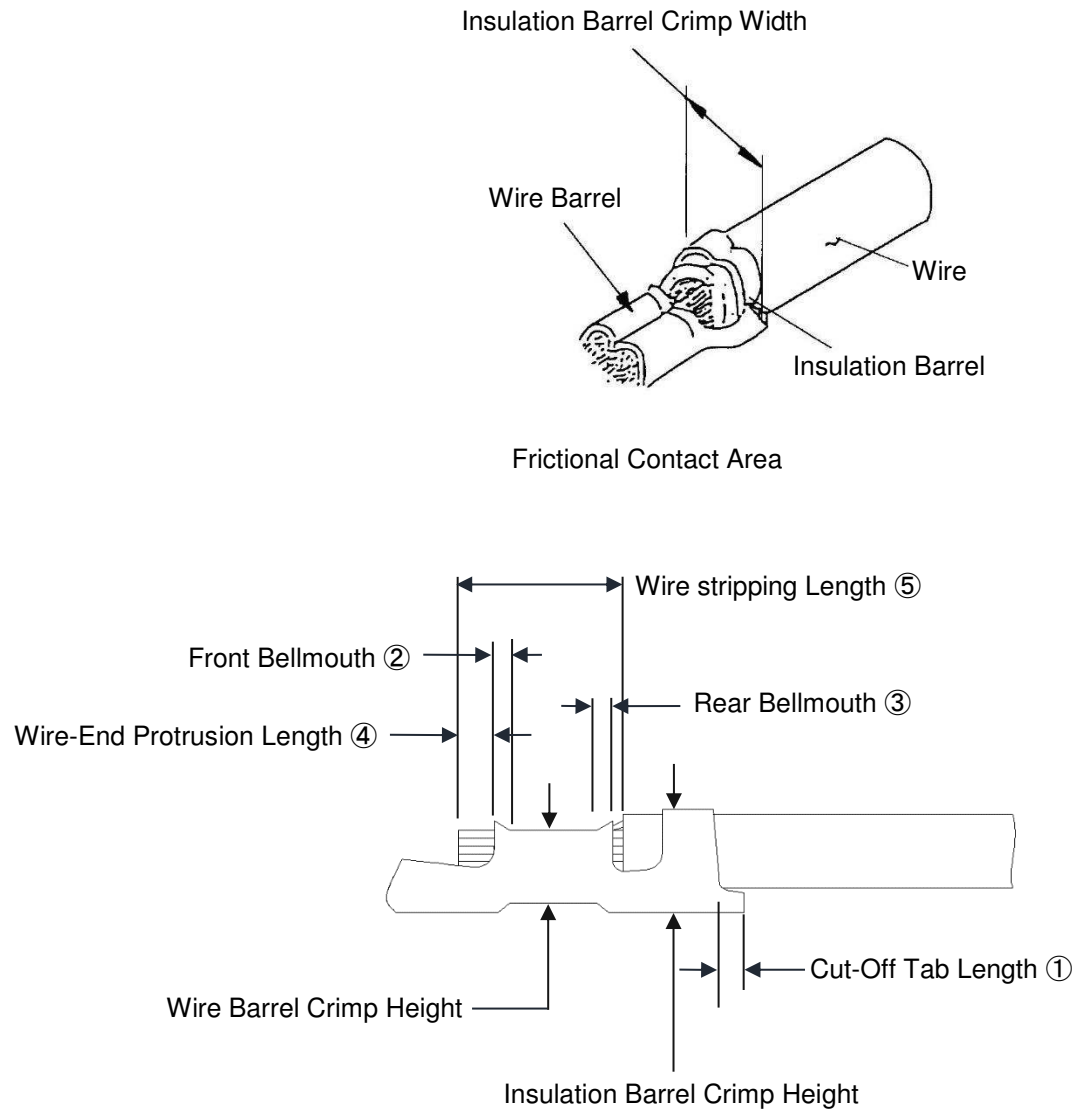


Fig. 1 (Continue)

