

1. Scope :

This specification covers the requirements for crimping of 2.5mm pitch HPI (High Performance Interconnect Wire-To-Board System) Connector (Crimp Type) for applicator and manually operated hand tool.

2. Applicable Connectors

| Contact Form   | Product Part Number | Crimping Tool | Wire Size (SQmm)                              | Ins. Diameter (mm) |
|----------------|---------------------|---------------|---|--------------------|
| Strip Terminal | 440134-1            | Applicator    | 0.08 ~ 0.30mm <sup>2</sup><br>(AWG #28 ~ #22) | φ 1.0 ~ φ 1.9mm    |

3. Nomenclature

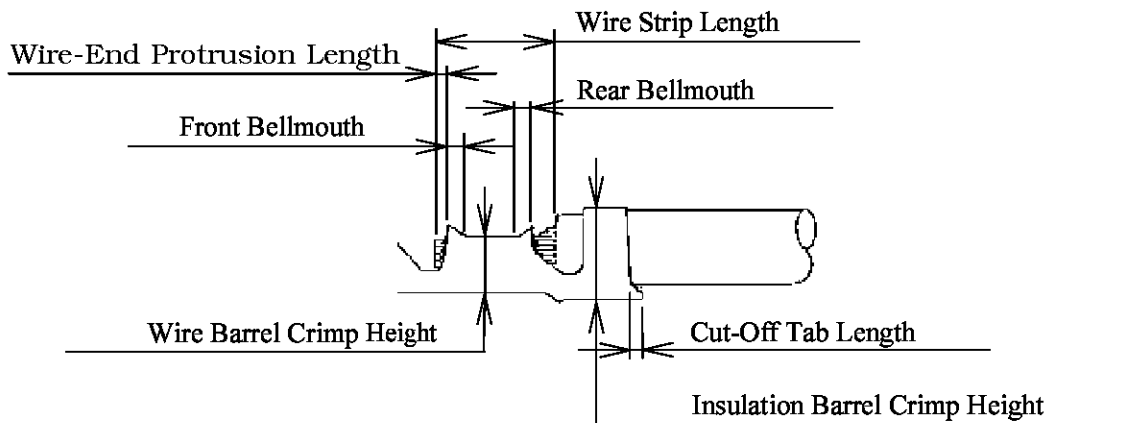
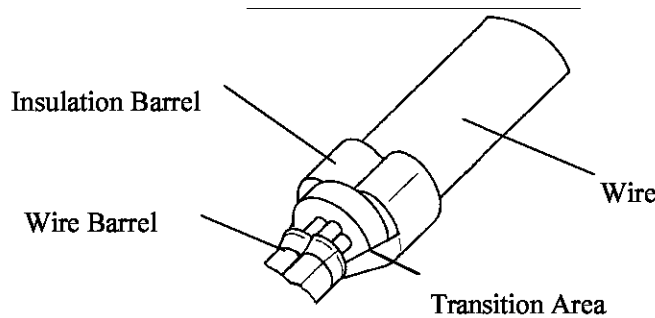
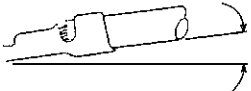
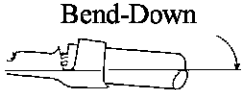
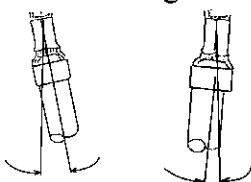
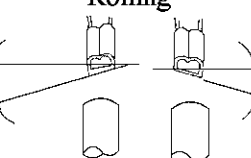


Fig.1

4 · Crimping Requirement

| No. | Check Items                        |  | Crimping Requirements           |           | Remarks |
|-----|------------------------------------|--|---------------------------------|-----------|---------|
|     |                                    |  | Applicator                      | Hand Tool |         |
| 1   | Wire Strip Length                  |  | 1.9 ~ 2.5 mm                    |           | Fig.1 - |
| 2   | Wire-End Protrusion Length         |  | 0.3 ~ 0.6 mm                    |           | Fig.1 - |
| 3   | Cut-Off Tab Length                 |  | 0 ~ 0.5 mm                      |           | Fig.1 - |
| 4   | Bellmouth                          | Front  | Front bellmouth can be visible. |           | Fig.1 - |
|     |                                    | Rear   | 0.1 ~ 0.3 mm                    |           | Fig.1 - |
| 5   | Wire Barrel Crimp                  |  | Refer Table.1                   |           | Fig.1 - |
| 6   | Insulation Barrel Crimp Height     |  | Refer Table.1                   |           | Fig.1 - |
| 7   | Allowable Deviation after Crimping | Bend-Up<br>    | 6° Max.                         | 6° Max.   |         |
| 8   |                                    | Bend-Down<br> | 6° Max.                         | 6° Max.   |         |
| 9   |                                    | Twisting<br>  | 5° Max.                         | 5° Max.   |         |
| 10  |                                    | Rolling<br>   | 7° Max.                         | 7° Max.   |         |

Tool mark is allowable at crimped areas and transition areas only.

## 5 · Crimping Data

Table.1

| Contact Part Number | Applicator Part Number | Wire Size      |                              | Insulation Strip Length | Wire Barrel  |              | Insulation Barrel | Finished Insulation Diameter |
|---------------------|------------------------|----------------|------------------------------|-------------------------|--------------|--------------|-------------------|------------------------------|
|                     |                        | Number of Wire | Size                         |                         | Crimp Width  | Crimp Height |                   |                              |
| 440134-1            | 1463115-2              | 1              | 0.30mm <sup>2</sup><br>(#22) | 1.9~ 2.5mm              | 1.4mm<br>"F" | 0.75±0.05mm  | 1.8mm<br>Max.     | φ1.0mm<br>~<br>φ1.9mm        |
|                     |                        | 1              | 0.22mm <sup>2</sup><br>(#24) |                         |              | 0.70±0.05mm  |                   |                              |
|                     |                        | 1              | 0.14mm <sup>2</sup><br>(#26) |                         |              | 0.65±0.05mm  |                   |                              |
|                     |                        | 1              | 0.08mm <sup>2</sup><br>(#28) |                         |              | 0.60~0.65mm  |                   |                              |

Table.2

| Wire Size       |     | Crimp Tensile Strength |
|-----------------|-----|------------------------|
| mm <sup>2</sup> | AWG | N (kgf) Min.           |
| 0.30            | 22  | 49.0 (5.0)             |
| 0.22            | 24  | 29.4 (3.0)             |
| 0.14            | 26  | 19.6 (2.0)             |
| 0.08            | 28  | 9.8 (1.0)              |

### Note

1. Tool mark is allowable at crimped areas and transition areas only.
2. The dimensions of crimp width of wire barrel and insulation barrel are the dimensions of crimping tool.

## 6 · Example of Applicable wire

Table.3

| Wire Size | Insulation Diameter (mm) | Applicable Wire |
|-----------|--------------------------|-----------------|
| AWG#28~22 | 1.0~1.9                  | UL-1007         |

All wires, including the above mentioned, need to be approved prior to usage.

## 7 · Validation

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Jebb Wu

|     |                 |                |           |             |            |
|-----|-----------------|----------------|-----------|-------------|------------|
|     |                 |                |           |             |            |
| A   | Revised         | (FW00-0092-00) | 27-NOV-00 |             |            |
| O   | Released        | (FW00-0059-00) | 27-OCT-00 |             |            |
| LTR | Revision Record |                | Date      | Prepared.by | Reviwed by |
|     |                 |                |           | Approved by |            |