

REC. CONTACT FOR 5mm PITCH CONNECTOR

1. SCOPE

1.1 Content

This specification covers the requirement for application of "RECEPTACLE CONTACT PNs **282308,282309** and **282310**". These requirements are applicable to automatic machine crimping tools. For specific wire and insulation ranges relative to the products covered in this specification, See Figure 4.

1.2 Reference Specification

For applicable performance requirements, see TE Specification or equivalent customer specification.

2. NOMENCLATURE

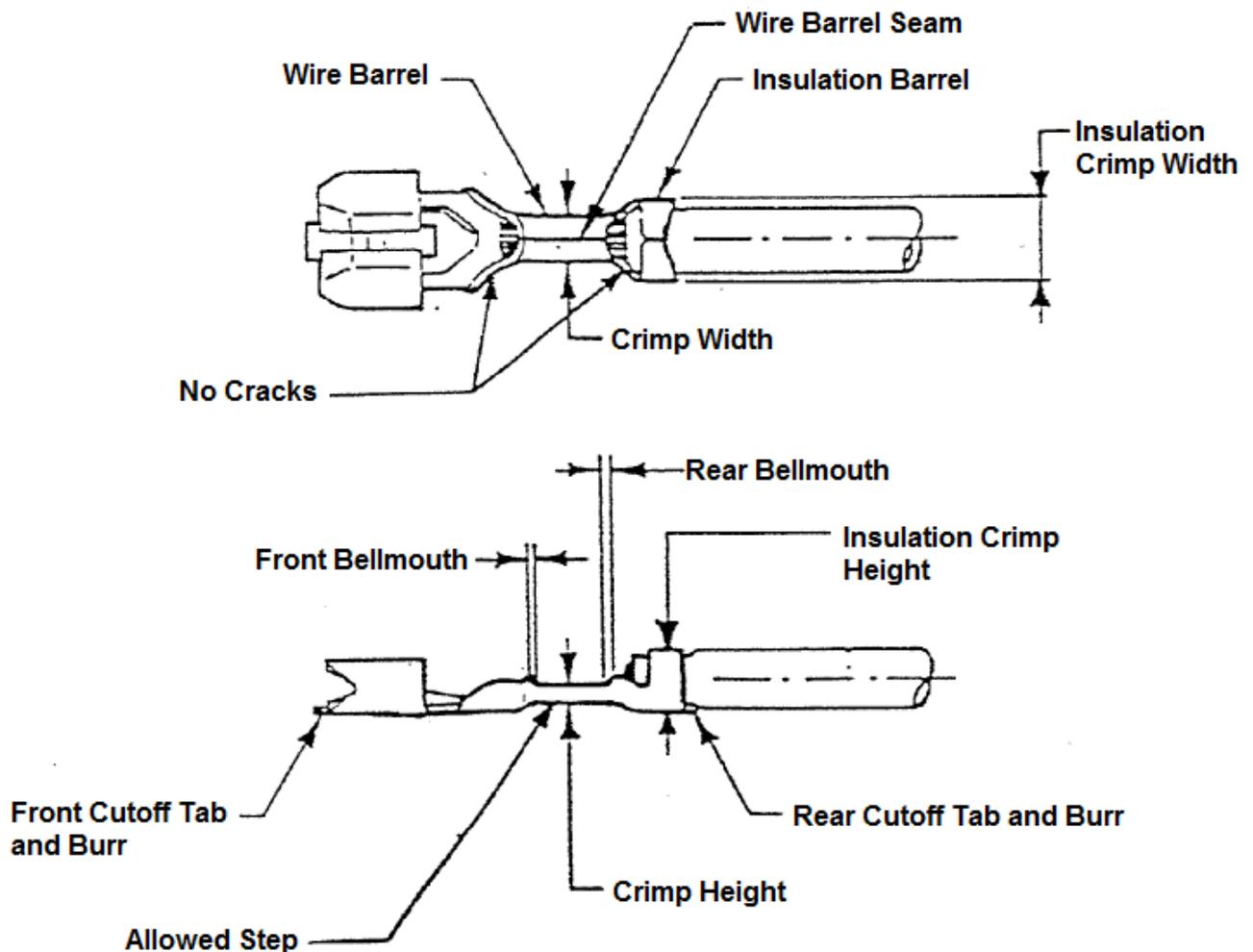


Figure 1



3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1 Wire Preparation

- A. Strip wire length
Insulation shall be stripped as indicated in Figure 4.
- B. Workmanship
Reasonable care shall be taken not nick, scrape or cut any strands during the stripping operation.

3.2 Carrier Cutoff Tab and Burr

- A. Cutoff Tab
Cutoff tab shall not exceed 0.3mm.
- B. Burr
Burr on cutoff shall not exceed 0.1mm.

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 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.
- C. Bellmouth
 - 1) Rear bellmouth length shall be 0.3 - 0.6mm.
 - 2) Front bellmouth length shall be 0.1 – 0.4mm.
- D. Conductor Location
 - 1) End of the wire shall be flush with the front end of the wire barrel or extend 0.7mm maximum 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 Wire Barrel Crimp

- A. Crimp Dimensions and Type
Crimp width and type shall be as shown in Figure 4.
- B. Wire Barrel Seam
Reasonable care shall be taken not to cut or break the insulation during the crimping operation.