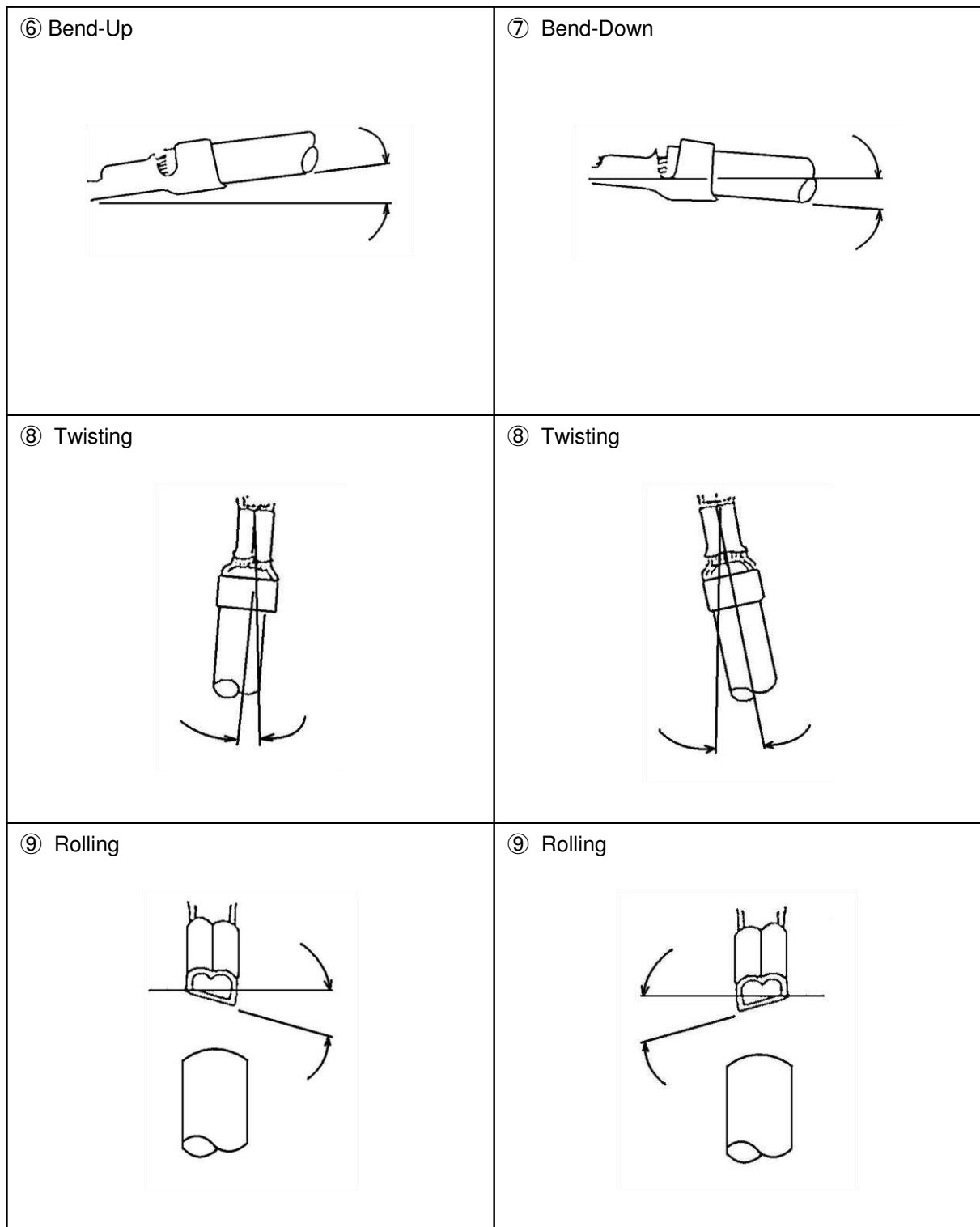


Fig. 1(Continue)

