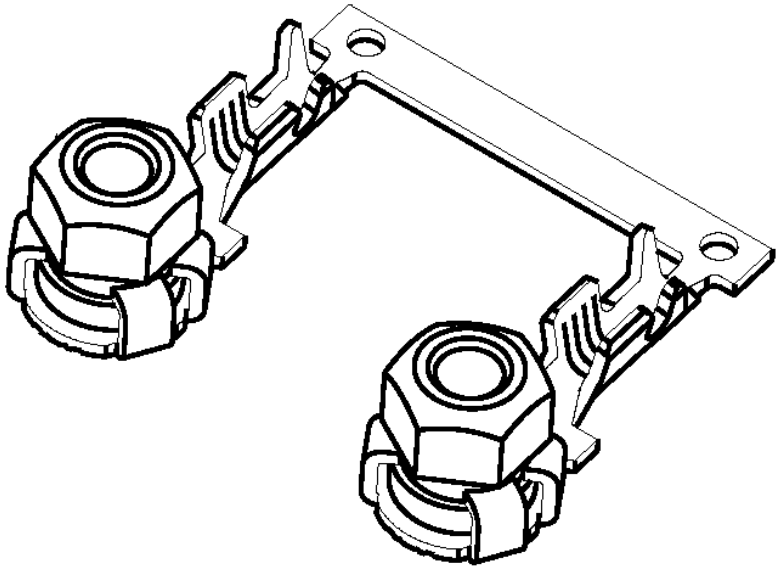
Ring Tongue Terminal, M4

APPLICATION SPECIFICATION



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LTR	**REVISION RECORD**	**AP**	**PR**	**DATE**	Ring Tongue Terminal, M4			

1. SCOPE

This specification covers the special guidelines for the application of the RING TONGUE TERMINAL, M4. The instructions are intended primarily for automatic or semi-automatic application of all versions for wire. If agreed it can also be applied to manual crimp tools. The contacts are listed by their use, the wire size ranges and crimping data in section 5.

2. REFERENCED DOCUMENTS

2.1 Customer Drawings

There is a customer drawing showing the dimensions and materials for each part number. In the case of a conflict between this document and a customer drawing, the customer drawing takes precedence.

2.2 Product Specifications

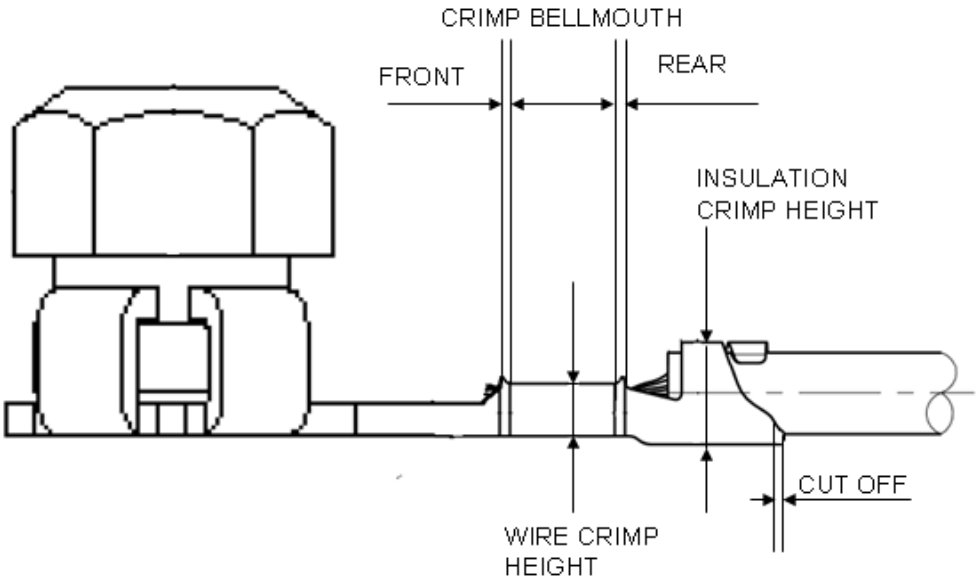
The Product Specifications 108-101142 describe the characteristics of these contacts, together with the electrical and mechanical requirements.

2.3 Application Specifications

The general guidelines laid down in Application Specifications 114-18022 also apply to the crimp quality.

3. DESCRIPTION

The terms shown below are used in the specification.



