

**1.Scope**

This standard applies to the crimping of the 250 series Tab and Receptacle Contacts

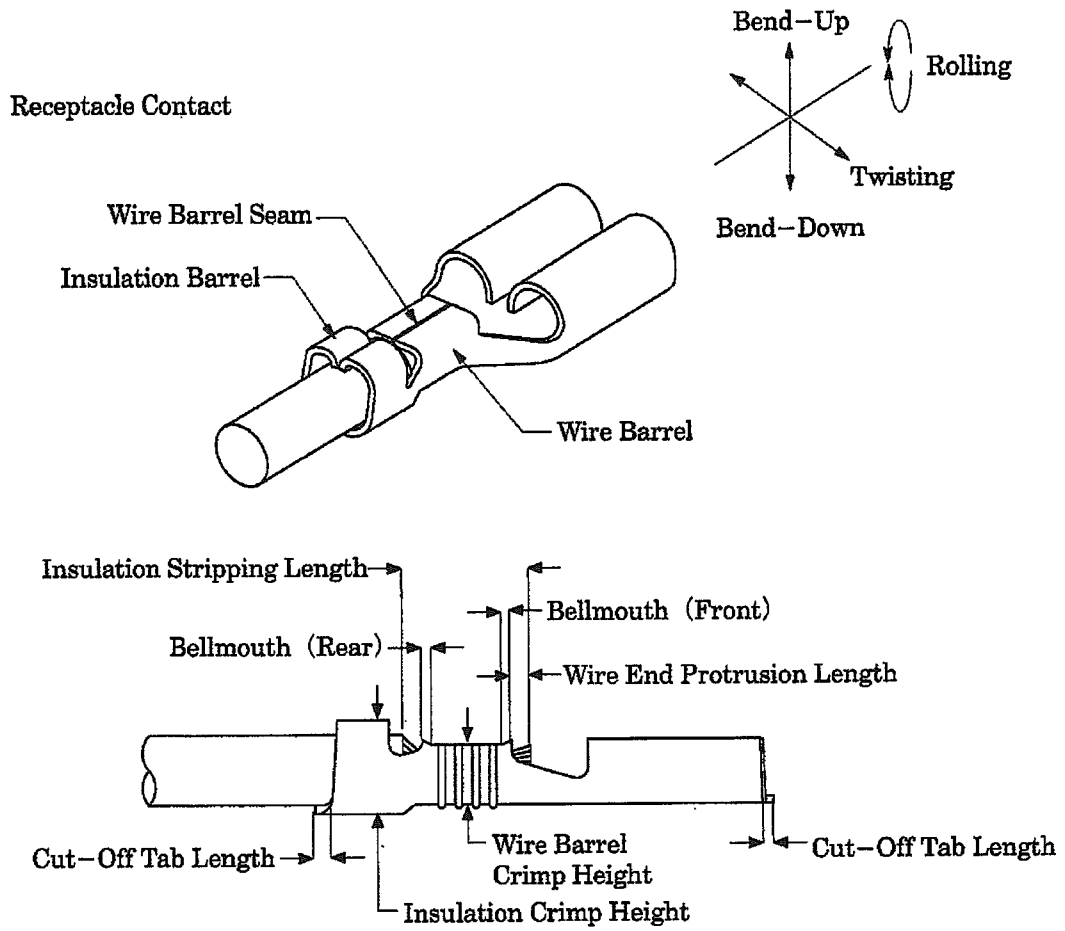
**2.Applicable Contacts**

| Contact Part No. | Descriptions        |
|------------------|---------------------|
| 170342           | Receptacle Contacts |
| 1376071          |                     |
| 170350           |                     |
| 170054           |                     |
| 170368           |                     |
| 170384           |                     |
| 170082           |                     |
| 170081           |                     |
| 170089           |                     |
| 170258           |                     |
| 179461           |                     |
| 170340           | Tab Contacts        |
| 170341           |                     |
| 170349           |                     |
| 170367           |                     |
| 170383           |                     |
| 170030           |                     |
| 170088           |                     |
| 170051           |                     |
| 179462           |                     |
| 170302           |                     |

