HMM/HMF 40A Machined Crimp Contact for Crimping

CONTENT

1. INTRODUCTION

This specification covers the requirements for the application of pin and socket contacts of HMM/HMF 40A machined crimp contact series. It is valid for proper manual, semiautomatic and fully automatic tools.

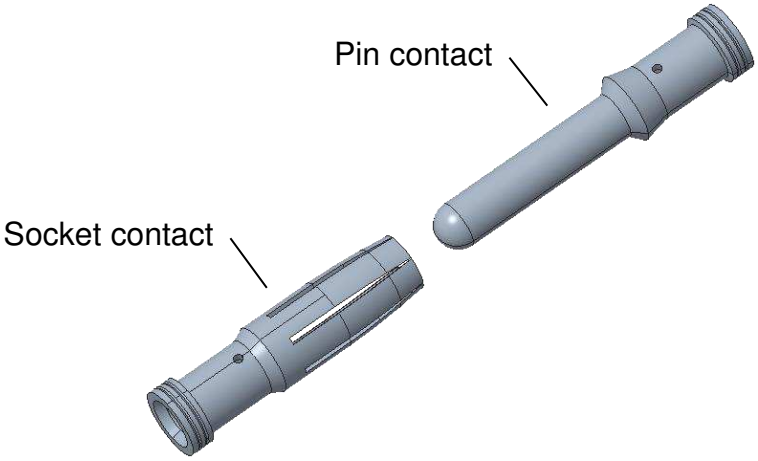


Figure 1

2. SUPPORT DOCUMENT

2.1 Drawings

Customer drawing for product part numbers are available from the service work. If there is a conflict between the information contained in the customer drawings and this specification or any other technical documentation supplied, contact TE connectivity Engineering.

2.2 Product Specification

Performance specification for HMM/HMF 40A machined crimp contact can be found in TE Connectivity related drawings and product specification 108-137640.

3. REQUIREMENTS

3.1 Prepare the crimp contact

Pin contact is applicable to the conductor cross-sectional area: 1.0 mm^2 ~10.0 mm^2

HMM pin contact		Wire guage	
Part number	Description	mm^2	AWG
T2040021010-000	HMM-1.0	1.0	18
T2040021015-000	HMM-1.5	1.5	16
T2040021025-000	HMM-2.5	2.5	14
T2040021040-000	HMM-4.0	4.0	12
T2040021060-000	HMM-6.0	6.0	10
T2040021100-000	HMM-10.0	10.0	8

Socket contact is applicable to the conductor cross-sectional area: 1.0 mm² ~10.0 mm²

HMM socket contact		Wire guage	
Part number	Description	mm²	AWG
T2040022010-000	HMF-1.0	1.0	18
T2040022015-000	HMF-1.5	1.5	16
T2040022025-000	HMF-2.5	2.5	14
T2040022040-000	HMF-4.0	4.0	12
T2040022060-000	HMF-6.0	6.0	10
T2040022100-000	HMF-10.0	10.0	8

3.2 Wire preparation

Using the appropriate cable stripping tool, strip the conductor as indicated in **Figure 2** and strip length according to **Table 1**, and proceed to clean and clear cuts of the insulating sleeve without damaging the strands.

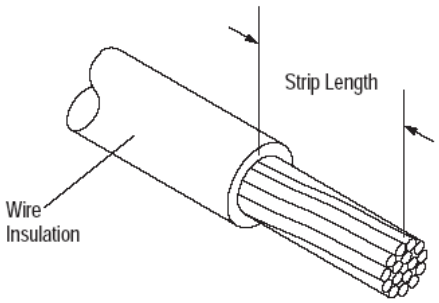


Figure 2

Table 1

Nominal conductor cross section		**Conductor strip length (mm)**
mm²	**AWG**	
1.0	18	$9.2^{+}/_{-0.5}$
1.5	16	$9.2^{+}/_{-0.5}$
2.5	14	$9.2^{+}/_{-0.5}$
4.0	12	$9.2^{+}/_{-0.5}$
6.0	10	$9.2^{+}/_{-0.5}$
10.0	8	$9.2^{+}/_{-0.5}$

3.3 Crimping the contact

Step **1:** Insert the stripped strands into the wire barrel of pin contact or socket contact. The hole located in **Figure 5** at the end of the barrel is for checking and be sure of the correct insertion of the conducting strands.

