

Terminal Ring Tongue M4 Assembly

1. SCOPE

This specification contains the guidelines for the application of Terminal Ring Tongue M4 Assembly. It applies primarily to the fully or semi-automatic application of the contacts; if agreed, it can also be applied to manual crimp tool.

The contacts are listed by their use, the wire size ranges and the crimping data in section 5.

Note : Only the TE crimp tool specified in section 5 may be used for application of the contacts. Any exceptions to this rule are defined by customer-specific documents.

2. REFERENCED DOCUMENTS

2.1 Customer Drawings

The dimensions and materials of the contacts are shown in the TE customer drawings.

2.2 Crimp Dimensions

For crimp dimensions refer to the product specific information in section 5 or the applicator log sheet.

2.3 Crimp Height Measurement

How to measure the crimp height is explained in Instruction Sheet 408-7424.

3. FEATURES OF A CRIMP CONNECTION

The following terms are used in this specification.

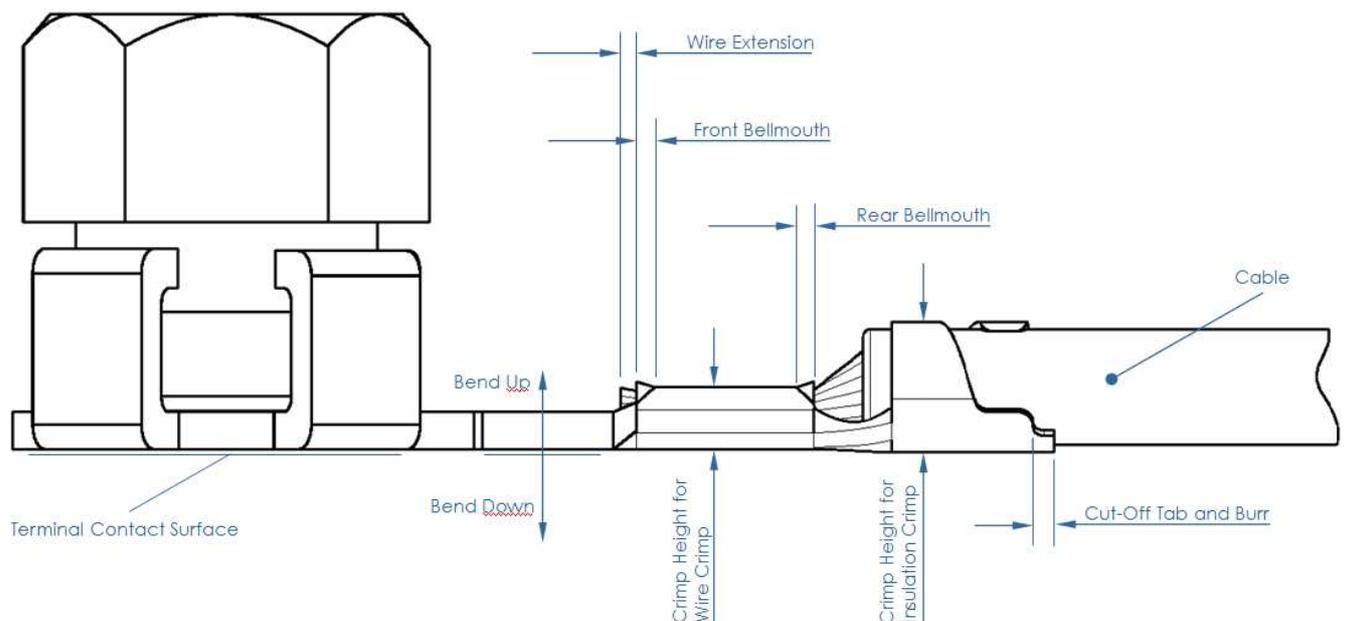


Figure 1

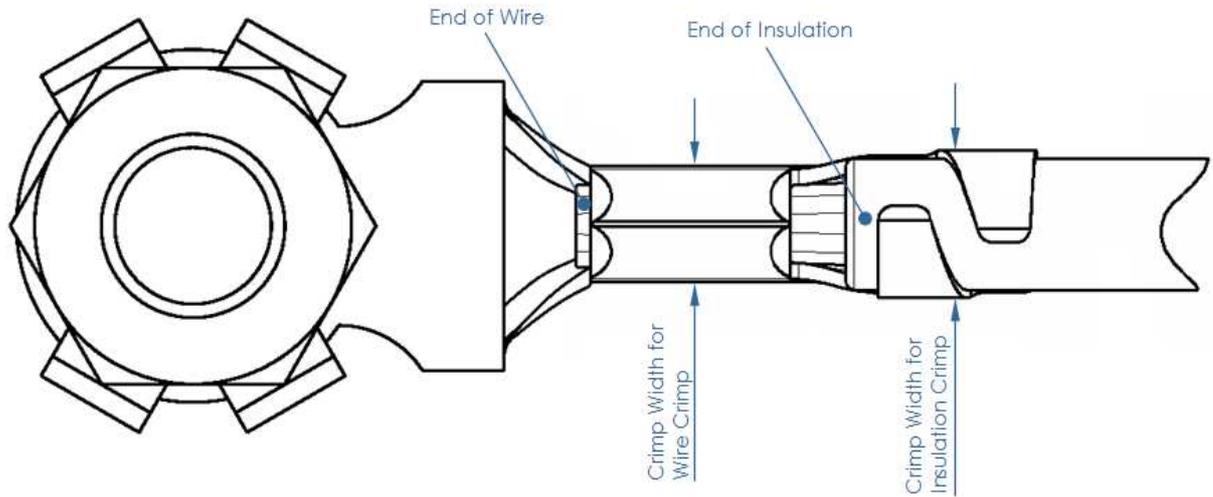


Figure 1 (cont)

4. CRIMP CONDITION

4.1 Applicator Crimp

Check Items		
1	Wire Extension	0.10 to 0.75 mm
2	Front Bellmouth	0.50 mm maximum
3	Rear Bellmouth	0.30 to 0.70 mm
4	Bend Up	0°
5	Bend Down	3° maximum
6	Cut-Off Tab Length	0.50 mm maximum
