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## Application specification of Mini FASTON

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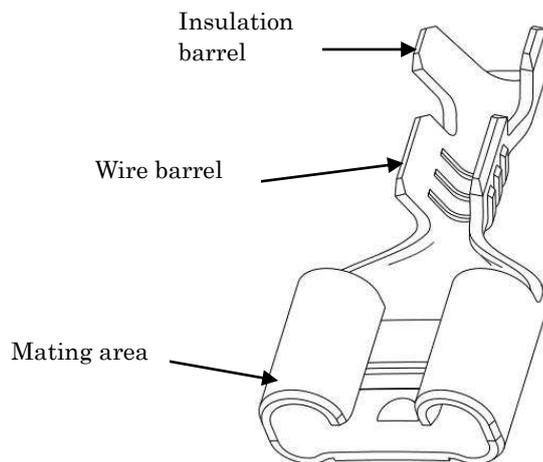
### 1. INTRODUCTION

This specification covers the requirements for application of Mini FASTON receptacles for wire-to-wire applications. Receptacle features a wire barrel with a lip that, when crimped, wraps around and captures the wire.

The receptacles accept a mating tab with a width of .250 inch [6.3 mm] with a thicknesses of .032 inch [0.81 mm]; Receptacle features a round detent that, when mated, engages the mating tab hole to provide the required retention force.

The receptacle is available in reeled form for terminating with automatic and semi-automatic machines.

When corresponding with TE Connectivity Personnel, use the terminology provided in this specification to facilitate your inquiries for information. Basic terms and features of this product are provided.



### 2. REFERENCE MATERIAL

#### 2.1. Customer Assistance

Product and tooling information can be obtained through a local TE Representative, by visiting our website at [www.te.com](http://www.te.com), or by calling PRODUCT INFORMATION or the TOOLING ASSISTANCE CENTER at the numbers at the bottom of page 1.

#### 2.2. Drawing

Customer Drawings for product part numbers are available from the service network. If there is a conflict between the information contained in the Customer Drawings and this specification or with any other technical documentation supplied, call PRODUCT INFORMATION at the number at the bottom of page 1.

#### 2.3. Specifications

Product Specification provides product performance requirements. Document

108-106216 Product specification

## 2.4. Instructional Material

The following available Instruction Sheets (408-series) are customer documents that provide application tooling information.

408-10390 Instruction Sheet for Ocean End-Feed Applicators

## 3. REQUIREMENTS

### 3.1. Safety

Do not stack product shipping containers so high that the containers buckle or deform.

### 3.2. Storage

#### A. Ultraviolet Light

Prolonged exposure to ultraviolet light may deteriorate the chemical composition used in the receptacle material.

#### B. Shelf Life

The receptacles should remain in the shipping containers until ready for use to prevent deformation. The receptacles should be used on a first in, first out basis to avoid storage contamination that could adversely affect performance.

#### C. Chemical Exposure

Do not store receptacles near any chemical listed below as they may cause stress corrosion cracking.

Alkalies      Ammonia Citrates      Phosphates Citrates      Sulfur Compounds  
 Amines      Carbonates      Nitrites      Sulfur Nitrites Tartrates

