
Title: Contact HN.D for Crimp Termination



Application Specification 114-74015

CONTACT HN.D FOR CRIMP TERMINATION

Note: All measurements in the drawings are in mm [inches]. Unless otherwise stated the free tolerances of all measurements are $\pm 0,2$ [$\pm .008$] and of all angles $\pm 2^\circ$. The measurements in the sketches and pictures are for identification purposes only.

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1. Purpose

This specification gives the regulations for the application of pin- and socket contacts of the HN.D series. It is valid for manual, semi automatic and fully automatic tools, whose types are listed under item 5.

2. Additional Documents

2.1 Customer Drawings

For measurements, materials and plating, please refer to the customer drawings.

2.2 Product Specification

The product specifications of the articles used must be observed.

2.3 Application Specification

For crimping quality the general guidelines of application specification no. 114-18022 apply.

2.4 Catalogue

The standard catalogue "Product Guide", as well as the "New Product Guide" contain information concerning contacts, inserts, housings, accessories, and application tools.

HTS standard, German	889728
HTS standard, English	889729
HTS standard, Italian	889730
HTS standard, Spanish	889731
HTS standard, French	889732
HTS Summary Catalogue	889734

2.5 Information Sheets

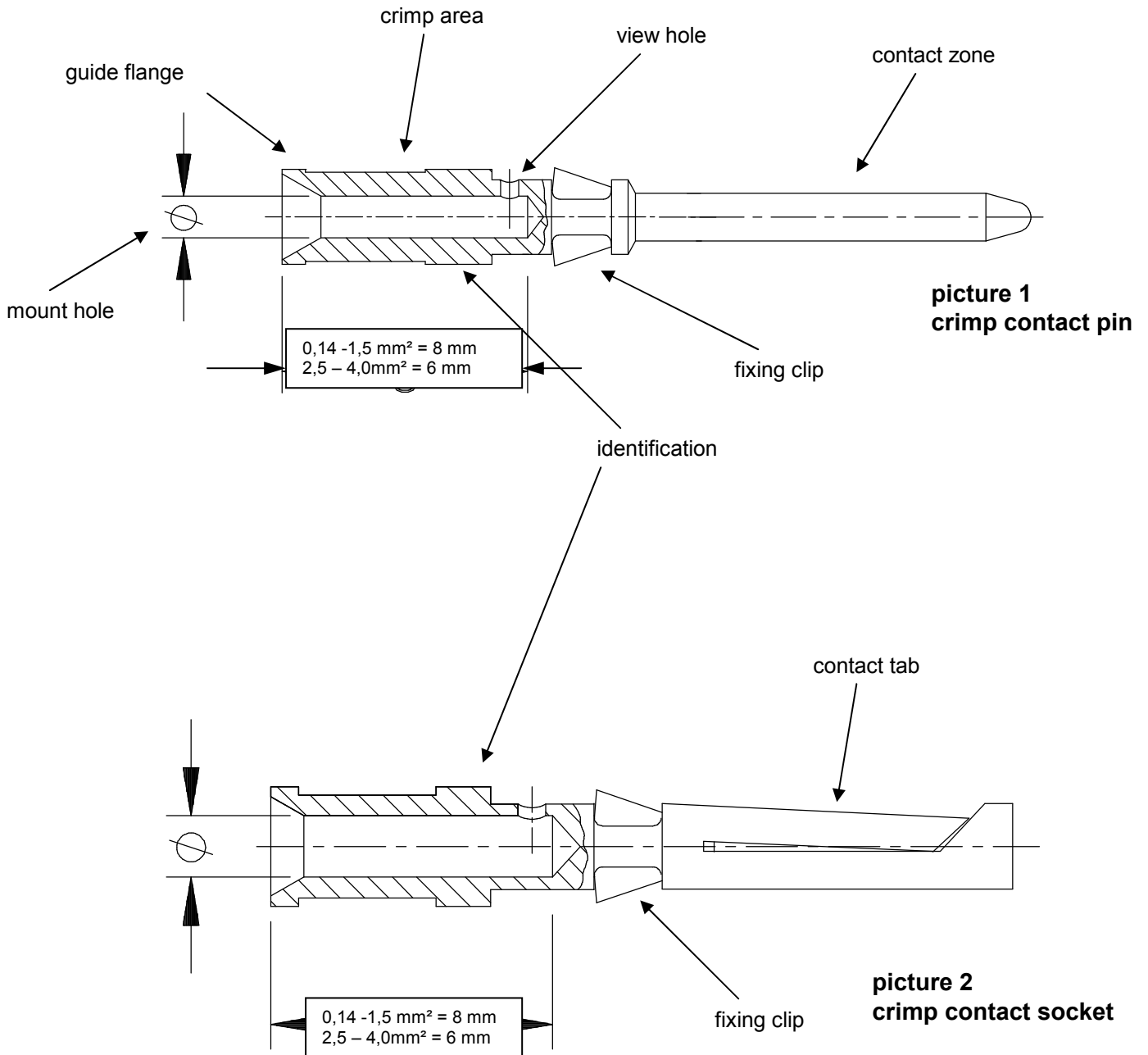
For information concerning application tools please refer to the information sheets.