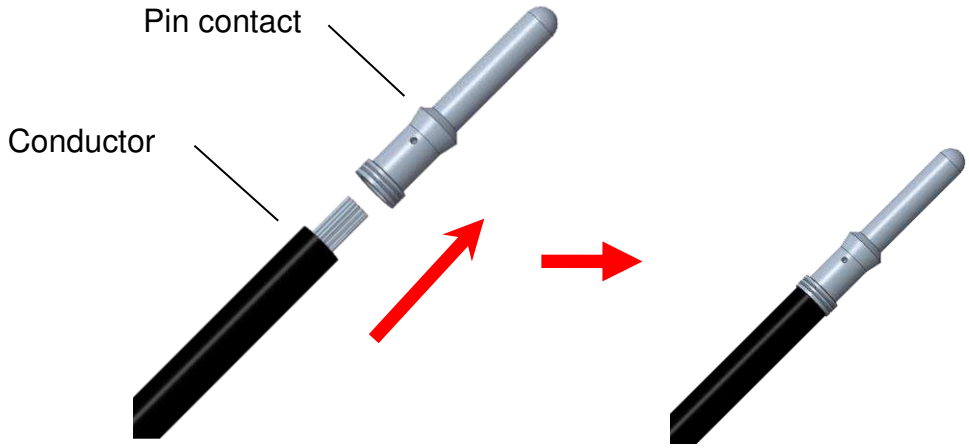


Figure 3

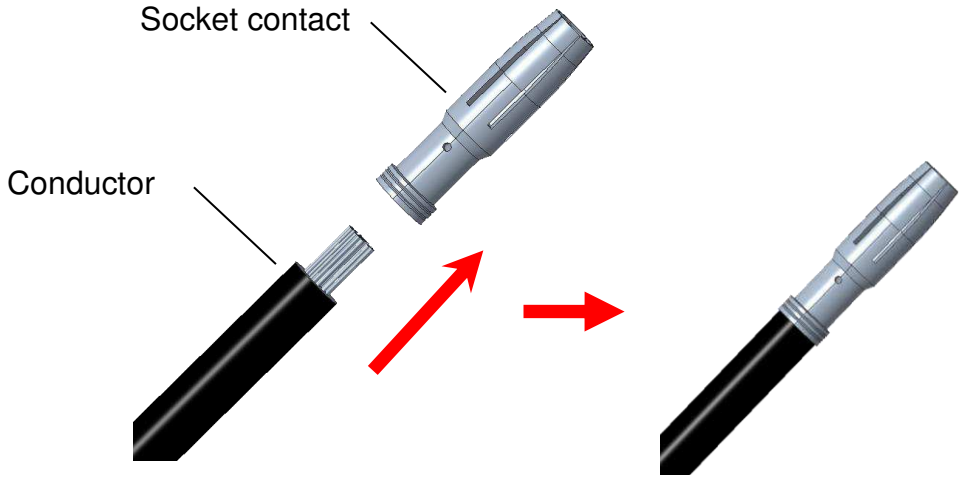


Figure 4

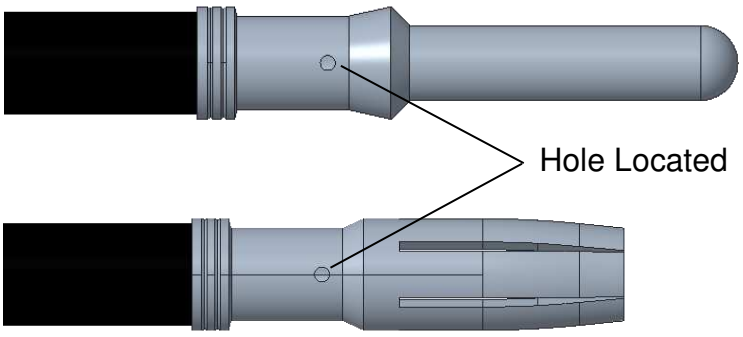
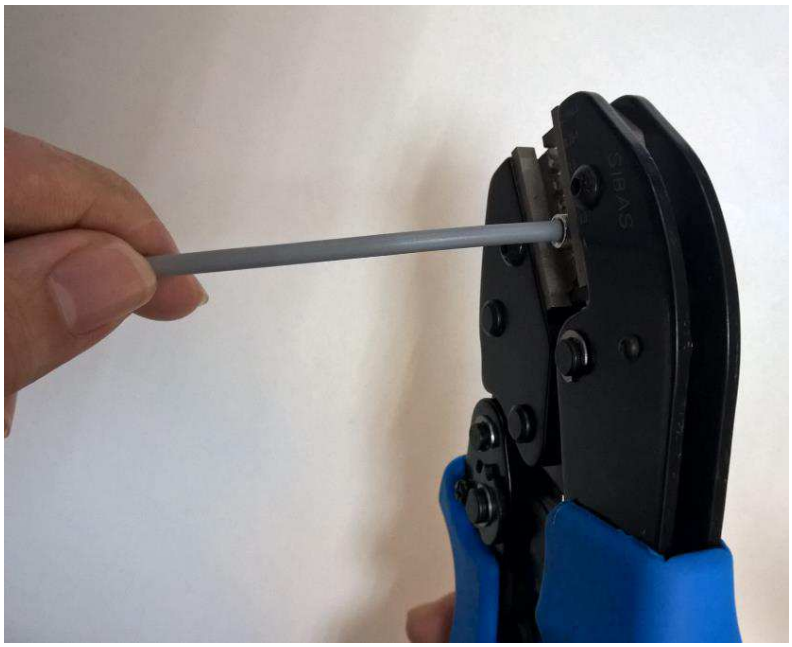


Figure 5

Sep **2**: Crimp contacts

Put the contact into crimping tool, then crimp the contact.

When crimping the contact, need to make sure the crimp tool fully press, then open the crimp tool and crimp the other contact.