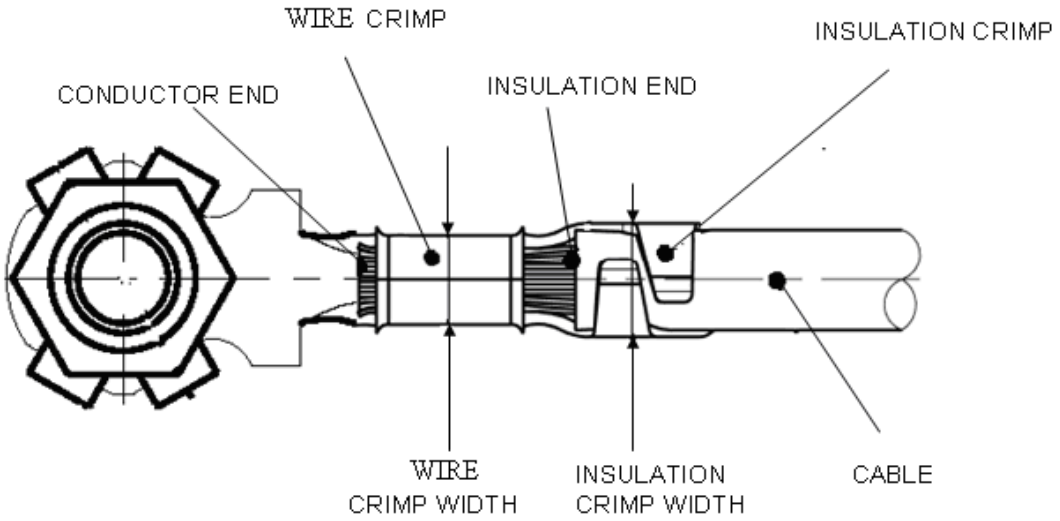


FIGURE 1

4. REQUIREMENTS

4.1 Wire

A. Selection

The contacts are primarily designed for RAYCHEM 55E series or FLR cables to DIN 72551 Part 5 and Part 6. Other wires require the approval of the Engineering Department. Single termination is preferred. Double termination within the wire range is possible only with restrictions.

B Preparation

The wire must be stripped to the length specified in Table 1, taking care that the individual strands are neither bent nor cut off.

4.2 Cut off and Burrs

The cut-off must be visible after crimping. The maximum length of the cut-off is 0.5mm. Any burrs at the cutting area may not exceed 0.08mm.

4.3 Wire Crimp

A. Conductor position

After crimping, the conductor end must extend 0.1 ... 1mm beyond the front end of the wire crimp. In no case may the end of the insulation be crimped in the wire crimp.

B. Crimp data

The shape, height and width of the crimp and the wire range are shown in Table 1.

C. Tensile strength of crimp connection

The tensile strength of crimp connection must comply with the requirements of 108-101142. Measuring of the tensile strength should be without insulation crimp.

D. Crimp bellmouth

The size of the rear bellmouth:1mm Max. A missing of front bellmouth is permissible.

4.4 Insulation Crimp

A. Position of the insulation end

In the case of contacts for crimping on wires, the insulation end must be visible in the transition between the wire crimp and the insulation crimp. In no case may the insulation be crimped on the wire crimp; conversely, the insulation must extend at least to the front edge of the insulation crimp.

B. Crimp data for insulation crimp

The shape and width of the crimp and the insulation diameter are shown in Table 1. Due to the large tolerances of the insulation diameters, no crimp height is specified.

4.5 Contact Area

After crimping, neither the nut nor the contact body is deformed.

5. CRIMPING DATA

CRIMP DATA FOR RING TONGUE TERMINAL, M4									
P/N	WIRE RANGE (mm^2)	INSULATION RANGE Φ (mm)	STRIPPED LENGTH ± 0.3(mm)	WIRE CRIMP				INSULATION CRIMP	
				CRIMP WIDTH/CB1 ±0.05(mm)	CRIMP HEIGHT/CH1 ±0.05(mm)		SHAPE	CRIMP WIDTH REF (mm)	SHAPE
2050842	0.75~1.0	1.55~2.10	5.5	3.3	0.75mm^2	2.18	F	3.3	WRAP
					1.0mm^2	2.24			
2050216-*	1.5~2.5	1.82~3.00	5.5	3.56	1.5mm^2	2.33	F	4.57	F
					2.0mm^2	2.43			
					2.5mm^2	2.57			
2050216-6	1.5	1.82~2.40	7.0	3.56	1.5mm^2	2.33	F	4.57	WRAP

NOTE: * MEANS 1~5

Table 1

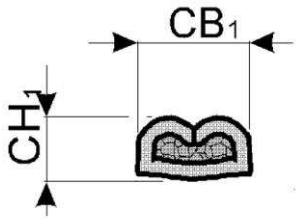


FIGURE 2 WIRE CRIMP (F TYPE)

F TYPE WRAP TYPE

FIGURE 3 INSULATION CRIMP (F & WRAP)