

This specification covers general requirements for crimping MIC MARK IV receptacle contacts manufactured by Tyco Electronics France. These requirements must be maintained to have satisfying performance of product.

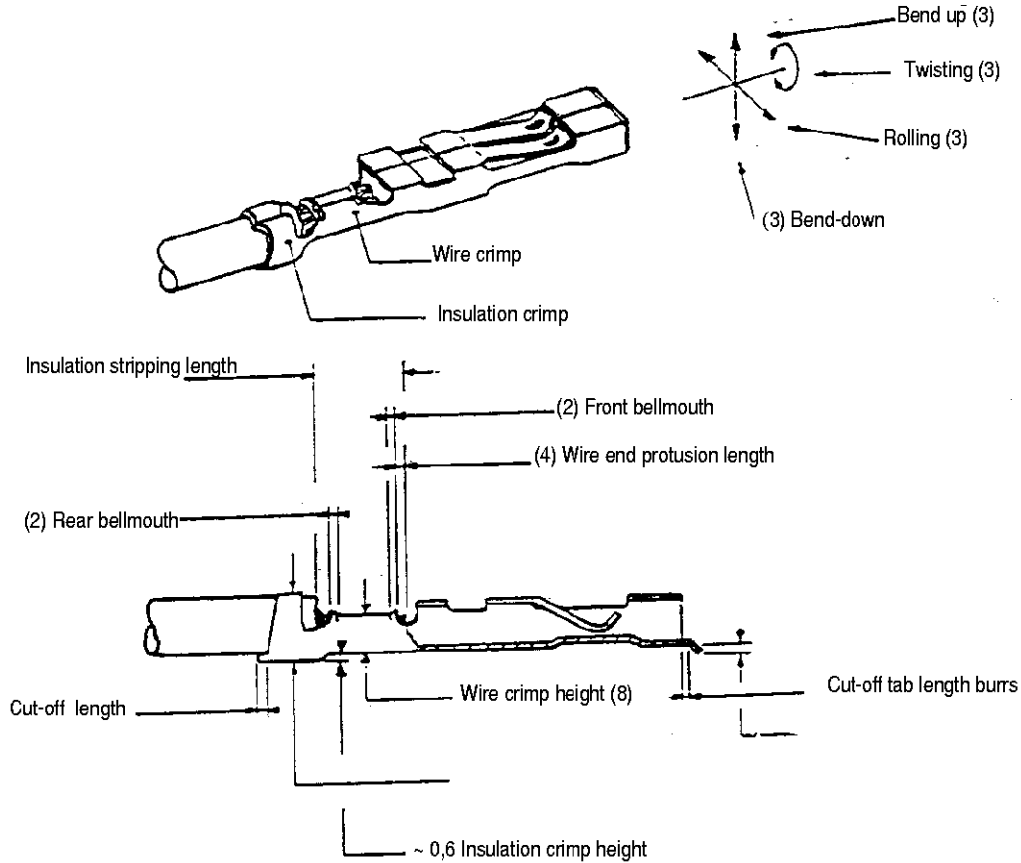


Figure 1

1. CRIMPING CHARACTERISTICS ON APPLICATOR

Check items		Specified requirements	See figure n °
A	Cut-off tab length	0,85 mm max 0,2 mm max	(1)
B	Rear and front bellmouth	Must be visually identified	(2)
C	Allowable deviation after crimping	Bend-up	7° max
		Bend-down	6° max
		Twisting	5° max
		Rolling	10° max
D	Wire end protusion length	0,8 0,4 mm	(4)
E	Insulation stripping length	5 à 6 mm	(5)

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2. CRIMPING VALUES

Contact pn (strip form)	Applicator	Wire range (mm ²)	Wire crimp width (mm)	(8) Wire crimp height (± 0,05)	Disc code	Insulation crimp width (mm)	(9) Insulation crimp height (+/- 0.2 mm)	Crimp tensile strenght (dan)
142647-1 144180-1	4-482378-3	0.35	1.78	1.21	C	2.8	2.1	5
		0.5		1.27	C		2.15	5
		0.6		1.32	B		2.2	10
		0.75		1.41	B		2.25	10
		1		1.48	A		2.4	15
		0.35+0.35		1.36	B		2.2	10
		0.35+0.6		1.48	A		2.6	15