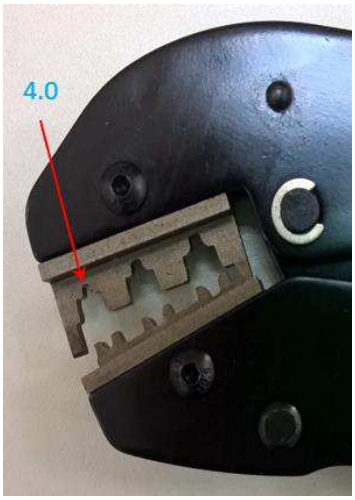


NOTE

a. Use the right crimp tooling for the contact with the different wire gauge.

1.0/1.5/2.5 mm^2 crimp tool: T3100000001-000 CRIMPBOX-0.5/4

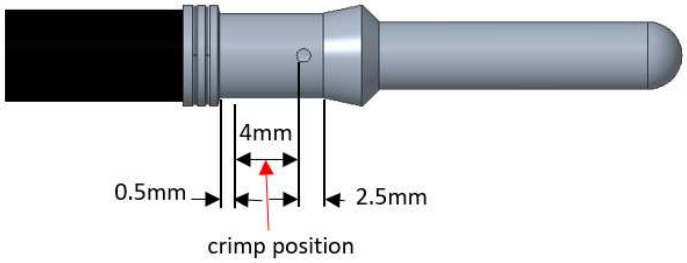
4.0 mm^2 crimp tool: T3100001001-000 CRIMPBOX-4.0/10.0



6.0/10.0 mm^2 crimp tool: T3100000032-100 (refer 114-137597) CRIMPBOX-E-60kN
Crimp die need to be ordered separately refer 114-137597

b. The right crimp area per the below crimp position：

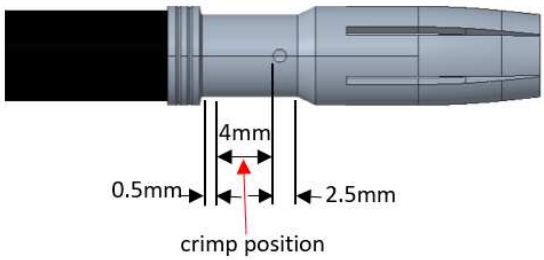
HMM contact：conductor cross-section 1.0 mm² ~10.0 mm²



After crimping 1.0 mm² ~4.0 mm²

After crimping 6.0 mm² ~10.0 mm²

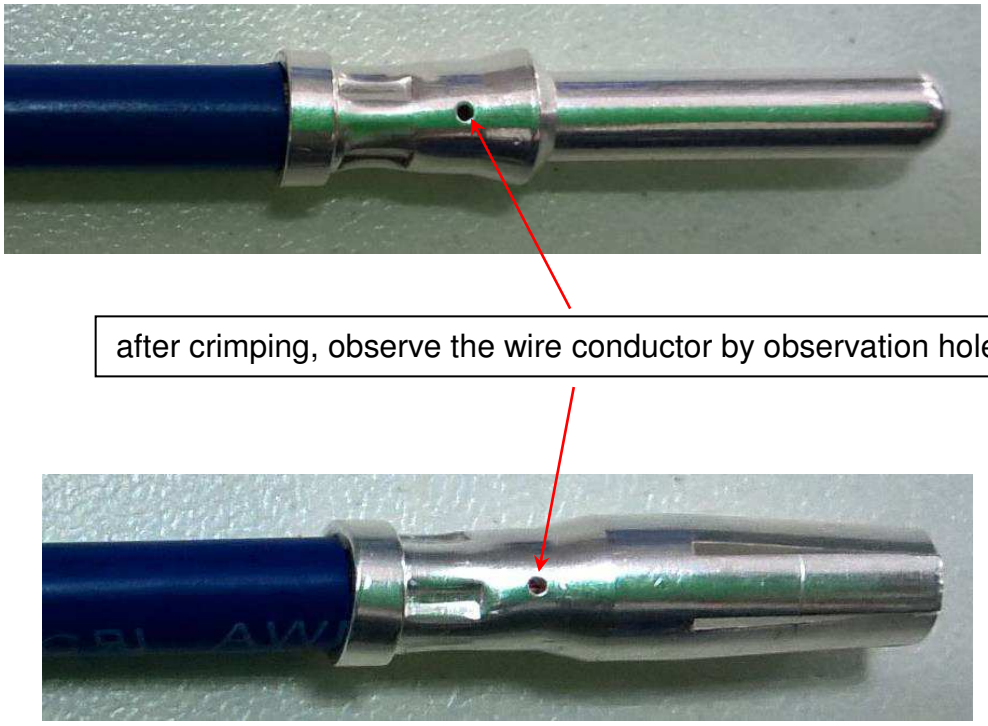
HMF contact：conductor cross-section 1.0 mm² ~10.0 mm²



After crimping 1.0 mm² ~4.0 mm²

After crimping 6.0 mm² ~10.0 mm²

c. after crimping, observe the wire conductor by observation hole.



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