## Crimping of 250 Series Tab and Receptacle Contacts

114-5052

### 3. Name of Parts



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### 4. Crimp Conditions and Data :

#### 4.1 Crimp Conditions :

\* The values in parentheses indicate the limits for hand tool crimp.

| No |                            |           | Crimping Requirements  |  | Remarks |
|----|----------------------------|-----------|--|--|---------|
|    |                            |           | Receptacle   | Tab  |         |
|    |                            |           | 170342,1376071,170350,<br>170368,170384,170032,<br>170031,170258,170054,<br>179461                                     | 170340,170341,170349,<br>170367,170383.170030,<br>170088,170051,179462 |         |
| 1  | Cut-off Tab Length         |           | 0.5mm Max.   |  |         |
| 2  | Bellmouth                  | Front     | 0.5mm Max * (0.9mm Max.)   |  |         |
|    |                            | Rear      | 0.15~0.65mm * (0.15-1.0mm)   |  |         |
| 3  | Deformation after Crimping | Bend-Up   | 5° Max * (6° Max.)   | 4° Max * (5° Max.)   |         |
|    |                            | Bend-Down | 3° Max * (3° Max.)   | 3° Max * (3° Max.)   |         |
|    |                            | Twisting  | 10° Max * (10° Max.)   | 5° Max * (8° Max.)   |         |
|    |                            | Rolling   | 8° Max * (8° Max.)   | 5° Max * (8° Max.)   |         |
| 4  | Wire End Protrusion Length |           | 0~2mm  | *1   |         |
| 5  | Wire Barrel Seam           |           | Seam to be closed ; a slight opening of seam can be permissible, on condition that no strands stray out of the barrel. |  |         |

\*1 ; 0~1.5mm : THIS SPEC APPLY TO 250 DOUBLE LOCK CONNECTOR SERIES.

#### 4.2 Crimp Data :

##### 4.2.1 Hand Tool Crimp

| Hand Tool Part Numbers | Contact Part Numbers | Wire Size mm <sup>2</sup> (AWG) | Wire Barrel Crimp |               | Crimp Tensile Strength (kg) (Min.) |
|------------------------|----------------------|---------------------------------|-------------------|---------------|------------------------------------|
|                        |                      |                                 | Crimp Height (mm) | Crimp Symbols |                                    |
| 934677-1               | 170051<br>179462     | 0.5(#20)                        | 1.18-1.37         | 20-18         | 6.0                                |
|                        |                      | 0.85(#18)                       | 1.18-1.45         |               | 8.0                                |
|                        |                      | 1.25(#16)                       | 1.34-1.61         | 16-14         | 18.0                               |
|                        |                      | 2.0(#14)                        | 1.34-1.83         |               | 23.0                               |
| 934678-1               | 170054<br>179461     | 0.5(#20)                        | 1.05-1.23         | 20-18         | 6.0                                |
|                        |                      | 0.85(#18)                       | 1.05-1.23         |               | 8.0                                |
|                        |                      | 1.25(#16)                       | 1.21-1.48         | 16-14         | 18.0                               |
|                        |                      | 2.0(#14)                        | 1.21-1.73         |               | 23.0                               |