### 3.3 Applicable Product Part Number

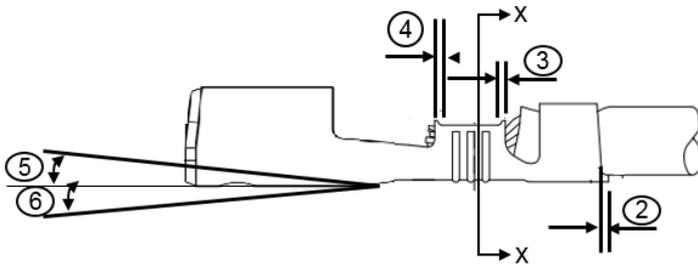
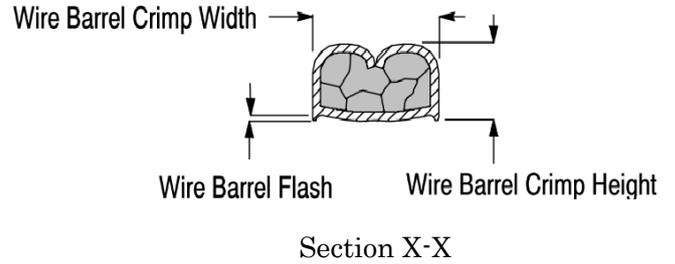
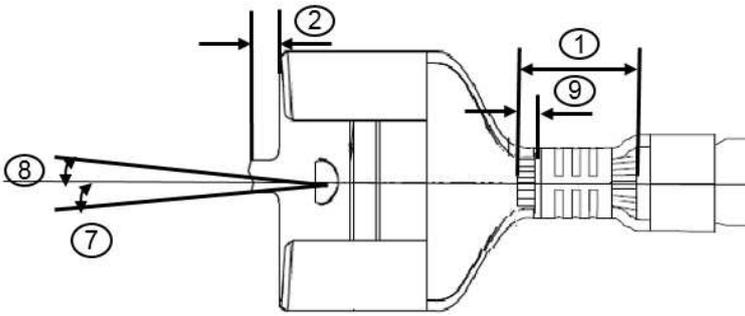
Description	Part No.	Wire Size	Insulation Diameter inch (mm)
Mini FASTON	X-2238045-X	AWG # 22- #18 (0.3 mm <sup>2</sup> ~0.8mm <sup>2</sup> )	.094-.110 (2.4-2.8)

### 3.4 Crimping Requirements

#### A. Crimping data

NO.	Check Item	Specified Requirements Inch (mm)	NO.	Check Item	Specified Requirements Inch (mm)
①	Insulation Stripping Length	.17±.02 (4.3±0.5)	⑥	Bend – Down	5° Max
②	Cut-Off Tab Length	.02 (0.5) Max	⑦	Twist	5° Max
③	Rear Bellmouth Length	.008~ .024 (0.2-0.6)	⑧	Roll	5° Max
④	Front Bellmouth Length	.024 (0.6) max.	⑨	Brush	Wire end must protrude from front end of wire barrel max. .019 (0.5)

⑤	Bend – Up	5° Max	Wire barrel flash	.0126 (0.32) Max.
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Contact Part No.(Strip)	Applicator No.	Wire size		Wire barrel Crimp		Insulation Barrel width
		No. of wires	AWG(mm2)	Width inch (mm)	Crimp Height inch (mm)	Width inch (mm)
X-2238045-X	X-2150663-X	1	22 AWG (0.3)	.090" (2.29)	.049+/--.002 (1.24+/-0.05)	.100" (2.54)
		1	20 AWG (0.5)		.051+/--.002 (1.30+/-0.05)	
		1	18 AWG (0.8)		.056+/--.002 (1.42+/-0.05)	

