

**Pitch 1.25mm,  
Economic Metric Interconnect Series,  
Wire-To-Board System.**

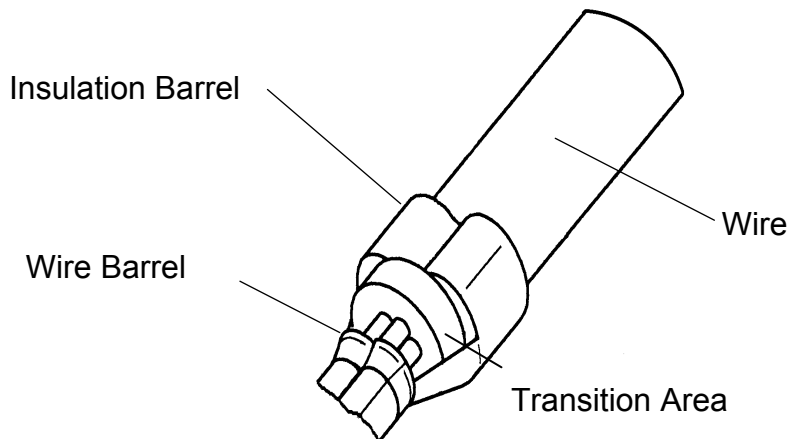
**1. SCOPE**

This specification covers the requirements for crimping of Pitch 1.25mm, Economic Metric Interconnect Series, Crimp Type, Wire-To-Board System Connector. These requirements are applicable to specific tools. For specific wire and products covers in this specification refer to the appropriate Tyco customer drawing.

**2. APPLICABLE PRODUCT**

Contact Form	Product Part Number	Crimping Tool	Wire Size (SQ mm)	Ins. Diameter (mm)
Strip Terminal	X-440147-X	Applicator	0.03 ~ 0.08mm <sup>2</sup> (AWG #32 ~ #28)	$\varphi$ 0.9 ~ $\varphi$ 1.0mm

**3. NOMENCLATURE**



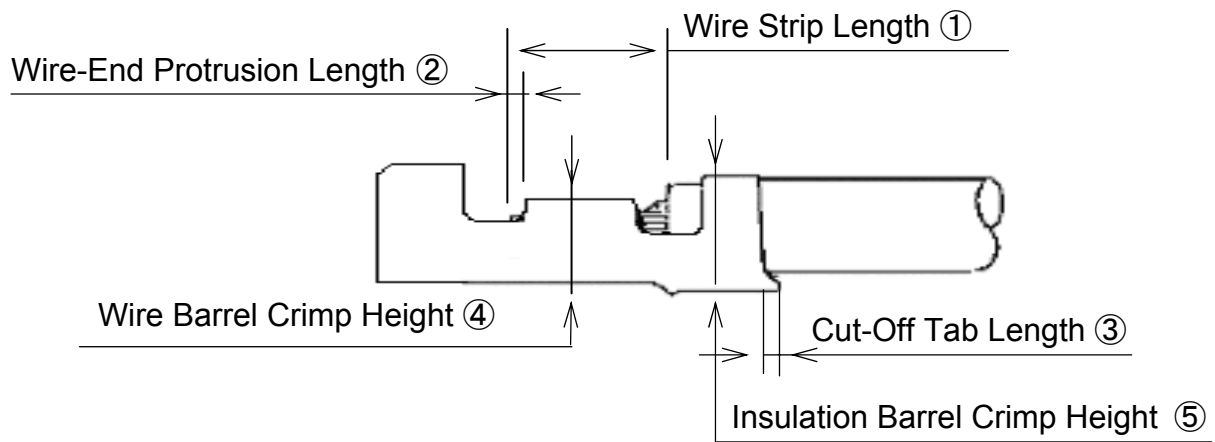
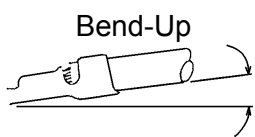
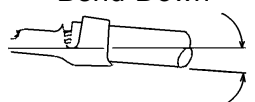
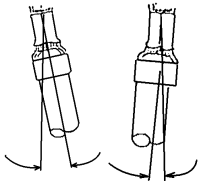
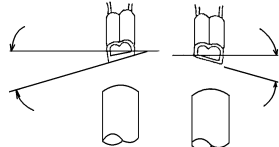


FIG 1.

