Lamp Socket Terminal , Application of

1. SCOPE

1.1 Content

This specification covers the requirements for application of the Lamp Socket Terminal .
These requirements are applicable to automatic and bench machines crimping tools .
For specific wire and insulation ranges relative to the product covered in this specification see Figure 4 .

1.2 Design

a) Contact may be disengaged from its lamp base by deflection the frontal contact .
b) The electrical contact in the lamp base is completed only if two terminals are loaded in each cavity of the appropriate housing .

2. TERMINOLOGY

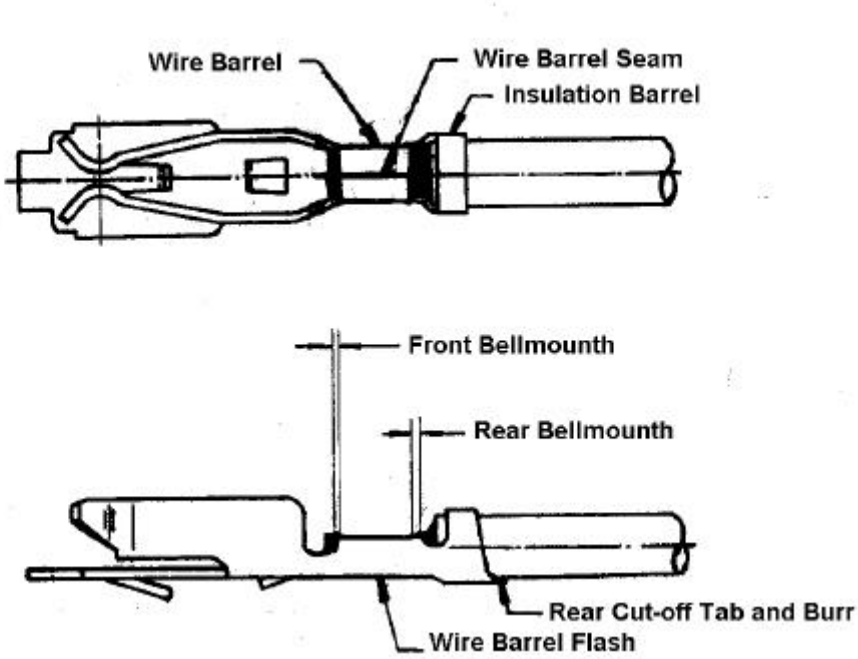


Figure 1

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1 Wire Preparation

a) Strip Length

Insulation shall be stripped as indicated in Figure 4 .

b) Workmanship

Reasonable care shall be taken not to nick , scrape or cut any strands or the solid wire during the stripping operation .

3.2 Carrier Cutoff Tab and Burr

a) Cutoff Tab

Cutoff tab shall not exceed .015 .

b) Burr

Burr on cutoff shall not exceed .005 .

3.3 Wire Barrel Crimp

a) Crimp Dimensions and Type

Crimp height , width and type shall be as shown in Figure 4 .

b) Wire Barrel Flash

Wire barrel flash shall not exceed .005 .

c) Wire Barrel Seam

Wire barrel seam shall be completely closed and there shall be no evidence of loose wire strands or wire strands visible in the seam .

d) Bellmounth

(1) Rear bellmounth length shall be .015 - .025 .
(2) Front bellmounth length shall not exceed .025 .

e) Conductor Location

(1) End of the wire shall be flush with the front end of the wire barrel or extend .030 maximun after crimping .

(2) Both insulation and conductor shall be visible between the insulation barrel and wire barrel .
Care shall be taken not to allow insulation to be crimped in the wire barrel .

3.4 Insulation Barrel Crimp

a) Crimp Dimensions and Type

Crimp height , width and type shall be as shown in Figure 4 .

b) Workmanship

Reasonable care shall be taken not to cut or break the insulation during the crimping operation .

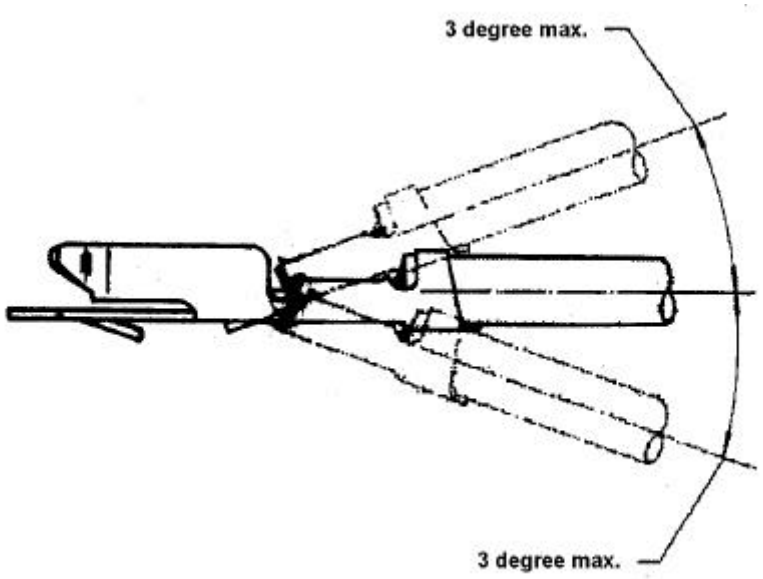
3.5 Locking Latch

Locking latch shall not be deformed .

