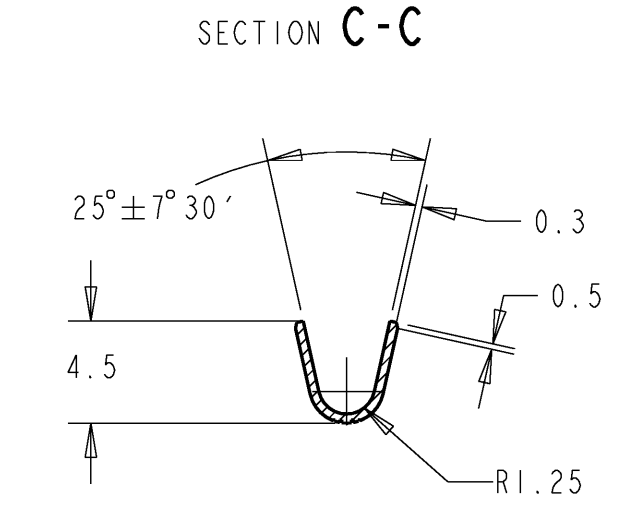
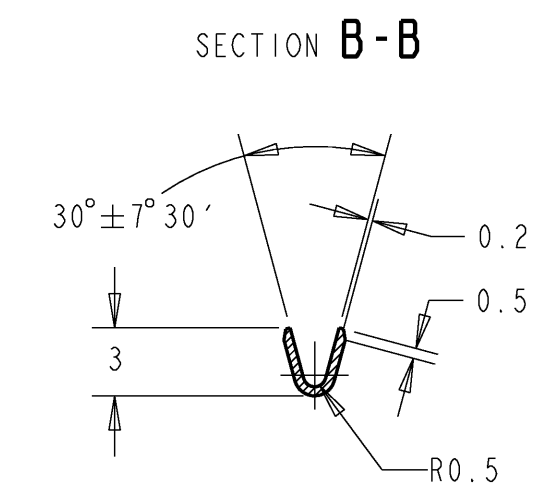
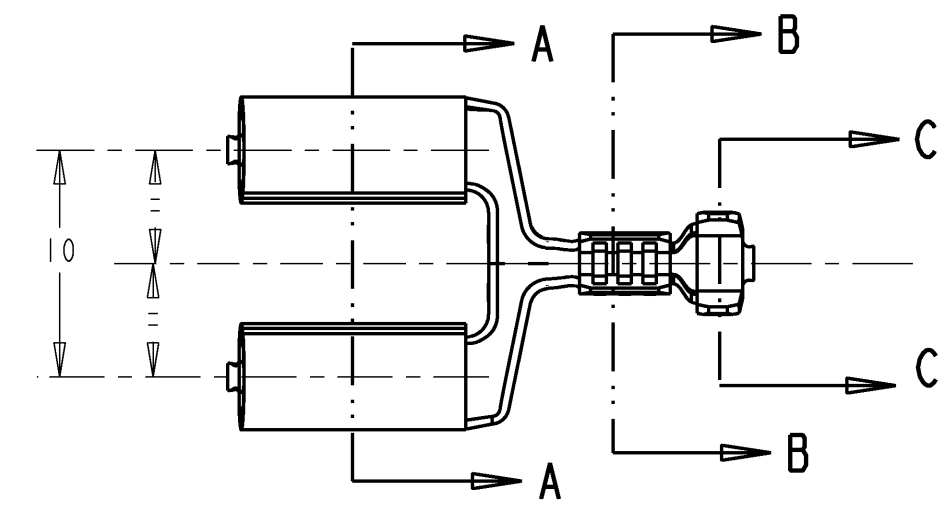
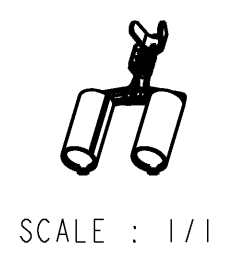