4. CRIMPING REQUIREMENT

No.	Check Items	Crimping Requirements		Remarks	
		Applicator	Hand Tool		
1	Wire Strip Length	0.9 ~ 1.3 mm		Fig.1 – ①	
2	Wire-End Protrusion Length	0.1 ~ 1.3 mm		Fig.1 – ②	
3	Cut-Off Tab Length	0.0 ~ 0.2 mm		Fig.1 – ③	
4	Wire Barrel Crimp	Refer Table.1		Fig.1 – ④	
5	Insulation Barrel Crimp Height	Refer Table.1		Fig.1 – ⑤	
6	Allowable Deviation after Crimping	 <p>Bend-Up</p>	6° Max.	6° Max.	
7		 <p>Bend-Down</p>	6° Max.	6° Max.	

8		<p>Twisting</p> 	5° Max.	5° Max.	
9		<p>Rolling</p> 	7° Max.	7° Max.	

5. CRIMPING DATA

Table.1

Contact Part Number	Applicator Part Number	Wire Size		Insulation Barrel		Wire Barrel	
		Number of Wire	Size	Crimp Height (A)	Crimp Width (B)	Crimp Height (C)	Crimp Width (D)
X-440147-X	N/A	1	0.08mm <sup>2</sup> (#28)	1.25mm	0.9~1.0mm	0.51~0.56mm	0.80mm
		1	0.05mm <sup>2</sup> (#30)	1.17mm	0.9~1.0mm	0.48~0.53mm	0.80mm
		1	0.03mm <sup>2</sup> (#32)	1.00mm	0.9~1.0mm	0.46~0.51mm	0.80mm

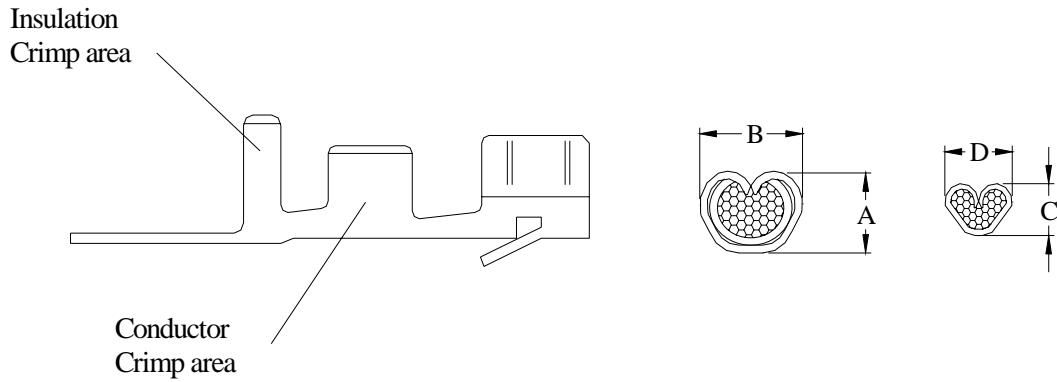


Table.2

Wire Size		Crimp Tensile Strength
MM <sup>2</sup>	AWG#	N (kgf) Min.
0.08	28	14.7 (1.5)
0.05	30	9.80(1.0)
0.03	32	4.90(0.5)

- Note: (a) Tool mark is allowable at crimped areas and transition areas only.  
 (b) The dimensions of crimp width of wire barrel and insulation barrel are the dimensions of crimping tool.