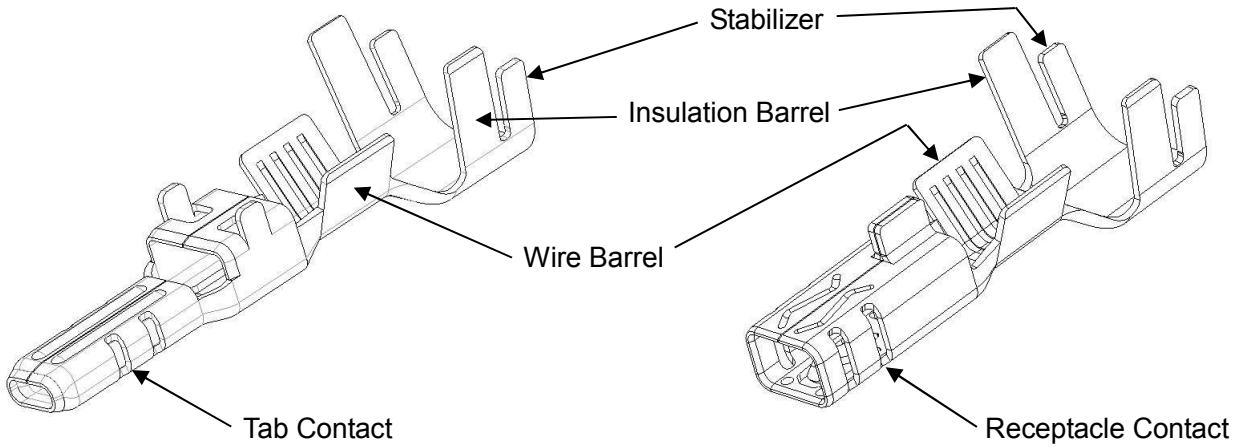


## Double Wire Crimping of Power Triple Lock Contact

### 1. Introduction

This specification covers the crimping requirements for Hybrid Pitch 20 Position connector.



**Figure 1**

### 2. Applicable Contact Part Numbers

Contact Type	Base Part No.
Tab Contact	2232498
Receptacle Contact	2232499

**Figure 2**

### 3. Applicable Wires

Wire Specification	Wire Size	Wire Strand Composition (No./Dia.)	Insulation Diameter (mm)
UL 1015	20 AWG	26 / 0.16	2.52
UL 1015	18 AWG	41 / 0.16	2.76
IEC VSF	0.5 mm <sup>2</sup>	20 / 0.18	2.37
IEC VSF	0.75 mm <sup>2</sup>	30 / 0.18	2.50

**Figure 3**

#### 4. Reference Material

##### 4.1 Drawings

Customer Drawings for product part numbers are available from the service network. If there is a conflict between the information contained in the Customer Drawings and this specification or with any other technical documentation supplied, the information contained in the Customer Drawings takes priority.

##### 4.2 Specifications

Product specification 108-61192 provides expected product performance requirements and test information.

#### 5. Storage Requirements

##### A. Ultraviolet Light

Prolonged exposure to ultraviolet light may deteriorate the chemical composition used in the product material.

##### B. Shelf Life

Each contact is packaged and shipped in an individual antistatic tube container or tape and reel. The product should remain in the shipping containers until ready for use to prevent deformation to components. The product should be used on a first in, first out basis to avoid storage contamination that could adversely affect performance.

##### C. Chemical Exposure

Product must not be stored near any chemical listed below as they may cause stress corrosion cracking in the material.

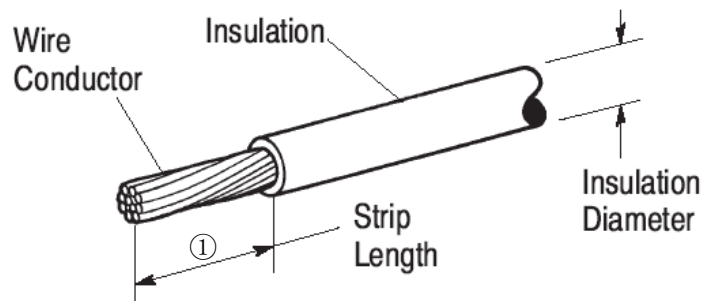
Alkalies	Ammonia	Citrates	Phosphates Citrates	Sulfur Compounds
Amines	Carbonates	Nitrites	Sulfur Nitrites	Tartrates

Note: Contacts that contain brass must not be stored or used in environments where these chemicals exist.