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4.2 Crimping Data

4.2.2 Crimping by Applicator

| Contact No. (Strip)                  | Applicator No. | Wire Size (Nominal) | Wire Barrel Crimp |        |      | Insulation Barrel Crimp |          | Crimp Tensile Strength (kg) |
|--------------------------------------|----------------|---------------------|-------------------|--------|------|-------------------------|----------|-----------------------------|
|                                      |                |                     | Width             | Height | Disc | Width                   | Height   |                             |
| 170340                               | 722798         | 0.5                 | 2.79 "F"          | 1.35   | D    | 4.57 "F"                | 3.1 Max. | 9 Min.                      |
|                                      |                | 0.85                |                   | 1.42   | C    |                         |          | 13 Min.                     |
|                                      |                | 1.25                |                   | 1.55   | B    |                         |          | 18 Min.                     |
|                                      |                | 2.0                 |                   | 1.68   | A    |                         |          | 27 Min.                     |
| 170030 Note(4)                       | 721300 Note(3) | 0.5                 | 2.79 "F"          | 1.35   | D    | 5.33 "Oval"             |          | 9 Min.                      |
|                                      |                | 0.85                |                   | 1.42   | C    |                         |          | 13 Min.                     |
|                                      |                | 1.25                |                   | 1.55   | B    |                         |          | 18 Min.                     |
|                                      |                | 2.0                 |                   | 1.68   | A    |                         |          | 27 Min.                     |
|                                      | 722798         | 2.79 "F"            | 0.5               | 1.35   | D    | 4.57 "F"                |          | 9 Min.                      |
|                                      |                |                     | 0.85              | 1.42   | C    |                         |          | 13 Min.                     |
|                                      |                |                     | 1.25              | 1.55   | B    |                         |          | 18 Min.                     |
|                                      |                |                     | 2.0               | 1.68   | A    |                         |          | 27 Min.                     |
| 170341                               | 722799         | 2.0                 | 3.30 "F"          | 1.73   | B    | 4.57 "F"                | 3.3 Max. | 27 Min.                     |
|                                      |                | 3.0                 |                   | 2.03   | A    |                         |          | 30 Min.                     |
| 170088                               | 721305         | 2.0                 | 3.30 "F"          | 1.73   | B    | 4.57 "F"                | 3.3 Max. | 27 Min.                     |
|                                      |                | 3.0                 |                   | 2.03   | A    |                         |          | 30 Min.                     |
| 170342<br>170371<br>170032<br>170031 | 721160         | 0.5                 | 2.79 "F"          | 1.12   | D    | 4.57 "F"                | 3.1 Max. | 9 Min.                      |
|                                      |                | 0.85                |                   | 1.19   | C    |                         |          | 13 Min.                     |
|                                      |                | 1.25                |                   | 1.35   | B    |                         |          | 18 Min.                     |
|                                      |                | 2.0                 |                   | 1.45   | A    |                         |          | 21 Min.                     |
| 170089<br>170258<br>1376071          | 721306         | 2.0                 | 3.30 "F"          | 1.47   | B    | 4.57 "F"                | 3.3 Max. | 27 Min.                     |
|                                      |                | 3.0                 |                   | 1.78   | A    |                         |          | 30 Min.                     |
| 170349<br>170367<br>170383           | 722787         | 0.3                 | 1.78 "F"          | 1.22   | B    | 3.05 "O"                |          | 8 Min.                      |
|                                      |                | 0.5                 |                   | 1.30   | A    |                         |          | 9 Min.                      |
| 170350<br>170368<br>170384           | 722788         | 0.3                 | 1.52 "F"          | 1.10   | B    | 2.79 "O"                |          | 8 Min.                      |
|                                      |                | 0.5                 |                   | 1.20   | A    |                         |          | 9 Min.                      |
| 170302                               | 722766         | 0.3                 | 2.29 "F"          | 1.25   | C    | 5.33 "O"                |          | 8 Min.                      |
|                                      |                | 0.5                 |                   | 1.33   | B    |                         |          | 9 Min.                      |
|                                      |                | 0.85                |                   | 1.44   | A    |                         |          | 13 Min.                     |

Notes :

- (1) The tolerance of wire barrel shall be within  $\pm 0.05$
- (2) Unless otherwise noted, the dimensions shown in Table shall be in mm
- (3) This applicator is of a restricted type, having width of insulation barrel in 5.33mm of oval type crimp.
- (4) When crimping 170030, two kinds of i.e. 4.57mm "F" and 5.33mm "Oval" are available. Select proper type according to the mounting housing.