

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

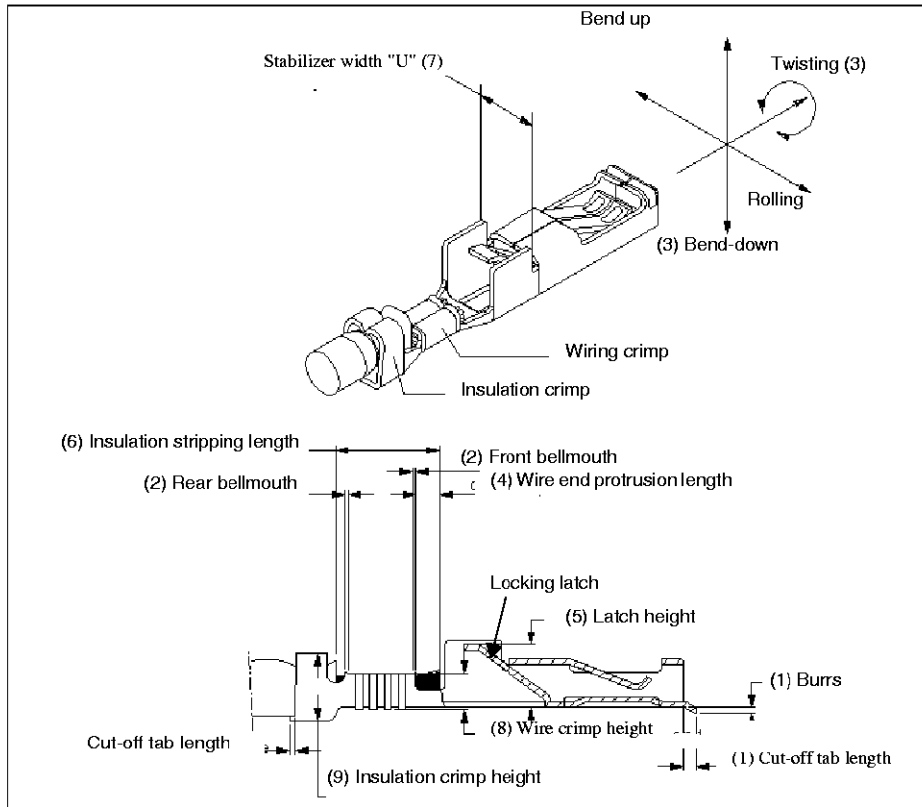


Figure 1

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	Allowed deviation after crimping	Bend-up	7° max	(3)
		Bend-down	6° max	
		Rolling	5° max	
		Twisting	10° max	
D	Wire end protrusion 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 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)	CRIMPING TENSILE STRENGTH (DAN)
142185-1	6-482378-1	1	2.8	1.42	D	3.6	2.85	15
		1.4		1.53	C		3.24	20
		2		1.70	B		3.65	20
		3		1.81	A		4.10	25
		1 + 0.35		1.53	C		3.24	
		1 + 0.6		1.53	C		3.24	
		1 + 1		1.70	B		3.65	
		1 + 1.4 (*)		1.70	B		3.65	
		1.4 + 0.35		1.53	C		3.24	
		1.4 + 0.6		1.70	B		3.65	
		1.4 + 1.4 (*)		1.81	A		4.10	
		2 + 0.35		1.70	B		3.65	
		2 + 0.6 (*)		1.70	B		3.65	
		0.6 + 0.6		1.42	D		2.85	

(*) Combinations not recommended (dimensions)