### 6. Crimping Requirements

NO.	Check Item	Specified Requirements	NO.	Check Item	Specified Requirements
①	Wire Stripping Length	4.5mm±0.3	⑧	Twisting/ Rolling	5° Max
②	Cut-Off Tab Length	0.5mm Max	⑨	Cutoff Tab Flash	0.13mm Max
③	Front Bellmouth Length	0.3mm Max.	⑩	Wire-End Extrusion	0.1~1.5mm.
④	Rear Bellmouth Length	0.2~0.5mm	⑪	Wire Barrel Flash	0.30mm Max
⑤	Bend – Up	3° Max	⑫	Length Growth (After Crimping)	0.5mm Max
⑥	Bend – Down	3° Max	⑬	Stabilizer Width at the Top (After Crimping)	5.2 ~ 5.8mm
⑦	Side to Side Bend	3° Max			

**Figure 4**



**Figure 4 (Cont'd)**

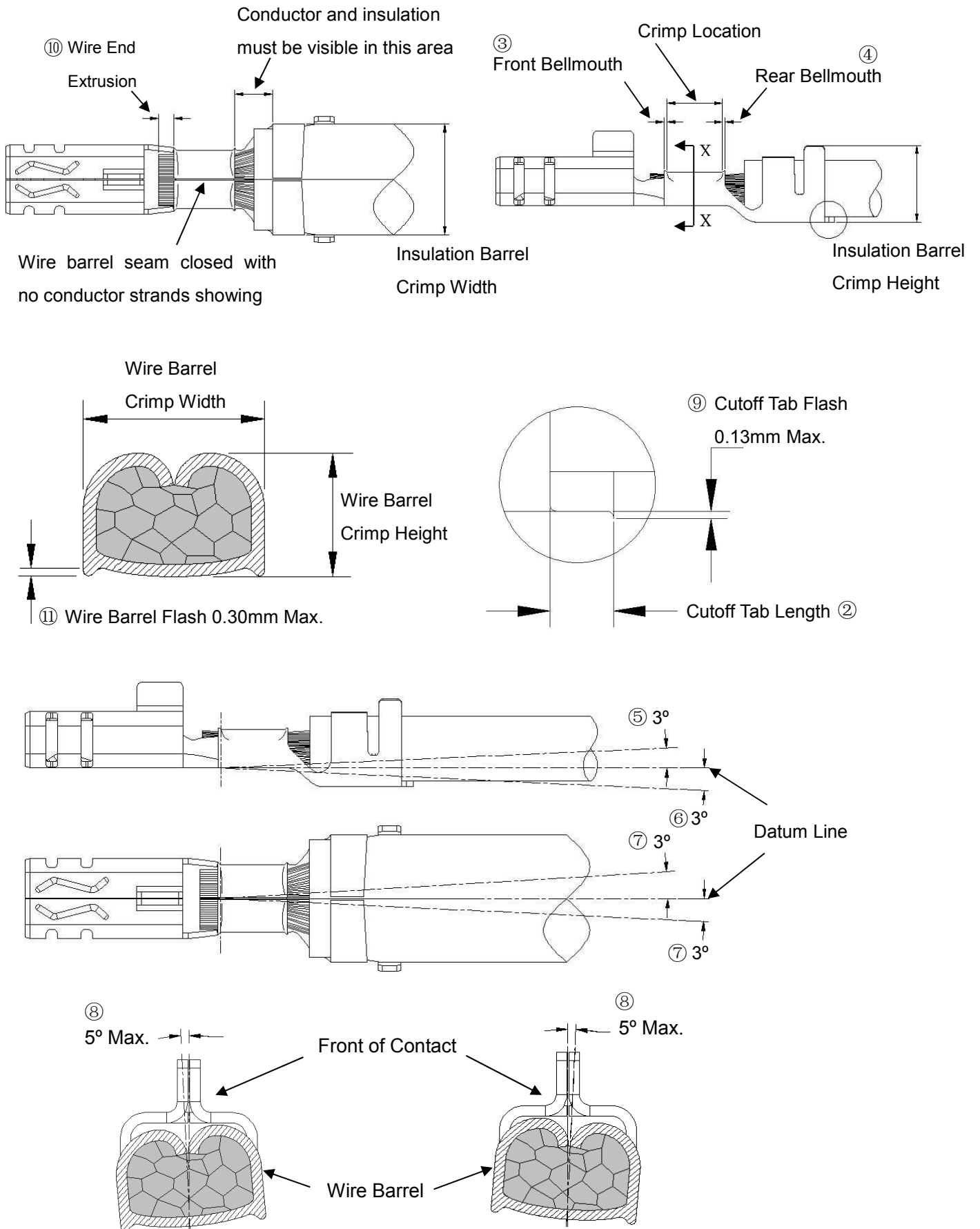
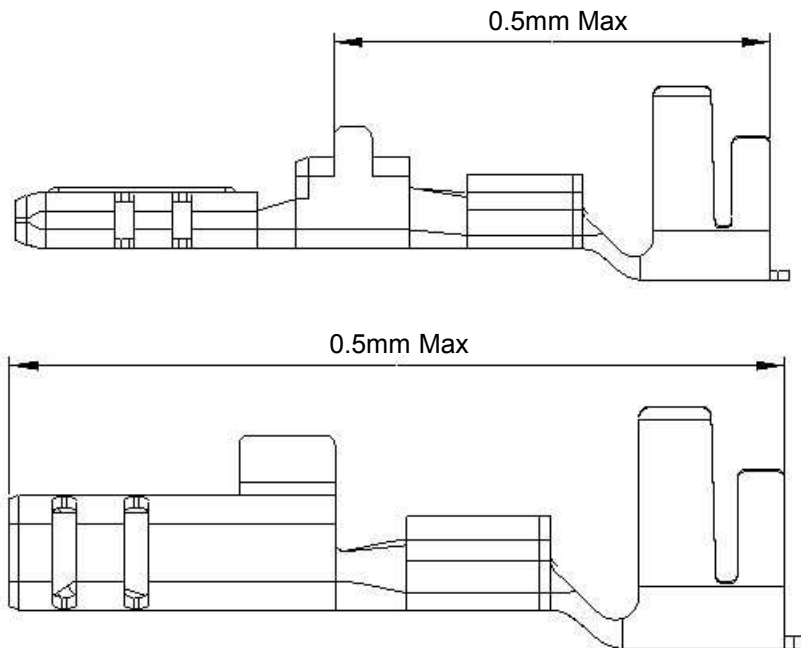


