

**Pitch 1.25mm,  
Economic Metric Interconnect Series,  
Wire-To-Board System.**

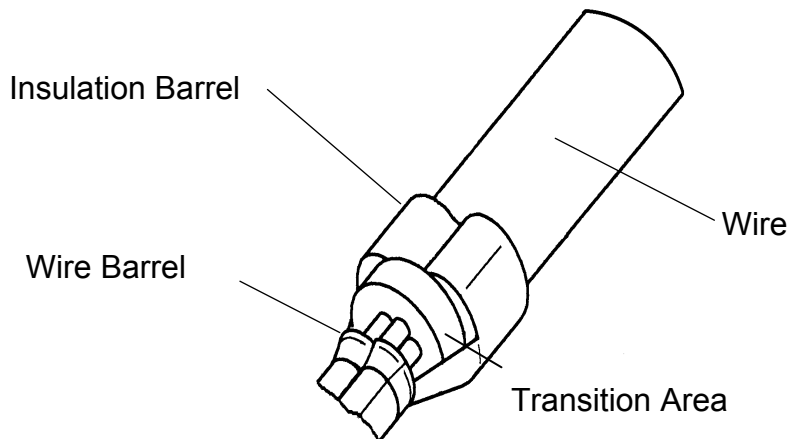
**1. SCOPE**

This specification covers the requirements for crimping of Pitch 1.25mm, Economic Metric Interconnect Series, Crimp Type, Wire-To-Board System Connector. These requirements are applicable to specific tools. For specific wire and products covers in this specification refer to the appropriate Tyco customer drawing.

**2. APPLICABLE PRODUCT**

Contact Form	Product Part Number	Crimping Tool	Wire Size (SQ mm)	Ins. Diameter (mm)
Strip Terminal	X-440147-X	Applicator	0.03 ~ 0.08mm <sup>2</sup> (AWG #32 ~ #28)	$\varphi$ 0.9 ~ $\varphi$ 1.0mm

**3. NOMENCLATURE**



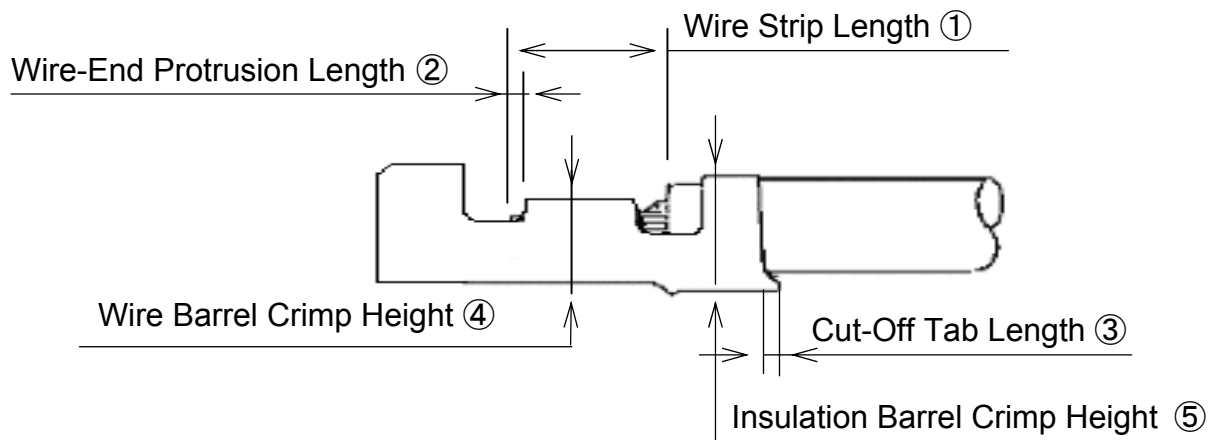
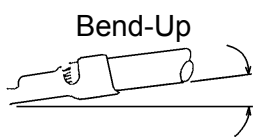
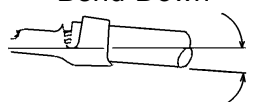
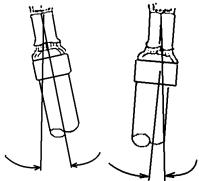
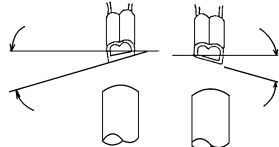


FIG 1.