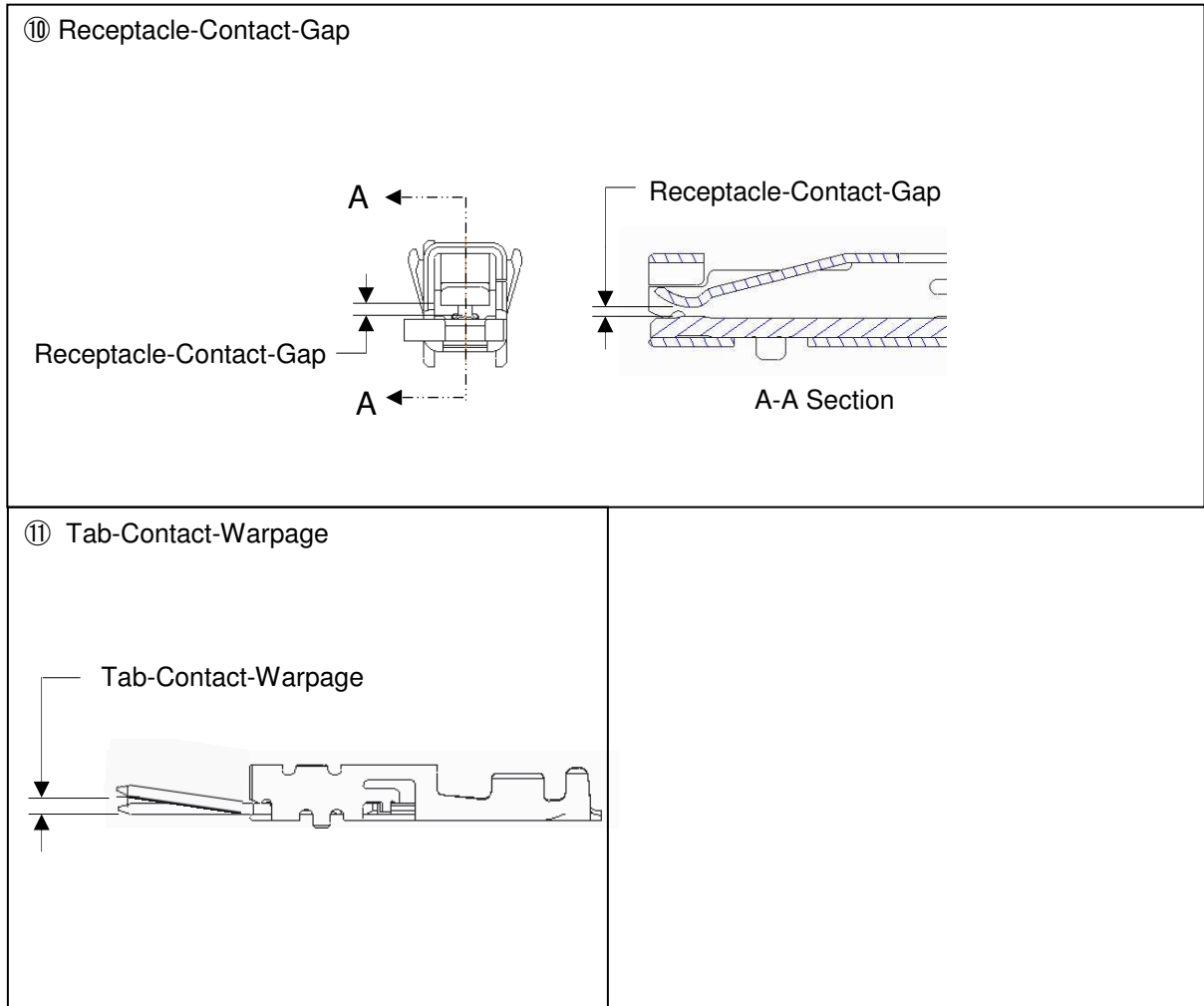


Fig. 1(End)

## 4. CRIMPING CONDITIONS AND CRIMP DATA

### 4.1. Crimping Condition

No.	Checking Items		Requirements	Remarks
1.	Allowable Deformation after Crimping	Bend-Up	5°Max.	Fig.1 ⑥
		Bend-Down	1°Max.	Fig.1 ⑦
		Twisting	5°Max.	Fig.1 ⑧
		Rolling	5°Max.	Fig.1 ⑨
2.	Cut-Off Tab Length		0.5mm Max.	Fig.1 ①
3.	Bellmouth	Front	0~0.35 mm	Fig.1 ②
		Rear	0.1~0.7 mm	Fig.1 ③
4.	Wire-End Protrusion Length		0.1~1.7 mm	Fig.1 ④
5.	Wire Stripping Length		3.5~4.1 mm	Fig.1 ⑤
6.	Receptacle-Contact-Gap		0.3mm Max	Fig.1 ⑩
7.	Tab-Contact-Warpage		0.2mm Max	Fig.1 ⑪

## 4.2. Crimp Data

### 4.2.1. Hand Tool Crimp

Contact Part No (Loose Piece)	Hand Tool No	Wire Size [mm <sup>2</sup> ] 【e】	Insulation Diameter [mm] 【d】	Crimp Height		Tensile Strength [N] Min
				Wire Barrel [mm]	Insulation Barrel(REF) [mm]	
1-2304815-1 2-2304815-1	2318602-1	0.178	0.84~1.1	1.09 $\pm$ 0.03	1.6	24.5
1-2304777-1 2-2304777-1		0.305	1.1~1.5	1.26 $\pm$ 0.03	1.75	44.1

- 【a】. Maximum finished insulation diameter of the applicable wire is shown above. (See 5<sup>th</sup> section)  
Do not use cable whose insulation diameter is out of specification. When using the over or under size insulation, retention condition of insulation barrel might be not appropriate.
- 【b】. Do not use wires which are out of specification. When using the over or under size wire, crimping condition may become over or under crimp.

## 5. APPLICABLE WIRES

Wire Size (nominal)	Number of Conductors/ Diameter of a conductor	Calculated crosssectional Area [mm <sup>2</sup> ]	Finished Insulation Diameter [mm]	Wire Specification
0.178 mm <sup>2</sup> (AWG#25)	0.18X7	0.178	0.84~1.1	-
0.305 mm <sup>2</sup> (AWG#22)	0.18X12	0.305	1.1~1.5	-

Note: For the wire with large insulation diameter, tooling marks might be left on the insulation after crimping.