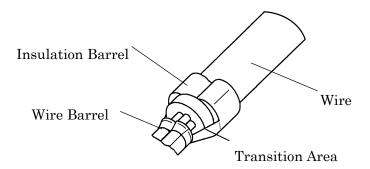
1. Scope:

This specification covers the requirements for crimping of 2.0mm 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 (SQ mm)	Ins. Diameter (mm)
Strip Terminal	440132-1 1735801-1	Applicator	$0.05 \sim 0.22 \text{mm}^2$ (AWG #30 \sim #24)	$\varphi 0.9 \sim \ \varphi 1.5$ mm

3. Nomenclature



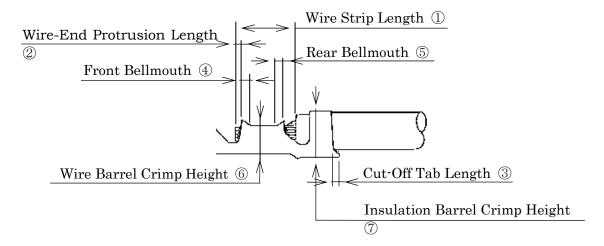


Fig.1

4. Crimping Requirement

No.	Check Items		Crimping R	Remarks		
1			Applicator	Hand Tool 2.5 mm	Fig 1_(1)	
1	Wir	e Strip Length			Fig.1-①	
2	Wire-End	l Protrusion Length	0.3 ~	0.6 mm	Fig.1-2	
3	Cut-	Off Tab Length	0 ~ 0.	$0 \sim 0.5$ mm		
4		Front	Front bellmout	h can be visible.	Fig.1-4	
4	Bellmouth	Rear	0.1 ~	0.3 mm	Fig.1-5	
5	Wire	e Barrel Crimp	Refer '	Γable.1	Fig.1-6	
6		ulation Barrel	1.7 mm Max. (Measure by	y Insulation Barrel area)	Fig.1-7	
7	Insulation	Barrel Crimp Height	Refer Table.1		Fig.1-8	
8		Bend-Up	6° Max.	6° Max.		
9		Bend-Down	6° Max.	6° Max.		
10	Allowable Deviation after Crimping	Twisting	5° Max.	5° Max.		
11		Rolling	7° Max.	7° Max.		

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

AMP 2.0mm Pitch HPI High Performance Interconnect (Low Cost) Wire-To-Board System

5. Crimping Data

Table.1

		Wire Size		Wire		e Barrel	Insulation Barrel	
Contact Part Number	Applicator Part Number	Number of Wire	Size	Insulation Strip Length	Crimp Width	Crimp Height	Crimp Height	Finished Insulation Diameter
		1	0.22mm ² (#24)	1.9~ 2.5mm		0.62~0.67mm		arphi0.9mm
440132-1	1463116-2	1	0.14mm ² (#26)		1.32mm "F"	0.57~0.62mm	1.7mm Max.	}
1735801-1		1	0.08mm ² (#28)			0.55~0.60mm		φ 1.5mm
		1	0.05mm2 (#30)			0.52~0.57mm		

Table.2

Wire	e Size	Crimp Tensile Strength
mm^2	AWG	N (kgf) Min.
0.22	24	29.4 (3.0)
0.14	26	19.6 (2.0)
0.08	28	9.8 (1.0)
0.05	30	7.8 (0.8)

$\underline{\text{Note}}$

- 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 crimpting tool.

6. Example of Applicable wire

Table.3

Wire Size	Insulation Diameter (mm)	Applicable Wire
AWG#30~24	0.9~1.5	UL-1007

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



AMP 2.0mm Pitch HPI High Performance Interconnect (Low Cost) Wire-To-Board System

 $\begin{array}{c} {\rm Application\ Specification} \\ {\rm 114\text{-}57011\ Rev.\ C} \end{array}$

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Approved by : Jebb Wu

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