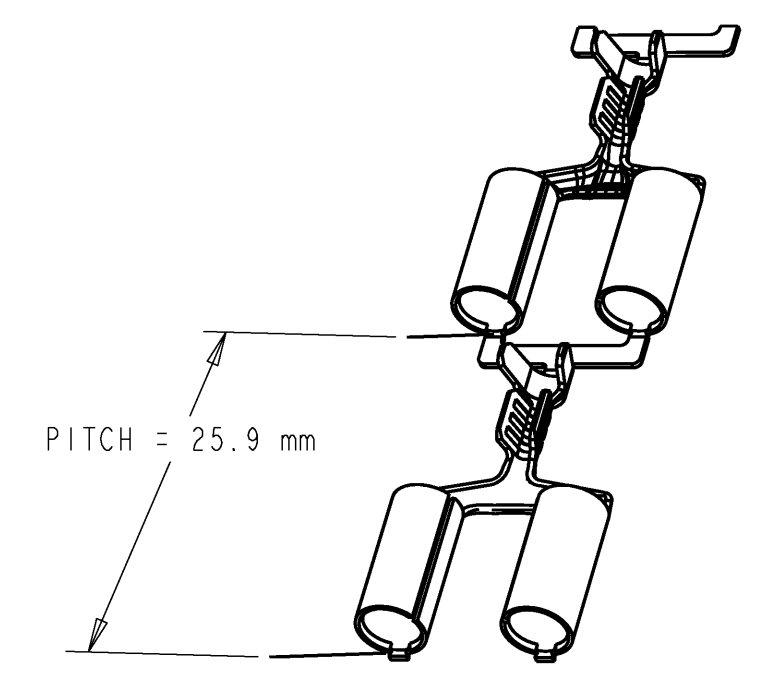
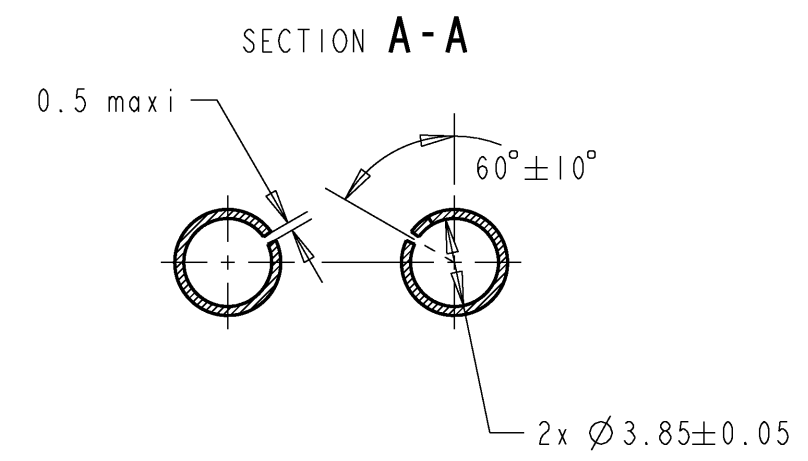
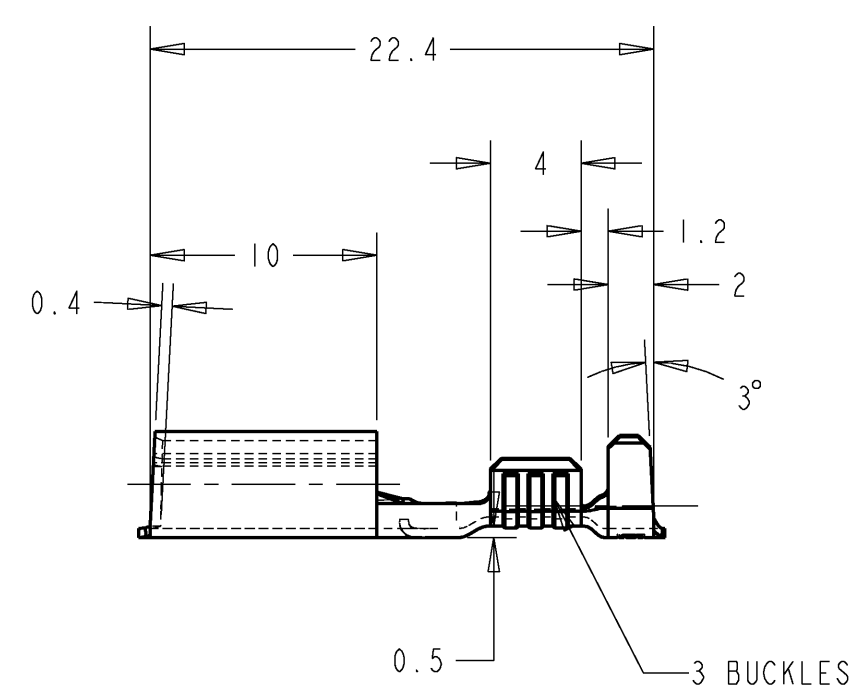