7	End of Insulation	must be visible between Wire Barrel and Insulation Barrel
8	Insulation Stripping Length	5.5 to 6.0 mm to all wire gauge (before Crimping)

Table 1

5. CRIMP DATA

5.1 Applicator Crimp

Part Number (Base Number)	Wire Size	Applicator Part Number	Wire Barrel Crimp			Insulation Barrel Crimp	
			Width (mm)	Height (mm)	Type	Width (mm)	Type
1599297	14 AWG	1385760	3.30 ± 0.05	2.54 ± 0.05	"F"	3.56 ± 0.10	"O"
	16 AWG		3.30 ± 0.05	2.36 ± 0.05	"F"	3.56 ± 0.10	"O"
1599298	1.50 mm ²	297745-1	3.56 ± 0.05	2.33 ± 0.05	"F"	4.57 ± 0.10	"F"
	2.00 mm ²		3.56 ± 0.05	2.43 ± 0.05	"F"	4.57 ± 0.10	"F"
	2.50 mm ²		3.56 ± 0.05	2.57 ± 0.05	"F"	4.57 ± 0.10	"F"
1599300	0.75 mm ²	297746-1	3.30 ± 0.05	2.18 ± 0.05	"F"	3.30 ± 0.05	"O"
	1.00 mm ²		3.30 ± 0.05	2.24 ± 0.05	"F"	3.30 ± 0.05	"O"
1599560	0.75 mm ²	---	3.30 ± 0.05	2.18 ± 0.05	"F"	3.30 ± 0.05	"O"
	1.00 mm ²		3.30 ± 0.05	2.24 ± 0.05	"F"	3.30 ± 0.05	"O"
1989276	14 AWG	---	3.30 ± 0.05	2.54 ± 0.05	"F"	3.56 ± 0.10	"O"
	16 AWG		3.30 ± 0.05	2.36 ± 0.05	"F"	3.56 ± 0.10	"O"

Table 2

Note : In addition to this specification the requirements of the specification 114-18022 are valid.

Revision Record					
Rev.	Date	Description	Edited	Checked	Approved
A	04-Dec-2012	Released	C. Cassali	M. Gisoldi	D. Oliveira
B	18-Jul-2013	Changed item 5.1	S.F. Oliveira	M. Gisoldi	D. Oliveira