

Crimping Socket Contact for 1mm Pin

The performance of applicable product is guaranteed only when processed by proper application tooling and condition described in this specification and/or TE recognized ones. No product is guaranteed when processed with the other tool or condition.

1. SCOPE

This specification covers the requirements for crimping Socket Contact for 1mm Pin.

2. APPLICABLE CONTACTS

TE Part Numbers	Finish	Applicable Wires
Strip Form		
1612124-3	Selective Gold	AVSS 0.3,0.5,0.3f,0.5f
1612124-8		CAVS 0.3,0.5 CHFUS 0.5,0.50 HFTUF 2cx0.5

3. NOMENCLATURE

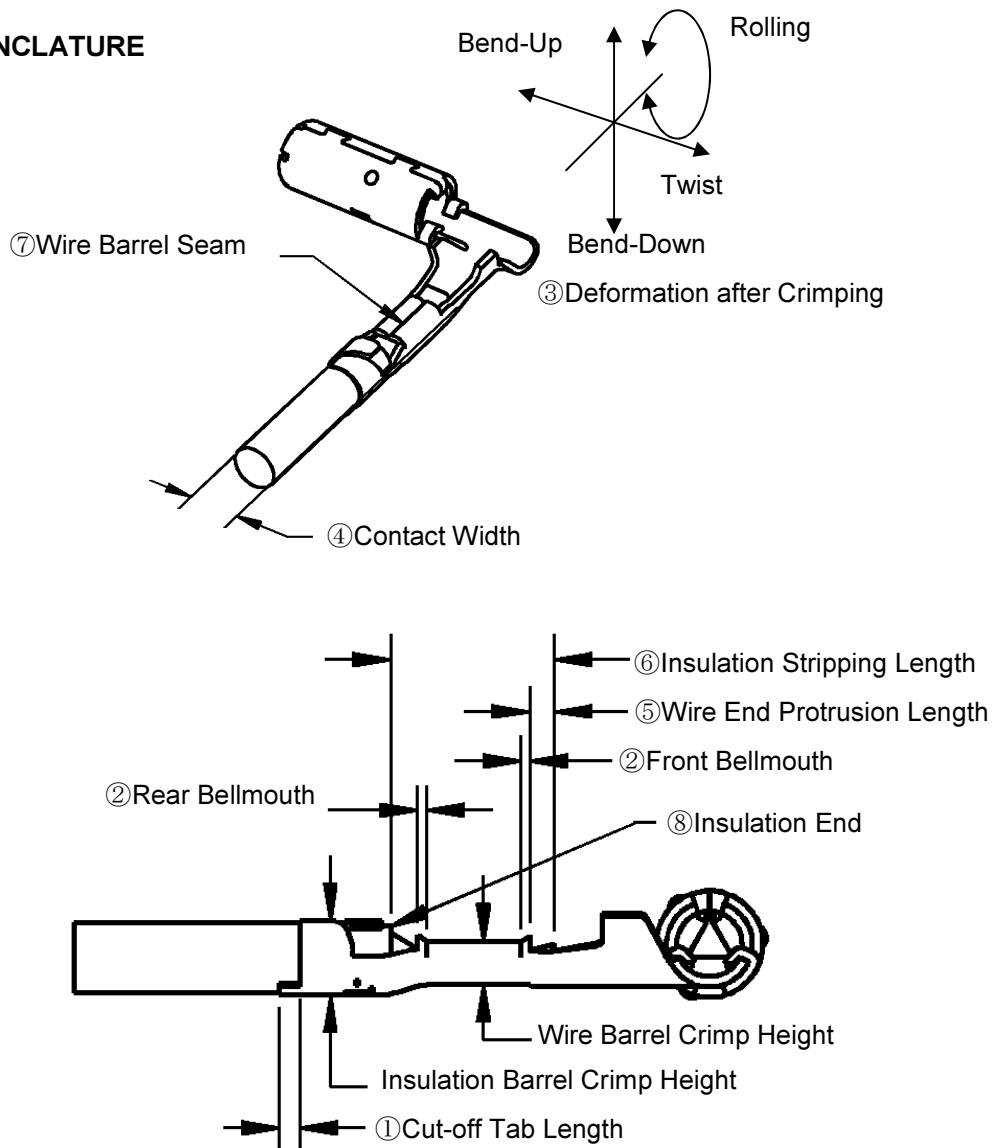


Fig.1

4. CRIMPING CONDITION

4.1. Applicator Crimp

Check Items	Number of Serration	1612124-3	1612124-8	Remarks	
		2	3		
1	Cut-off Tab Length	0.1~0.5 mm		Fig.1-①	
2	Bellmouth	Front	0.3 mm Max.	0mm	Fig.1-②
		Rear	0.1~0.5 mm		
3	Deformation After Crimping	Bend	$\pm 3^\circ$ Max.		Fig.1-③
		Twist	$\pm 3^\circ$ Max.		
		Rolling	$\pm 10^\circ$ Max.		
4	Contact Width after Crimping	2.0mm Max.		Fig.1-④	
5	Wire End Protrusion Length	0~1.0 mm		Fig.1-⑤	
6	Insulation Stripping Length	3.0~3.5 mm		Fig.1-⑥	
7	Wire Barrel Seam	Seam must be closed (No strand loses out of the seam)		Fig.1-⑦	
8	Insulation End	Insulation End must be between Wire barrel and Insulation Barrel		Fig.1-⑧	

5. CRIMP DATA

5.1. Applicator Crimp