3.5 Cracks

There shall be no cracks between wire barrel/insulation barrel and transition wire barrel/contact portion after crimping. (As indicated in Fig. 1)

3.6 Alignment

A. Straightness

- 1) The contact, including the cutoff tab and burr shall not be bent above or below the datum line more than the amount in Figure 2.

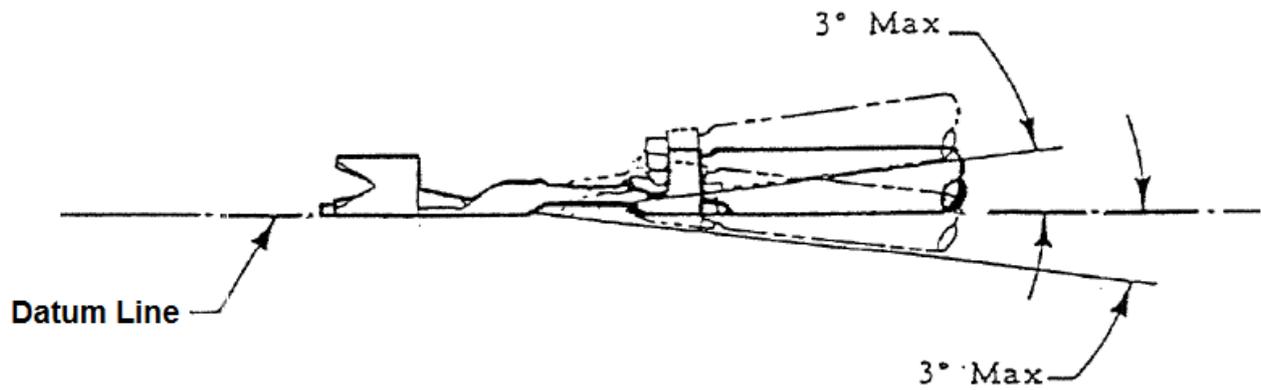


Figure 2

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

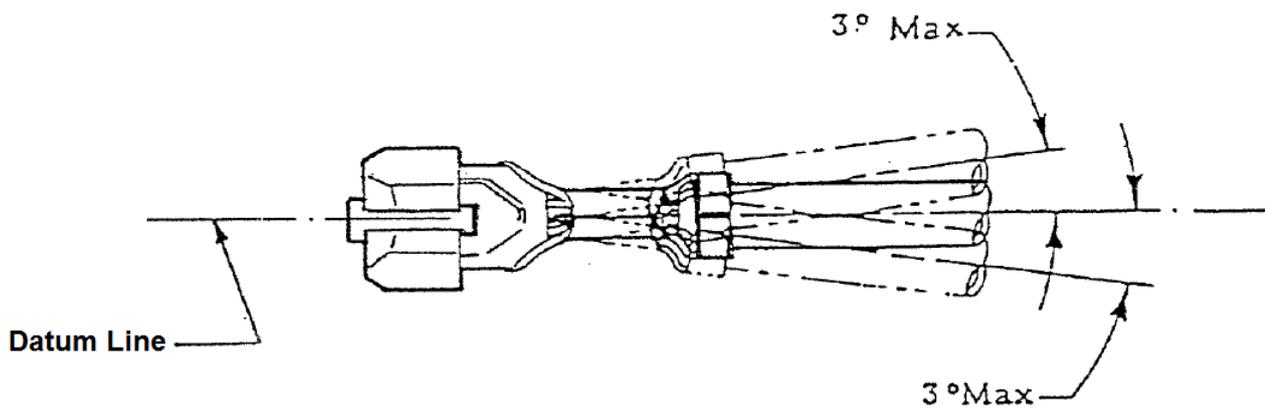


Figure 3

B. Assembly

The following list of Do's and Don'ts are to be followed when assembling contact into housing cavities.

1) Do's

- a) Do insert contacts fully.
- b) Do check for proper insertion by pulling back lightly.
- c) Do ensure proper handling of contacts to eliminate deformation.

2) Don'ts

- a) Don't insert contacts into housing at an angle.
- b) Don't rock connecting while mating.
- c) Don't tie harness closer than 1.50 inches to back of housing.
- d) Don't dress wires sharply to one side of housing.

C. Twist of Roll

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

TE PART NUMBER OF TERMINAL	WIRES		INSULATION DIAMETER mm (ONLY FOR REF.)	STRIP WIRE LENGTH ± 0.3mm	WIRE BARREL CRIMP			INSULATION BARREL CRIMP		
	Nr.	SIZE mm ²			WIDTH ±0.1mm	HEIGHT ±0.05mm	CRIMPER TYPE	WIDTH ±0.1mm	HEIGHT	CRIMPER TYPE
282308	1	0.5	2.0 – 2.2	5	2.03	F	3.3	3.4mm Max.	F	1.32
	1	0.75	2.4 – 2.6							1.40
	1	1	2.4 – 2.6							1.49
	1	1.5	3.15 – 3.35							1.66
282310 (REDUCED INSULATION CABLE)	1	0.5	1.7 Max.	5	2.03	F	3	3.4mm Max.	F	1.32
	1	0.75	1.9 Max.							1.40
	1	1	2.1 Max.							1.49
	1	1.5	2.4 Max.							1.66
282309	1+1	1	2.4 – 2.6	5	3	F	5	3.4mm Max.	F	1.6
	*		2.4 – 2.6							

* PARALELL WIRES

Figure 4