

.020K Recep. Terminal



1. SCOPE

This specification contains the guidelines for the application of contact system 020K.

It applies primarily to the full- or semi-automatic application of the contacts

2. REFERENCED DOCUMENTS

2.1 Customer Drawings

The dimensions and materials of the contacts are shown in the TE customer drawings.

In the case of a conflict between this document and the customer drawing, the customer drawing takes precedence.

2.2 Product Specification

The Product Specification 108-61263 describes the characteristics of these contacts, together with the electrical and mechanical requirements.

2.3 Application Specification

The crimp quality must also comply with the general guidelines laid down in the application specification 114-18022.

3. DESCRIPTION OF NOMENCLATURE

The following terms are used in the specification. Fig.1

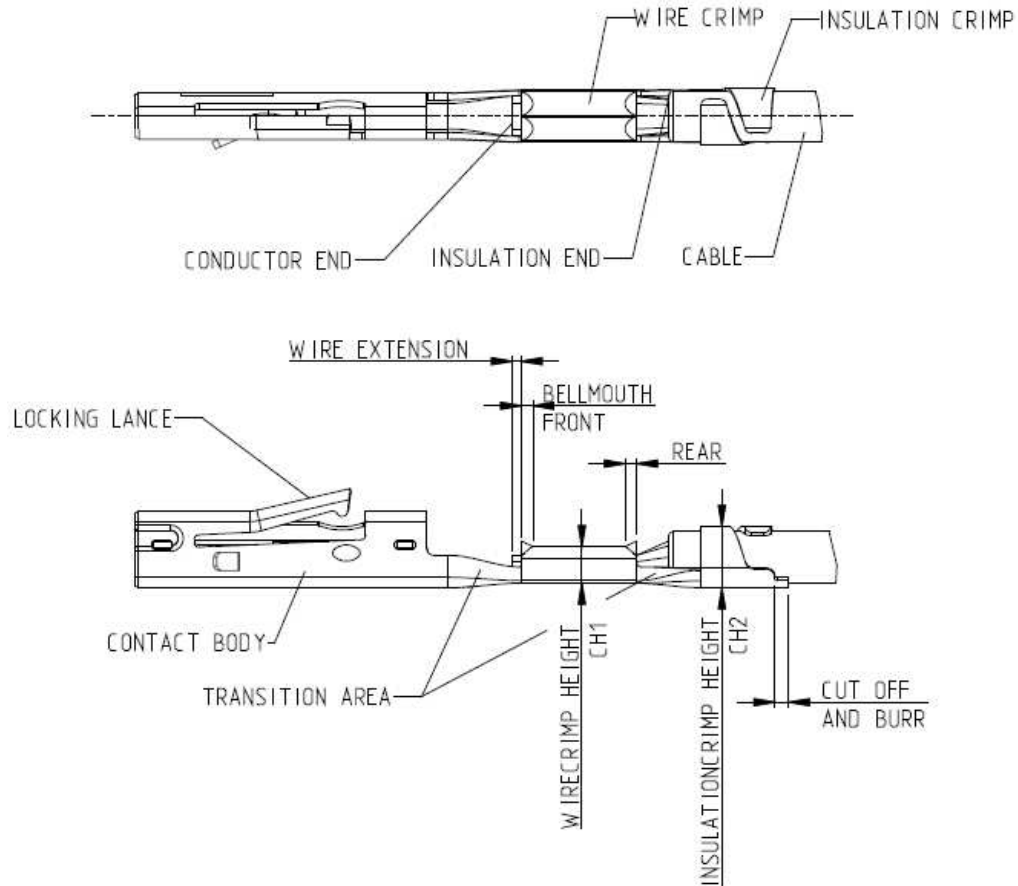


Fig. 1

4. REQUIREMENTS

4.1 Wire

Only single termination is permitted.

4.2 Cut off Tab

The cut off tab is still visible and may be 0.2mm Max long.

4.3 Wire Crimp

A. Wire position

After crimping the end of the wire must extend 0 to 0.4mm beyond the front edge of the wire crimp.

No upcoming strands. In no case may the end of the insulation be crimped under the wire crimp.

B. Crimping data

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

Crimp height measurement: see 114-18022.

C. Burr on base of crimp

Any burr on the base of the crimp may not exceed 0.1mm

D. Bellmouth

The rear bellmouth must be $0.25^{+0.15}$ according to Spec. 114-18022.

The front bellmouth should be absent or can be 0.15mm Max.

4.4 Transition

A bulging of contact material to the outside at the transitions of wire crimp to body and wire crimp to insulation crimp is not allowed.

4.5 Insulation Crimp

The shape and width are shown in Table 1.

The crimp height is set according the bending or winding test as described in Spec 114-18022.

To ensure loading it is important to keep the crimper width test dimension CP₂ in tolerance.

This dimension must also kept in the transition-areas.

4.6 Contact Area

Neither the locking lance nor the contact body may be bent or deformed.

max. CP2

0...0.4

CP2

A

0.1 A

B

0.1±0.1

0.1±0.1

0.15 B

0.15 B

Trennsteg max.0.2

CUT-OFF max.0.2

Fig. 2

5. CRIMP DATA

Table 1: 020K Application Crimp									
Contact P/N	Wire Range (mm ²)	Insulation Range Ø (mm)	Strip Length (mm)	Wire Barrel Crimp			Insulation Barrel Crimp		
				Width(CB ₁) (mm)	Height (CH ₁) (mm)	Crimper Width Test Dimension CP ₁ (mm)	Width(CB ₂) (mm)	Height(CH ₂) (mm)	Crimper Width Test Dimension CP ₂ (mm)
2219299-1	0.22	0.95-1.2	3.65 ± 0.15	1.07 “F”	0.65 ± 0.02	1.07 +0.15	1.27 “O” Wrap	1.6 Max	1.5 Max
2351499-1	0.3	1.4-1.5			0.66 ± 0.02				
2459353-1	0.35	1.2-1.4							



6. APPLICABLE WIRE RANGE

Nominal Wire Size	Number of Strands / Diameter of Strand (mm)	Calculated Cross Section Area (mm ²)	Overall outside Diameter (mm)	
			Normal	Maximum
0.22	7 / Compressed	0.2425	0.95	1.2
0.3	7 / 0.26	0.3717	1.4	1.5
0.35	12 / 0.21	0.4156	1.2	1.4