3.6 Alignment

a) Straightness

(1) The contact , including the cutoff and burr shall not be bent above or bellow the datum lines more than amount shown in Figure 2 .



(2) The side to side bending of the contact shall not exceed the limits specified in Figure 3 .

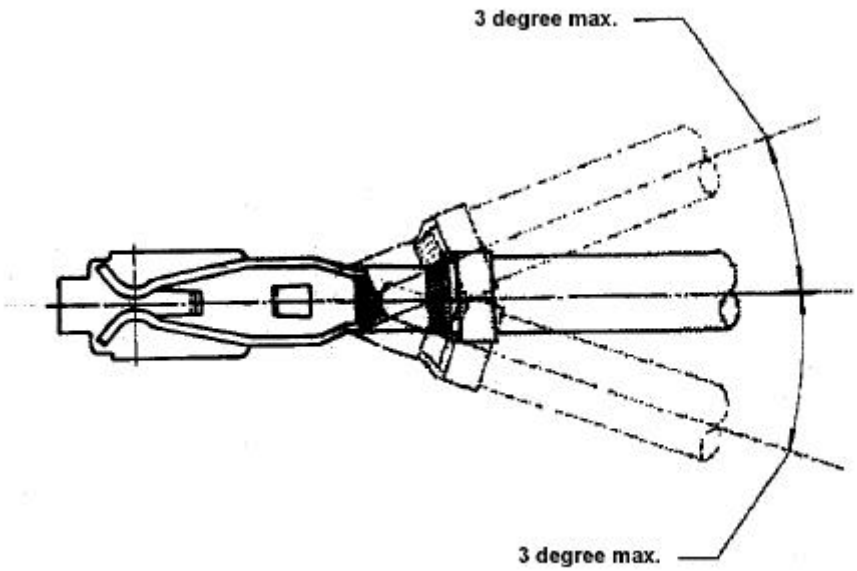


Figure 3

b) Twist or Roll

There shall be no twist or roll in crimped portion that will impair usage of the contact .

4. CRIMPING DATA

4.1 Reference Log P/N 572667-0

Part Number	Wire Size	Insulation Diameter	Strip Length	Wire Barrel Crimp			Insulation Barrel Crimp			Used On
				Width	Heigh +/- .005	Type	Width	Heigh	Type	
626277-1 626277-2	0,5 mm² 0,75 mm² 1,0 mm² 1,5 mm²	1,9 – 2,7 mm	3,8 – 4,6 mm	2,29 (.090)	1,40 mm 1,50 mm 1,60 mm 1,75 mm	F	4,57 (.180)	(a)	F	Regular Wires / Housing P/N 626460-X

(a) Insulation shall be securely held by the insulation barrel and crimp height is dependent upon insulation diameter .

4.2 Reference Log P/N 572667-5

Part Number	Wire Size	Insulation Diameter	Strip Length	Wire Barrel Crimp			Insulation Barrel Crimp			Used On
				Width	Heigh +/- .005	Type	Width	Heigh	Type	
626277-1 626277-2	0,5 mm² 0,75 mm² 1,0 mm² 1,5 mm²	1,9 – 2,7 mm	3,8 – 4,6 Mm	2,29 (.090)	1,40 mm 1,50 mm 1,60 mm 1,75 mm	F	4,06 (.160)	(a)	OV	Thin Wall Wires / Housing P/N's 626276-X / 626460-X / 699499-X

(a) Insulation shall be securely held by the insulation barrel and crimp height is dependent upon insulation diameter .

4.3 Reference Log P/N 572667-6 (VW / Audi / Skoda)

This Applicator doesn't apply 0,5mm² wire

Part Number	Wire Size	Insulation Diameter	Strip Length	Wire Barrel Crimp			Insulation Barrel Crimp			Used On
				Width	Heigh +/- .005	Type	Width	Heigh	Type	
626277-1 626277-2 626277-3 626277-4	0,75 mm² 1,0 mm² 1,5 mm²	1,9 – 2,7 mm	3,8 – 4,6 mm	2,29 (.090)	1,50 mm 1,60 mm 1,75 mm	F	3,55 (.140)	(a)	OV	Thin wall wires / housing P/N's 626276-X / 626460-X / 699499-X 1718178-X

(a) Insulation shall be securely held by the insulation barrel and crimp height is dependent upon insulation diameter .

Figure 4

4.4 Reference Log P/N 2-297762-5 (0,5 – 1,00 mm²)

Part Number	Wire Size	Insulation Diameter	Strip Length	Wire Barrel Crimp			Insulation Barrel Crimp			Used On
				Width	Heigh +/- .005	Type	Width	Heigh	Type	
1599382-1 1599382-2 1599382-3 1599382-4	0,50 mm² 0,75 mm² 1,00 mm²	1,4 – 2,3 mm	3,8 – 4,6 mm	2,03 (.080)	1,40 mm 1,50 mm 1,60 mm	F	2,79 (.120)	(a)	OV	Thin wall wires / housing P/N's 626276-X / 626460-X / 699499-X 1718178-X

(a) Insulation shall be securely held by the insulation barrel and crimp height is dependent upon insulation diameter .

Figure 4 (cont.)

Revision Record		
Revision	**Date**	**Description**
O	28-Sep-1999	Issued
A	10-May-2002	LB00-0121-02
B	13-May-2002	LB00-0123-02
C	06-Jun-2002	LB00-0146-02
D	13-Apr-2004	LB00-0199-04
E	17-Sep-2004	LE10-0286-04