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LOC	DIST	REVISIONS				
P	LTR	DESCRIPTION MODIFICATIONS	DATE	DWN DESS.	APVD APP.	
F	00	A	Modif. diam. 3.7 => 3.85; 0.15 => 0.5 max	14JUN2004	PFs	JDr
		B	M&J specification de sertissage après qualification	31 Oct 2006	PFs	JDr
			Ajout valeurs de tractions + section 0.5²			
		C	Tol sur angle 10°, +/-5 *devient +/-10°	07 NOV 2007	PFs	JDr
		D	Real sections wires and conductor	09 JAN 2009	PFs	JDr
		D	crimping width set up. English translation	" " "	"	"



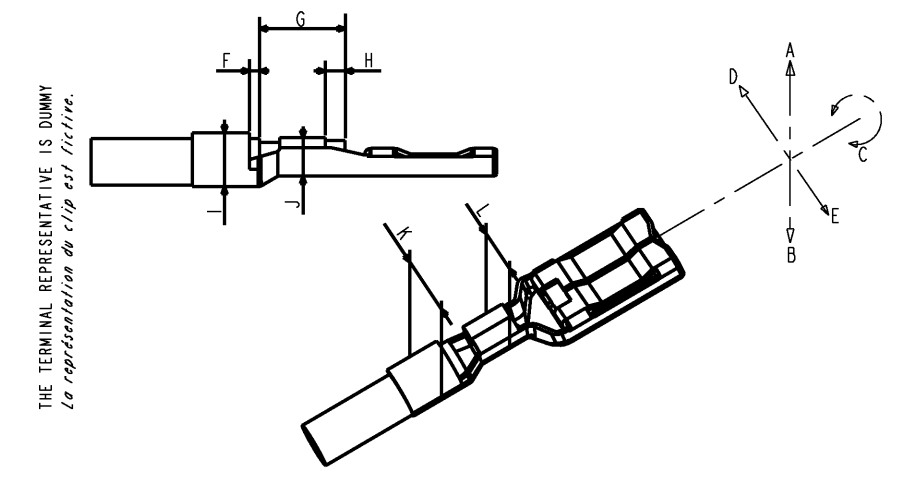
NOTE:

- INSERTION FORCE MEASURES : (FOR EACH WAY)
- Ø MALE CALIPER = 4±0.05 mm
- INSERTION FORCE Min = 15N
- INSERTION FORCE Max = 80N
- EXTRACTION FORCE Min = 15N
- EXTRACTION FORCE Max = 90N
- MATERIAL: PRE-TINNED PHOSPHORUS BRONZE, THICKNESS = 0.4mm

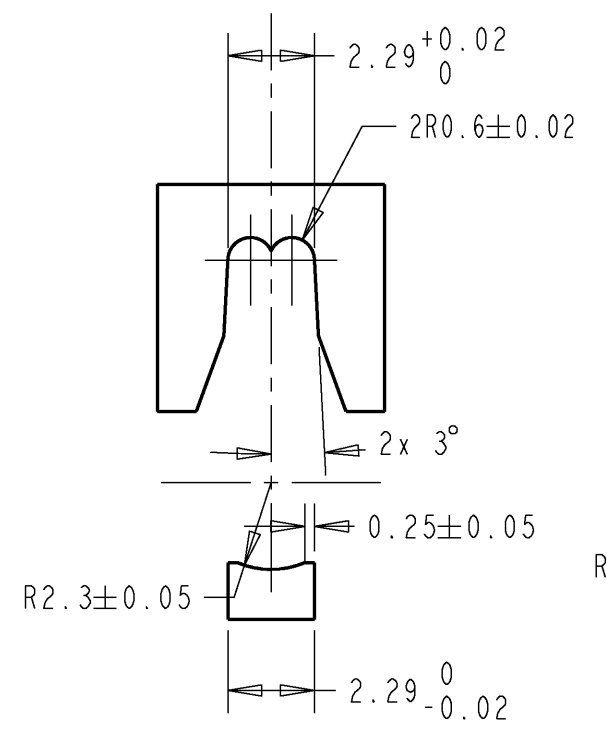
CRIMPING PARAMETERS

CRIMPING CONDUCTOR BARREL	WIRE BARREL LAYOUT = 6.4mm				INSULATION HOOPING		WIRE BARREL LAYOUT = 10.3mm		
	REAL mm²	WIDTH L±0.1	HEIGHT J±0.05	TRACTION (N)	REPRESENTATIVE CONFIGURATION	Ø ISOLANT mini	Ø ISOLANT Maxi	WIDTH K±0.2	HEIGHT I±0.1
0.35 IR	0.32	2.32	1.28	> 60N	0.35 IR	1.25	1.4	3.6	2.6
0.5 IR	0.49	2.32	1.33	> 70N	0.5 IR	1.4	1.7	3.6	2.65
0.6 IR	0.56	2.32	1.37	> 80N	0.6 IR	-	1.8	3.6	2.7
1 IR	0.93	2.32	1.43	> 115	1 IR	1.99	2.15	3.6	2.85

