Crimping of 187 Positive Lock Receptacle MK-II for 0.8T Tab (Heat Resistant)

1. Introduction

This specification covers the requirements for crimping of 187 Positive Lock Receptacle MK-II for 0.8T Tab (Heat Resistant) crimped by TE applicator.

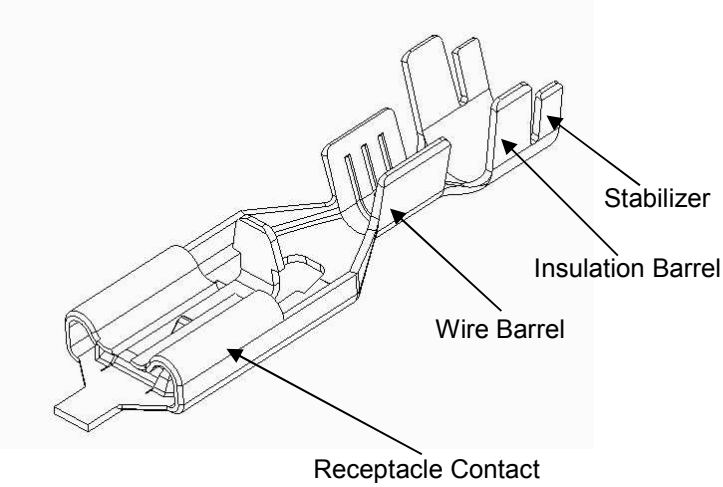

Fig. 1

2. Applicable Products

Description	P/N	Wire Size (mm^2)	Insulation Diameter (mm)	Contact Form
Receptacle Contact	2297529-1	AWG #22~#20 (0.34~0.53)	Ø1.56~2.15	Strip

Table 1

3. Reference Material

3.1 Drawings

The information contained in Customer Drawings takes priority if there is a conflict with this specification or with any technical documentation supplied by TE Connectivity.

3.2 Specifications

Product Specification 108-61158 provides expected product performance requirements and test information.

4. Crimping Requirements

4.1 Crimping Conditions

No	Check Points		Requirements	Remarks
1	Allowable Limits Deformation After Crimping	Bend-Up	5º max	Fig. 2 (1)
		Bend-Down	5º max	Fig. 2 (2)
		Twist	5º max	Fig. 2 (3)
		Rolling	15º max	Fig. 3 (4)
2	Cut-off Tab Length		0.5mm Max	Fig. 4 (5)
3	Front Bellmouth		0.7mm Max	Fig. 4 (6)
4	Rear Bellmouth		0.2~0.7mm	Fig. 4 (7)
5	Wire End Protrusion Length		Wire end must protrude from front end of wire barrel, but not exceed 1.2mm	Fig. 4 (8)
6	Insulation Stripping Length		Refer to Table 3	Fig. 4 (9)