Figure 4 (Cont'd)

### ⑫ Length Growth (After Crimping)



### ⑬ Stabilizer Width at the Top (After Crimping)

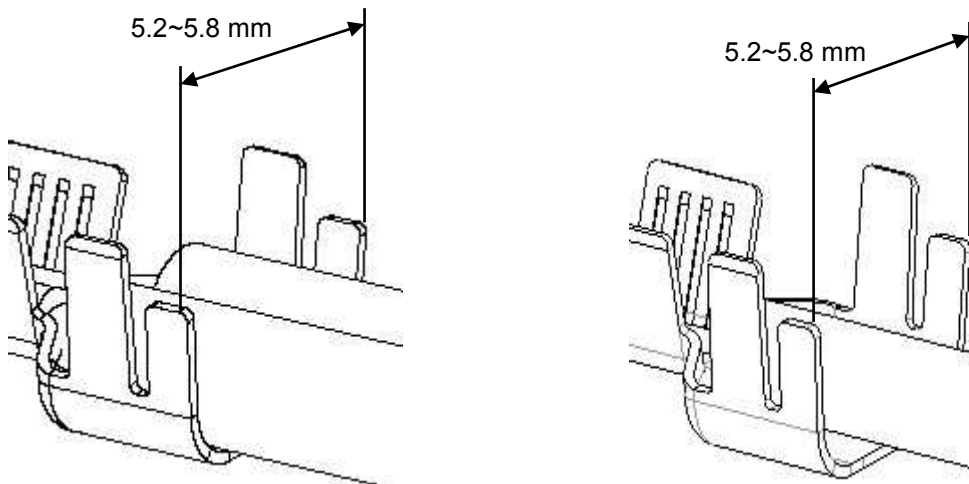


Figure 4 (End)

## 7. Crimping Data

### 7.1 Applicator

Contact P/N (Strip)	Applicator P/N (Spare Kit P/N)	Wire size			Insulation Stripping Length (mm)	Insulation Diameter (mm)	Wire Barrel Crimp			Insulation Barrel Crimp	
		No.of Conductor	mm <sup>2</sup> (AWG#) single conductor	Spec			Width (mm)	Crimp Height (mm)	Tensile strength N(kgf) Min.	Width (mm)	Crimp Height (mm) Ref.
2232498-1	2266157-1	2 Note 1)	0.5 (#20)	VSF UL1015	4.5±0.3	2.37 2.52	2.29 "F"	1.18 ±0.04	58.8 (6.0)	5.2 "F"	2.9
2232499-1	(7-2266157-7 )		0.75	VSF		2.5		1.36 ±0.05	89.0 (9.1)		3.0
			0.83 (#18)	UL1015		2.76		1.40 ±0.05	89.0 (9.1)		3.1

**Figure 5**

Note:

- 1) When crimping 2 wires laid side by side, the strands shall be pinched together and stretched away without twisting in order to not only prevent strands stick out but also to ensure all strands are narrower than the top width of the opened wire barrel.

#### 8. Specification Approval

Prepared by,

SC KIM

Product Engineer

Checked By,

BH CHO

Senior Product Engineer

Approved by,

BW KANG

Product Engineering Manager