

CONTACT RECEPTACLE CRIMP HE13 HE14

1 - SCOPE

This specification covers the requirements for application of HE13 – HE14 receptacle contacts. These requirements are applicable to hand or automatic machine crimping tools. For specific wire and insulation ranges relative to the products covered in this specification see figure 4.

2 - GLOSSARY

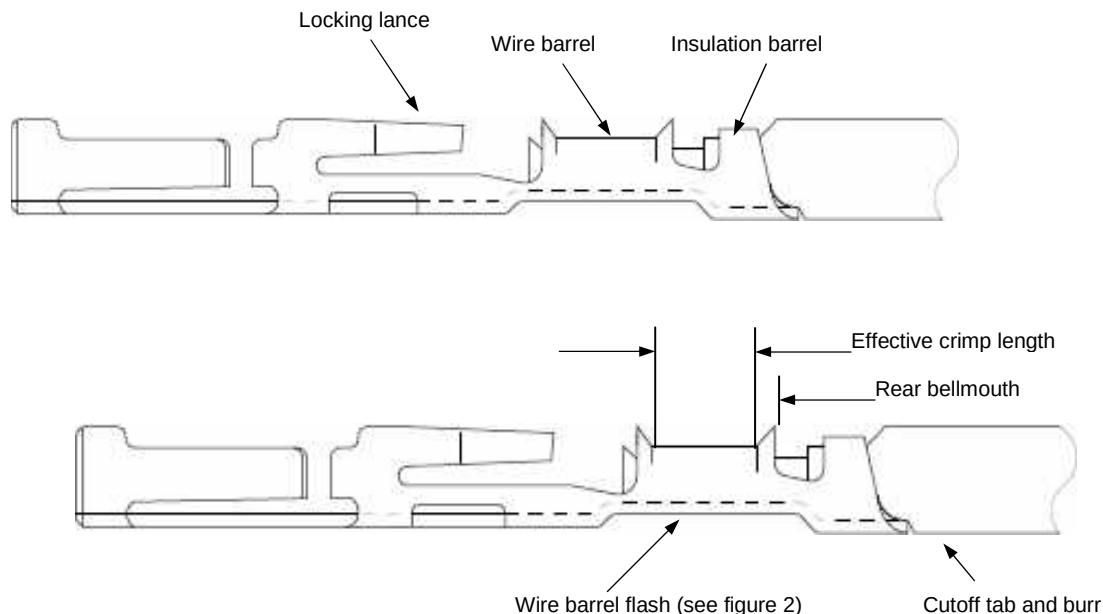


Figure 1

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 shall not exceed 0.25 mm

B. Burr

Burr on cutoff tab shall not exceed 0.08 mm.

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3.3. Wire barrel crimp

A. Crimp Dimensions and type

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

B. Effective crimp length

Effective crimp length shall be 1.70 mm minimum, and is defined as that portion of the barrel, excluding bellmouth, fully formed by the crimping tool.

C. Wire barrel Flash

Wire barrel flash shall not exceed 0.2 mm as shown in figure 2.

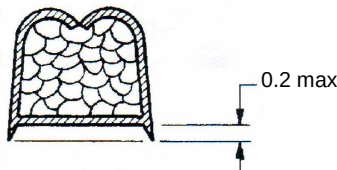


Figure 2

D. 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.

E. Bellmouth

Rear bellmouth length shall be 0.15 mm min.

F. Conductor location

- (1) End of the wire shall be flush with the front end of the wire barrel or extend 0.8 mm max. 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 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 lance

Locking lance shall not be deformed.

3.6. Alignment

A. Straightness

The contact, including the cutoff tab and burr shall not be bent below the datum line or more than 0.5 mm above the datum line as shown in figure 3.

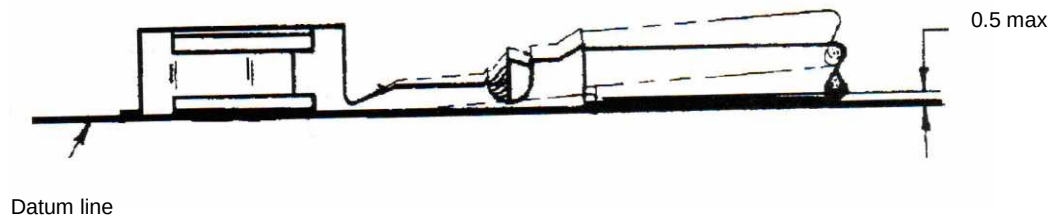


Figure 3

B. Twist or roll

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

TERMINAL P/N	WIRE SIZE	INSUL DIAM (mm)	STRIP LENGTH (mm)	WIRE BARREL CRIMP		INSULATION BARREL CRIMP	
				WIDTH (mm)	HEIGHT (mm+/- 0,05)	WIDTH (mm)	TYPE CRIMPER
188744-1	0,22mm ² -AWG 24	0,8 -1,5	3,2-4,0	1,07 nom	0,71	1,57 nom	F
188744-1	0,12 mm ² - AWG 26	0,8 -1,5	3,2-4,0	1,07 nom	0,66	1,57 nom	F
188744-1	0,08 mm ² - AWG 28	0,8 -1,5	3,2-4,0	1,07 nom	0,66	1,57 nom	F
182734-2	0,22 mm ² -AWG 24	0,8 -1,5	3,2-4,0	1,07 nom	0,71	1,57 nom	F
182734-2	0,12 mm ² - AWG 26	0,8 -1,5	3,2-4,0	1,07 nom	0,66	1,57 nom	F
182734-2	0,08 mm ² -AWG 28	0,8 -1,5	3,2-4,0	1,07 nom	0,66	1,57 nom	F
188746-1	0,22 mm ² -AWG 24	0,8 -1,5	3,2-4,0	1,07 nom	0,71	1,57 nom	F
188746-1	0,12 mm ² - AWG 26	0,8 -1,5	3,2-4,0	1,07 nom	0,66	1,57 nom	F
188746-1	0,08 mm ⁻² AWG 28	0,8 -1,5	3,2-4,0	1,07 nom	0,66	1,57 nom	F
182734-3	0,22 mm ² -AWG 24	0,8 -1,5	3,2-4,0	1,07 nom	0,71	1,57 nom	F
182734-3	0,12 mm ² - AWG 26	0,8 -1,5	3,2-4,0	1,07 nom	0,66	1,57 nom	F
182734-3	0,08 mm ² - AWG 28	0,8 -1,5	3,2-4,0	1,07 nom	0,66	1,57 nom	F

Figure 4