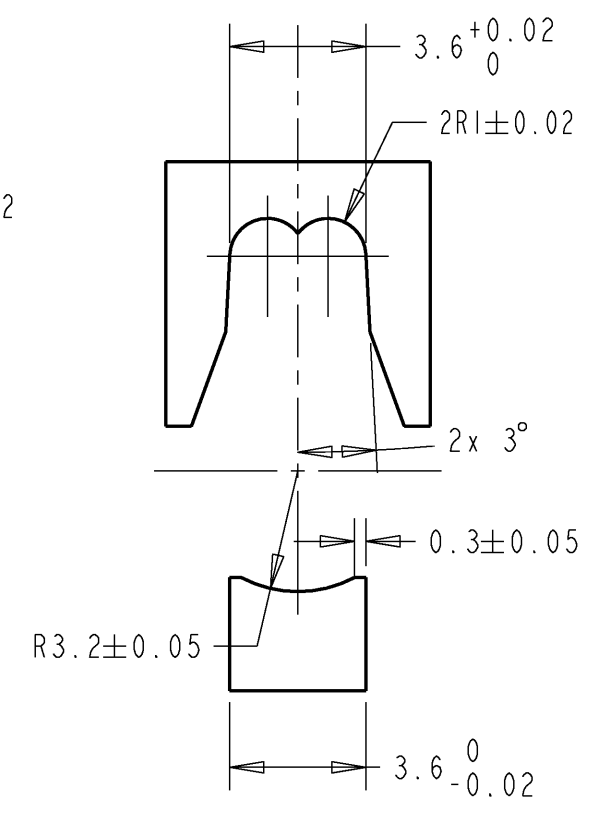
PN Tyco Electronics	PN CUSTOMER
1544516-1	



CRIMPER AND ANVIL CONDUCTOR BARREL



CRIMPER AND ANVIL INSULATE BARREL



CHECKING CHARACTERISTICS	VALUE TO MEASURE	REPERE
DEFORM AFTER CRIMPING	INFLECTION UPWARDS	2° maxi A
	INFLECTION DOWNWARDS	2° maxi B
	TWIST	3° maxi C
DEFORM AS PART AXIS	2° maxi	D - E
STRIPPING LENGTH	5.5±0.5	G
WIRE EXCESS	0.6±0.5	H
INSULATE BEHAVIOUR	DOUBLE INFLECTIONS AT 90°	A-B et D-E

THIS DRAWING IS A CONTROLLED DOCUMENT FOR TYCO ELECTRONICS CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.
 CE PLAN EST UN DOCUMENT CONTROLE PAR AMP INCORPORATED. IL EST SUSCEPTIBLE D'ETRE REVISE. CONTACTER LE SERVICE TECHNIQUE D'AMP DE FRANCE POUR OBTENIR LA DERNIERE REVISION.

DIMENSIONS:	TOLERANCES UNLESS OTHERWISE SPECIFIED: (SUIV NB DE DECIMALES) 0 PLC/DEC: ± 1 PLC/DEC: ± 2 PLC/DEC: ±0.15 3 PLC/DEC: ± 4 PLC/DEC: ± ANGLES ±5°	DWN/DESSINE P. FLORES 14jun04 CHK/VERIFIE L. CORONELLI 14jun04 APVD/APPROUVE J. DAHER 14jun04	Tyco Electronics France SAS RN 90, 38530 Chapareillan
MATERIAL MATIERE	SEE TABLE	PRODUCT SPEC SPEC. PRODUIT APPLICATION SPEC SPEC. APPLICATION WEIGHT MASSE APPROX. 1.5g	NAME TITRE - DOUILLE DOUBLE A SERTIR DOUBLE RING TO CRIMP
CUSTOMER DRAWING /PLAN CLIENT		UNIQUEMENT POUR REFERENCE	SCALE ECHELLE : SHEET FEUILLE OF DE REV D