Contact Part Number (Strip Form)	Wire Size (Nominal)	Applicator Part Number	Wire Barrel Crimp(mm)			Insulation Barrel Crimp (mm)			⁽³⁾ Crimp Tensile Strength (N)
			Width ⁽²⁾	Height	Disk Ltr.	Width ⁽²⁾	Height ⁽¹⁾	Disk Ltr.	
1612124-3 1612124-8	AVSS /CAVS 0.3 0.3f	2088776-2	1.4"F"	0.96 ± 0.05	B	1.83"O"	1.5	(4)	50 Min.
	AVSS /CAVS 0.5			1.06 ± 0.05	A		1.8		70 Min.
	AVSS 0.5f			1.06 ± 0.05	A		1.8		70 Min.
	CHFUS 0.35			0.93 ± 0.05	B		1.4		50 Min.
	CHFUS 0.50			1.02 ± 0.05	A		1.5		70 Min.

- NOTE**
- (1) Insulation Barrel Crimp Height to be within ± 0.1
 - (2)Crimp Width dimensions are not the product width after crimping, but given by the width of crimper slot for reference
 - (3)Crimp Tensile Strength is without Insulation Barrel.
 - (4)About a disk of Insulation Barrel Crimp, please choose timely and adjust.

6. APPLICABLE WIRE DATA

Wire Size (Nominal)	Number and Diameter of Conductor	Cross-Sectional Area of Conductor	AVSS		CAVS		CHFUS		HFTUF 2C	
			Std.	Max	Std.	Max	Std.	Max	Std.	Max
0.3	7/0.26	0.3716	1.4	1.5	—	—	—	—	—	—
	7/circular compression		—	—	1.4	1.5	—	—	—	—
0.5	7/0.32	0.5629	1.6	1.7	—	—	—	—	—	—
	7/circular compression		—	—	1.6	1.7	—	—	—	—
0.3f	19/0.16	0.3821	1.4	1.5	—	—	—	—	—	—
0.5f	19/0.19	0.5387	1.6	1.7	—	—	—	—	1.6	1.7
0.35	7/circular compression	0.3436	—	—	—	—	1.10	1.20	—	—
0.50	7/circular compression	0.4948	—	—	—	—	1.25	1.40	—	—