4. CRIMPING REQUIREMENT

No.	Check Items	Crimping Requirements		Remarks	
		Applicator	Hand Tool		
1	Wire Strip Length	0.9 ~ 1.3 mm		Fig.1 – ①	
2	Wire-End Protrusion Length	0.1 ~ 1.3 mm		Fig.1 – ②	
3	Cut-Off Tab Length	0.0 ~ 0.2 mm		Fig.1 – ③	
4	Wire Barrel Crimp	Refer Table.1		Fig.1 – ④	
5	Insulation Barrel Crimp Height	Refer Table.1		Fig.1 – ⑤	
6	Allowable Deviation after Crimping	 <p>Bend-Up</p>	6° Max.	6° Max.	
7		 <p>Bend-Down</p>	6° Max.	6° Max.	

8		<p style="text-align: center;">Twisting</p> 	5° Max.	5° Max.	
9		<p style="text-align: center;">Rolling</p> 	7° Max.	7° Max.	

**5. CRIMPING DATA**

Table.1

Contact Part Number	Applicator Part Number	Wire Size		Insulation Barrel		Wire Barrel	
		Number of Wire	Size	Crimp Height (A)	Crimp Width (B)	Crimp Height (C)	Crimp Width (D)
X-440147-X	N/A	1	0.08mm <sup>2</sup> (#28)	1.25mm	0.9~1.0mm	0.51~0.56mm	0.80mm
		1	0.05mm <sup>2</sup> (#30)	1.17mm	0.9~1.0mm	0.48~0.53mm	0.80mm
		1	0.03mm <sup>2</sup> (#32)	1.00mm	0.9~1.0mm	0.46~0.51mm	0.80mm

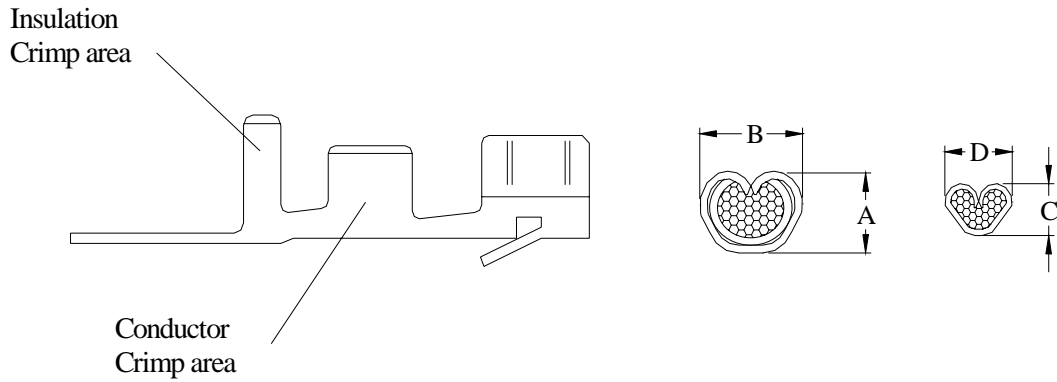


Table.2

Wire Size		Crimp Tensile Strength
MM <sup>2</sup>	AWG#	N (kgf) Min.
0.08	28	14.7 (1.5)
0.05	30	9.80(1.0)
0.03	32	4.90(0.5)

- Note: (a) Tool mark is allowable at crimped areas and transition areas only.  
 (b) The dimensions of crimp width of wire barrel and insulation barrel are the dimensions of crimping tool.