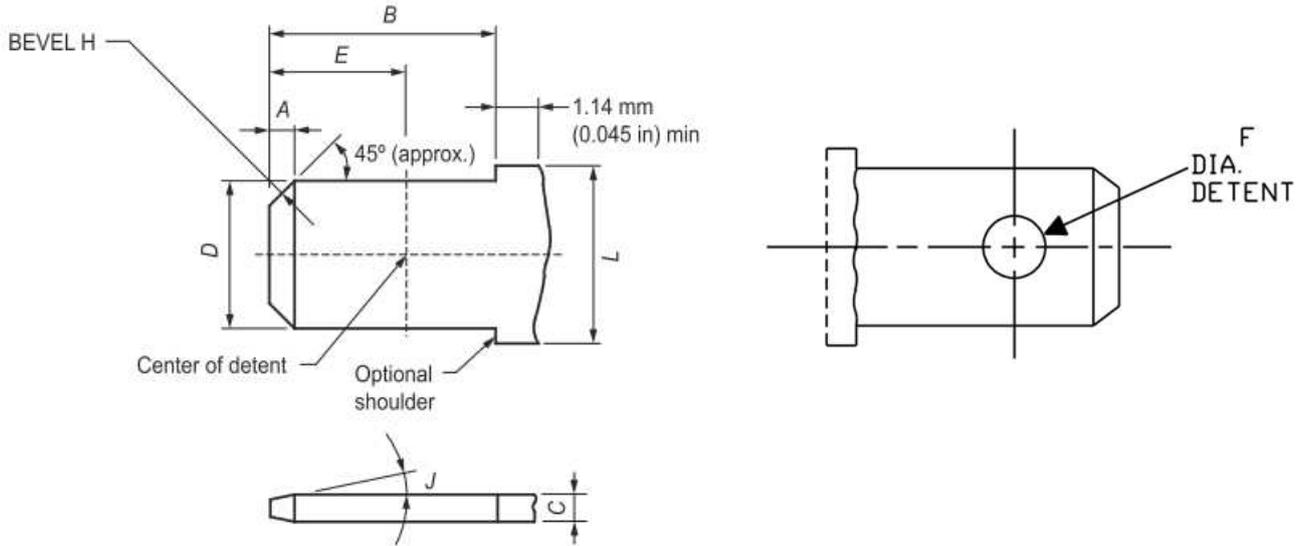
**Notes**

1. During wire preparation care must be taken not to damage or nick the wire strands.
2. Avoid foreign particles and greasy and oily matters from entering inside the wire barrel.
3. During termination, care must be taken to ensure all strands are captured. No visible strand outs permitted.
4. During termination process, care must be taken to ensure insulation does not enter wire barrel

**B. Tensile strength**

Wire range AWG (mm2)	TENSILE FORCE lbs (N)
22 (0.3)	8 (36)
20 (0.5)	13 (58)
18 (0.8)	20 (89)

### 3.5 Mating tab



unit:inch

Nominal size	A	B(min)	C	D	E	F	J
0.250 x 0.032 with hole	0.040		0.033	0.253	0.186	0.080	12°
	0.020	0.307	0.030	0.244	0.169	0.063	8°

unit:mm

Nominal size	A	B(min)	C	D	E	F	J
6.3 x 0.8 with hole	1.0		0.84	6.40	4.7	2.0	12°
	0.5	7.8	0.77	6.20	4.3	1.6	8°

Notes:

1. Included are dimensions are corresponding with UL310.
2. In the table where two values are provided, the lesser value is the minimum permitted value and the larger is the maximum permitted value.

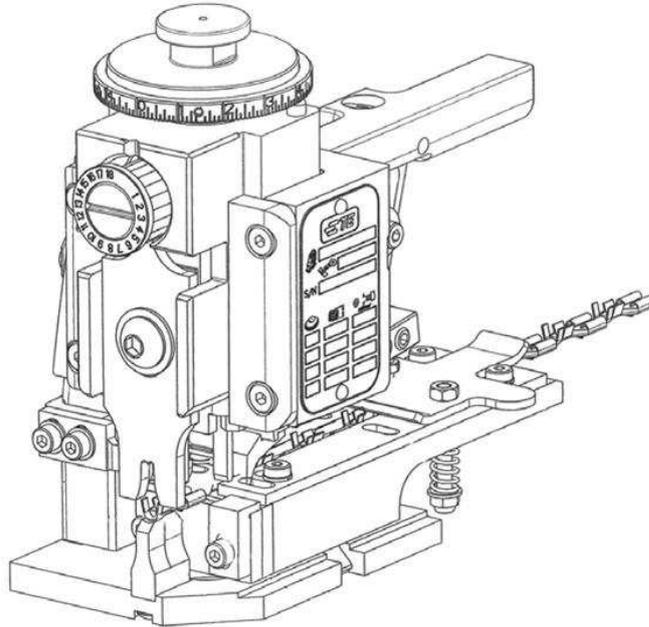
### 3.6. Repair

These receptacles are not repairable once termination has been made. Any defective receptacles should be removed and replaced with a new one.

## 4. TOOLING

Applicators are recommended for the application. Applicators contain the tooling for feeding and crimping strip-form terminals. Automatic machines provide the power to operate the applicator.

Applicator part number: X-2150663-X



Ocean Applicator