2.6 National Standards

DIN VDE 0627/06.86	Connectors and Connecting Devices
DIN IEC 352 P.2	Solderless Crimped Connection, Crimp Connections

3. Description

The terms listed below are used in the specification.



4. Requirements

4.1 Wire Selection

Flexible multicore copper cable with cross section for contact mount hole according to table 1.

When choosing cables the measurements of the lead funnel of the insulator used must be considered, so that the conductor insulation can be inserted into the insulator.

table 1:

cross section		connection drilling (max) Ø [mm]	Identification no.
[mm ²]	AWG		
0.14-0.37	26-22	0.9	1
0.5	20	1.1	2
0.75-1.0	18	1.40	3
1.5	16	1.8	4
2.5	14	2.2	5
4.0	12	2,4	6

4.2 Crimp termination

Strip length L

table 2:

contact insert	strip length L for all wire cross sections [mm]
HN.D 0,14 - 1,5mm ²	8.0
HN.D 2,5 - 4.0mm ²	6.0

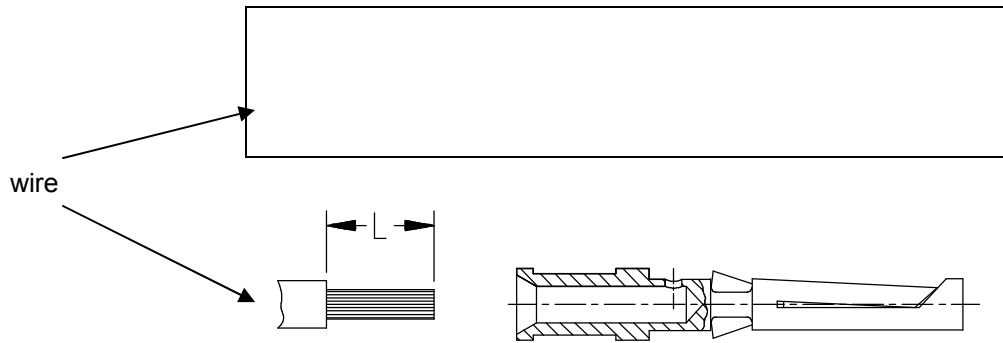
Insert the cable – stripped according to table 2 – into the mount hole of the contact. The wire cores must be visible in the view hole.

Afterwards, crimp the contact in the crimp area using the correct tool (as specified in item 5) for this type of contact. While processing make sure that the contact in the contact zone is not damaged or deformed. It must also be guaranteed that the fixing clip does not get damaged or deformed.

After processing, the fixing clip must move freely on the contact. After engaging the contact into the contact chamber the contact must not be twisted by the cable.

When using manual crimp tools the following points must be followed:

1. equip manual crimp tools with the correct locator or positioning ferrule
2. when using different manual crimping tools the pliers must be adjusted by plug gauge to fit the crimp area
3. insert the contact into the locator according to its crimp cross section. A crimp connection which is made without the suitable locator does not comply with DIN IEC 352 part 2
4. fully insert the contacts into the locator, which is the only way the correct crimping position can be guaranteed



picture 3: stripped length

4.3 Storage

The contacts should remain in the shipping containers until ready for use. They should be used on a first-in, first-out basis to avoid storage contamination.

Do not store in an aggressive environment.

5. Tools

For the processing of crimp contacts hand tools and semi automatic machines are available.

AMP-P/N	Order Text
1-1105851-8	RSZ.HE-HND-HVT
1-1105553-8	Bu-HND-CSV.40
1-1105551-8	HN.D-CSZ.25
1-1105854-8	CBE 220V
on request	stripper crimper, type AM05

table 3