

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

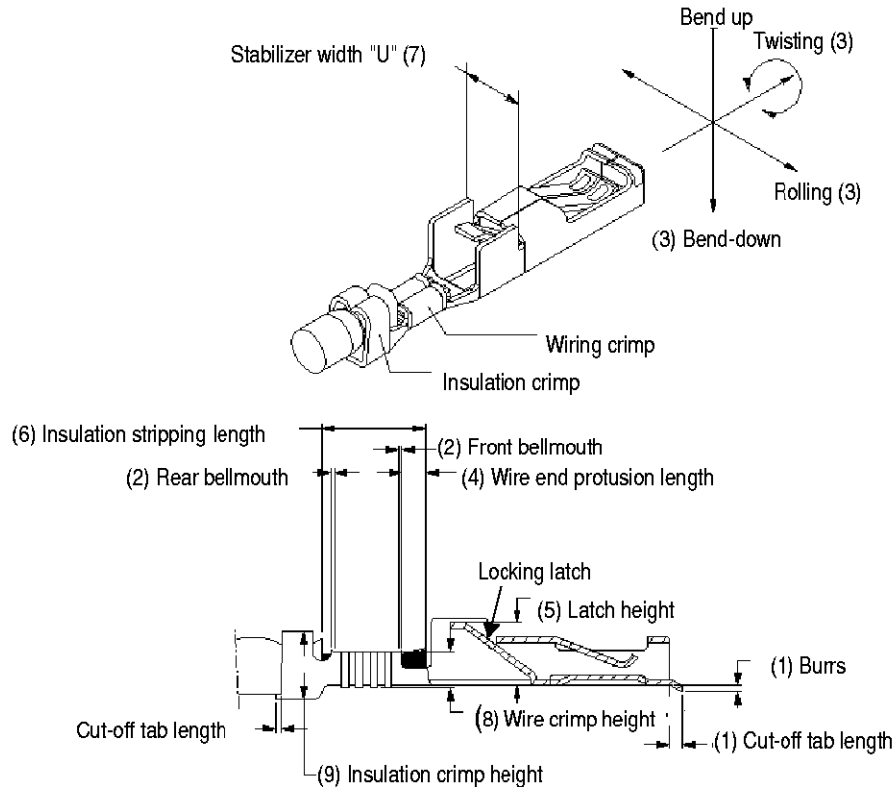


Figure 1

1. CRIMPING REQUIREMENTS ON APPLICATOR

	CHECK ITEMS		SPECIFIED REQUIREMENTS	SEE FIGURE N °
A	Cutt-off tab, length burrs		0,2 ± 0,15 0,1 max	(1)
B	Front and rear bellmouth		Must be visually identified	(2)
C	Allowable deviation after crimping	Bend-up	7° max	(3)
		Bend-down	6° max	
		Rolling	5° max	
		Twisting	10° max	
D	Wire end protusion length		0,8 ± 0,7 mm	(4)
E	Locking latch height		3,5 à 3,8 mm	(5)
F	Insulation stripping length		5,5 ± 0,4 mm	(6)
G	Stabilizer width (U)		3,8 ± 0,2 mm	(7)

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2. CRIMPING VALUES

Contact P/N (strip form)	Applicator N°	Wire size (mm ²)	Wire crimp width (mm)	(8) Wire crimp height (0,05)	Disc code	Insulation crimp width (mm) (0,2 proposal)	(9) Insulation crimp height (mm)	Crimp tensile strength (dan)
142183-1	0-482378-5	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

(*) Combinations not recommended (dimensions)