

1. Scope :

This specification covers the requirements for crimping of 2.5mm pitch HPI (High Performance Interconnect Wire-To-Board System) Connector (Crimp Type) for applicator and manually operated hand tool.

2. Applicable Connectors

Contact Form	Product Part Number	Crimping Tool	Wire Size (SQmm)	Ins. Diameter (mm)
Strip Terminal	440134-1	Applicator	0.08 ~ 0.30mm ² (AWG #28 ~ #22)	ϕ 1.0 ~ ϕ 1.9mm

3. Nomenclature

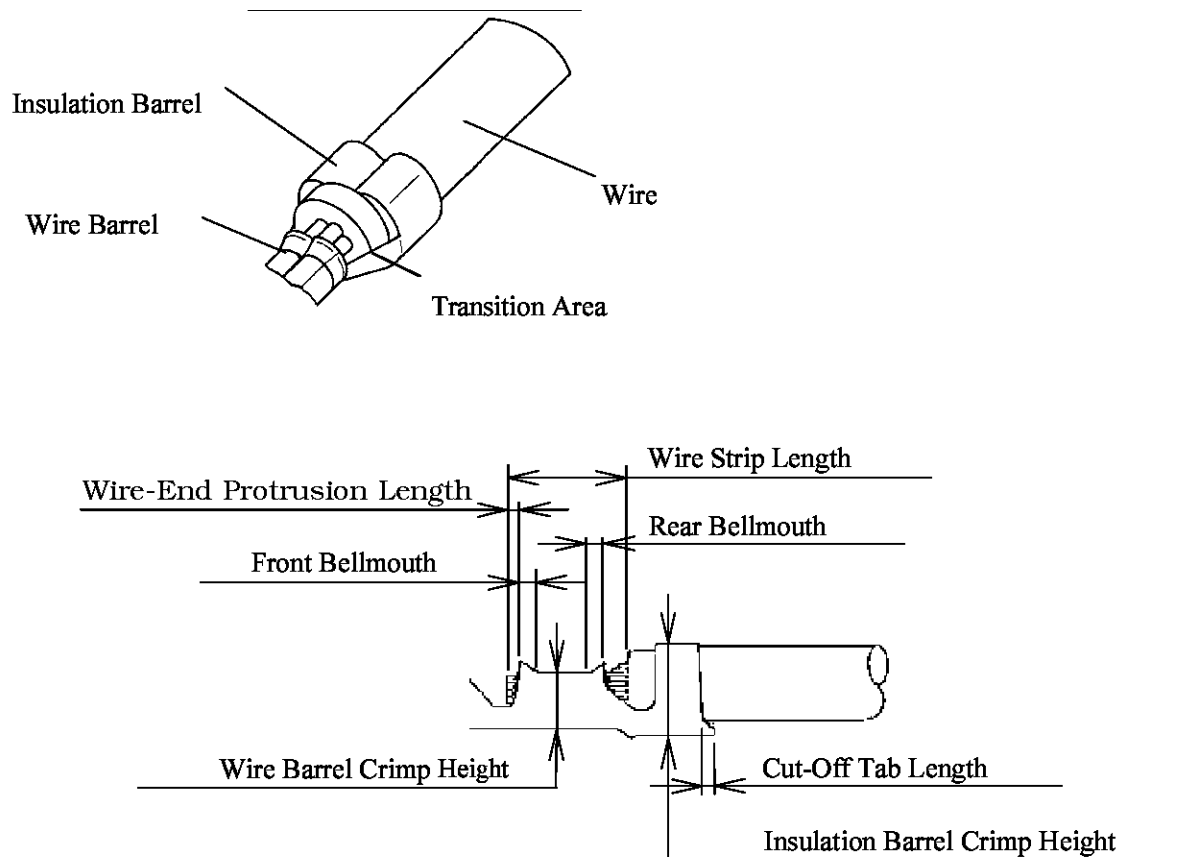
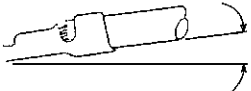
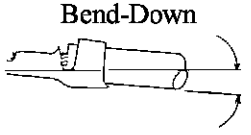
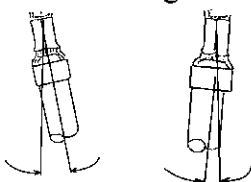
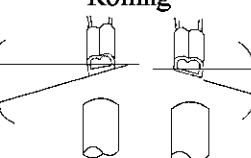


Fig.1

4 · Crimping Requirement

No.	Check Items		Crimping Requirements		Remarks
			Applicator	Hand Tool	
1	Wire Strip Length		1.9 ~ 2.5 mm		Fig.1 —
2	Wire-End Protrusion Length		0.3 ~ 0.6 mm		Fig.1 —
3	Cut-Off Tab Length		0 ~ 0.5 mm		Fig.1 —
4	Bellmouth	Front	Front bellmouth can be visible.		Fig.1 —
		Rear	0.1 ~ 0.3 mm		Fig.1 —
5	Wire Barrel Crimp		Refer Table.1		Fig.1 —
6	Insulation Barrel Crimp Height		Refer Table.1		Fig.1 —
7	Allowable Deviation after Crimping	Bend-Up 	6° Max.	6° Max.	
8		Bend-Down 	6° Max.	6° Max.	
9		Twisting 	5° Max.	5° Max.	
10		Rolling 	7° Max.	7° Max.	

Tool mark is allowable at crimped areas and transition areas only.

5 · Crimping Data

Table.1

Contact Part Number	Applicator Part Number	Wire Size		Insulation Strip Length	Wire Barrel		Insulation Barrel	Finished Insulation Diameter
		Number of Wire	Size		Crimp Width	Crimp Height	Crimp Height	
440134-1	1463115-2	1	0.30mm ² (#22)	1.9~ 2.5mm	1.4mm "F"	0.75±0.05mm	1.8mm Max.	φ1.0mm
		1	0.22mm ² (#24)			0.70±0.05mm		φ1.1mm
		1	0.14mm ² (#26)			0.65±0.05mm		φ1.2mm
		1	0.08mm ² (#28)			0.60~0.65mm		φ1.9mm

Table.2

Wire Size		Crimp Tensile Strength
mm ²	AWG	N (kgf) Min.
0.30	22	49.0 (5.0)
0.22	24	29.4 (3.0)
0.14	26	19.6 (2.0)
0.08	28	9.8 (1.0)

Note

1. Tool mark is allowable at crimped areas and transition areas only.
2. The dimensions of crimp width of wire barrel and insulation barrel are the dimensions of crimping tool.

6 · Example of Applicable wire

Table.3

Wire Size	Insulation Diameter (mm)	Applicable Wire
AWG#28~22	1.0~1.9	UL-1007

All wires, including the above mentioned, need to be approved prior to usage.

7 · Validation

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O	Released (FW00-0059-00)	27-OCT-00			
LTR	Revision Record	Date	Prepared.by	Reviwed by	Approved by