Table 2

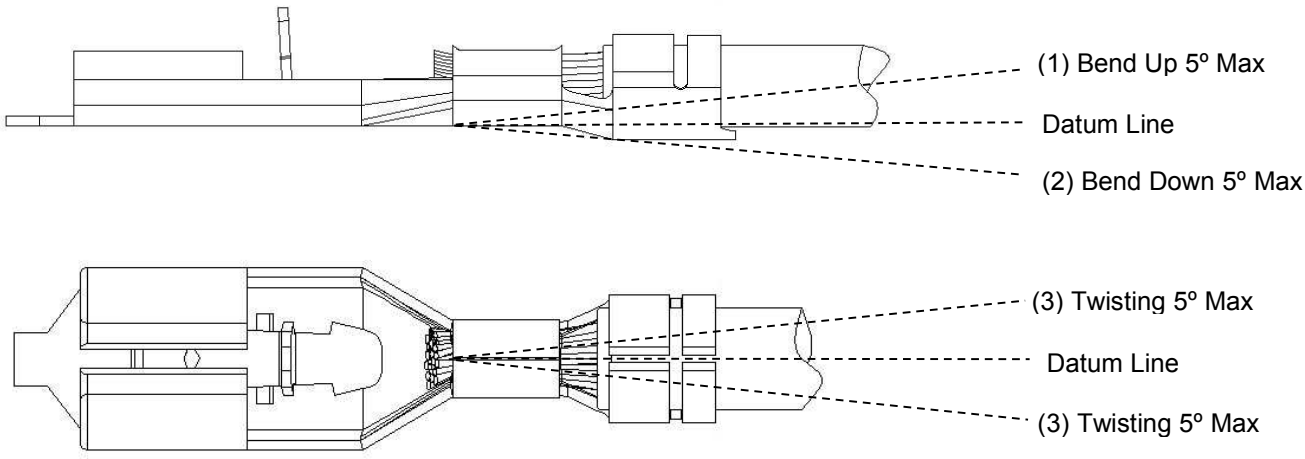

Fig 2

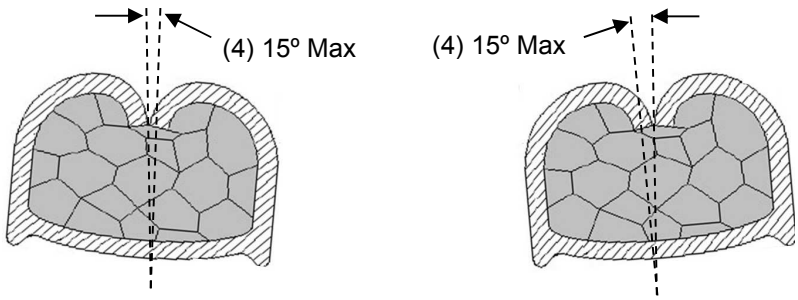

Fig 3

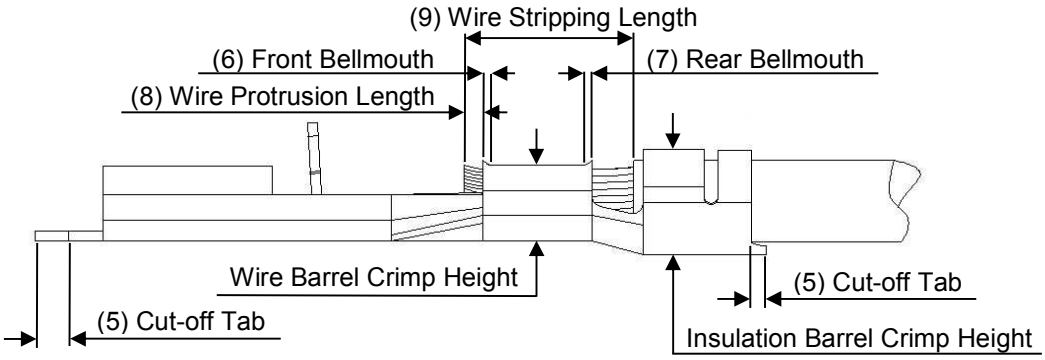

Fig 4

4.2 Crimping Data

Contact P/N (Strip Form)	Applicator P/N (Spare Kit P/N)	Wire Size		Wire Stripping Length (±0.5mm)	Wire Barrel Crimping			Insulation Barrel Crimp Width (mm)	Insulation Diameter (mm)	Crimp Tensile Strength (kgf)
		# of wires	(mm^2)		Width (mm)	Crimp Height (±0.05mm)	Disk Letter			
2297529-1	2150638-2 (7-2150638-7)	1	0.34	4.5	1.57 "F"	1.06	C	3.0 "F"	1.56 (1)	5.0
		1	0.53			1.09	B		2.15 (2)	7.0
		2	0.34			1.15	A		1.95 (2)	5.0 (3)

Table 3

Note ;
(1) Reference wire : UL style No. 3398
(2) Reference wire : UL style No. 3122
(3) Crimped wire pull-out force for one of the two

5. Revision History

Rev.	Revision Record	DATE
A	Released	16May2016

6. Specification Approval

Prepared by,
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Checked By,
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