801 East Mission Road San Marcos, CA 92069 760-744-0125 www.sullinscorp.com

Product Specification Report								
PA	RT NO.		TITLE		PRO	DUCT SPEC.	DWG. NO.	
WCT	<sup>-</sup> 001-MCT	CRIMP TOOL		(	OPS-045	N/A		
<b>REQUESTER</b>	TYPE		TESTED BY REVIEW			DATE	PAGES	
SULLINS	PRODUC SPECIFICAT		JG	КО	S	5-15-2015	10	

### **REVISION HISTORY**

DATE	REV	DESCRIPTION	INITIATED BY
5-15-2015	Α	INITIAL RELEASE	JG
6/24/2022	В0	Rework SWT204 In Progress	TT





# **CERTIFICATION**

This is to certify that the evaluation described herein was designed and executed by personnel of Sullins Connector Solutions of San Marcos California.

All equipment and measuring instruments used during testing were calibrated and traceable to NIST according to ISO/IEC 17025:2005 and ANSI-Z540-1, as applicable.

All data, raw and summarized, analysis and conclusions present herein are the property of Sullins Connector Solutions. No copy of this report, except in full, shall be forwarded to any agency, customer, etc., without the written approval of Sullins Connector Solutions.

Date: 06/20/14

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# CRIMP TOOL PART NUMBER: WCT001-MCT

This tool will crimp 3 different connectors as follows:

SWT204 (DWG 11627); Currently is not working condition, in the progress of rework.

SWT201 (DWG 11621);

SWT25X (DWG 11631).

Terminal No.	Wire	Size	Conduct	<del>or crimp</del>	Insulate	Pull force	
			Height	Width	Height	Width	Min.
	AWG	O.D.	mm	mm	mm	mm	Kgf
	<del>22</del>	<del>1.76</del>	0.70-0.80	1.32 max.	<del>1.50-1.60</del>	1.80 max.	<del>3.6</del>
SWT204	<del>24</del>	<del>1.60</del>	0.70-0.80	1.30 max.	<del>1.48-1.58</del>	1.75 max.	2.7
	<del>26</del>	1.48	0.65-0.75	1.30 max.	1.40-1.50	1.75 max.	1.8

Terminal No.	Wire	Size	Conduct	or crimp	Insulato	Pull force	
			Height	Width	Height	Width	Min.
	AWG	O.D.	mm	mm	mm	mm	Kgf
	24	1.60	0.69-0.79	1.29 max.	1.43-1.53	1.64 max.	3.0
SWT201	26	1.48	0.66-0.76	1.29 max.	1.40-1.50	1.64 max.	2.0
	28	1.20	0.63-0.73	1.28 max.	1.40-1.50	1.59 max.	1.0

Terminal No.	Wire Size		Conduct	or crimp	Insulato	Pull force	
			Height	Width	Height	Width	Min.
	AWG	O.D.	mm	mm	mm	mm	Kgf
	20	1.94	0.97-1.07	1.51 max.	1.73-1.83	1.90 max.	5.9
SWT25X	22	1.76	0.840.94	1.49 max.	1.56-1.66	1.86 max.	3.6
	24	1.60	0.79-0.89	1.48 max.	1.50-1.60	1.82 max.	2.7
	26	1.48	0.77-0.87	1.47 max.	1.45-1.55	1.80 max.	1.8

### Performance:

Crimping Tool with 4 nests.

2 nests are used for connector SWT25X and one each for the remaining connectors.

### Test:

A crimp test was performed and cross section pictures were made.

The crimp cycle is finished when the tool ratchet releases.

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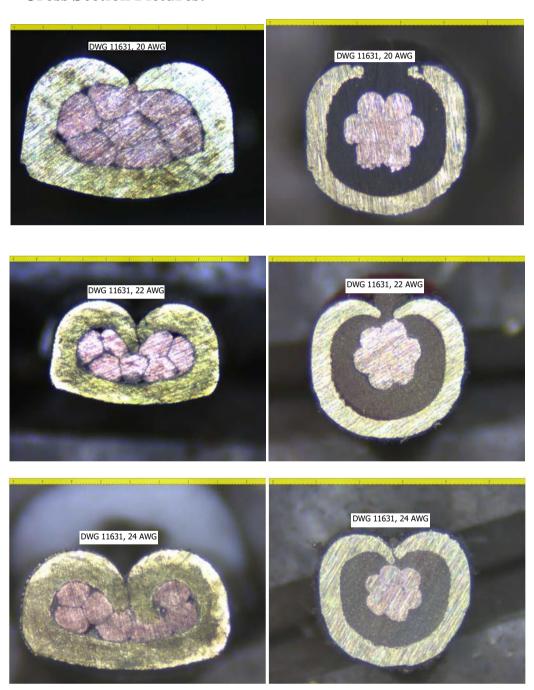
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Tested by	O.S				Da	te	2011-05-04						
Tool reference	WCT00	1-MCT			Co	nnector ty	ре						
Preload at start of test					Pre	Preload at end of test							
Nest / (marking)													
Test wire [mm <sup>2</sup> / AWG}	20A	WG	22AWG 24A\		WG	26AWG		22AWG		24AWG			
Wire type	UL1007					UL1007 UL1007			UL1007		UL1007		
Contact / Terminal	SWT25X					WT25X SWT25X			SWT204		SWT204		
Crimp height [mm]	[mm]		[mm]		[m	[mm]		[mm]		[mm]		[mm]	
1 [mm]	1,	00	0,92		0,	87	0,84		0,78		0,74		
Crimp width [mm]		ım]	[m	-	[m			ım]		nm]		nm]	
1 [mm]		50	1,4			45	1,45			28		26	
Insulation height [mm]		im]	[m	_		m]		im]		nm]		nm]	
1 [mm]		73	1,0		1,			55		54		51	
Insulation width [mm] 1 [mm]	_	<mark>m]</mark> 81	[m	-		<mark>m]</mark> 73		<mark>m]</mark> 72		nm] 72		<mark>nm]</mark> .71	
Tensile test / fail. mode 1)	[N]	P/W/C	[N]	P/W/C	[N]	P/W/C	[N]	P/W/C	[N]	72 P/W/C	[N]	P/W/C	
1 [N]	79	W	58,5	W	49,5	W	30	W	84,5	W	58,5	W	
2 [N]	82,5	W	65,5	W	49,5	W	27	W	84	W	58,5	W	
3 [N]	81	W	76,5	W	48,5	W	37	W	76,5	W	57	W	
Min required value			ĺ						10,0		1		
according to customer	57	,86	35	5,3	26	26,47 17,6		7,6	35,3		26,47		
Comments – nest							1						
Comments – tool													
Nest / (marking)													
Test wire [mm <sup>2</sup> / AWG}	26A	WG	24AWG		26AWG		28A	WG					
Wire type	UL1	007	UL1007		UL1	UL1007 UL1007		007					
Contact / Terminal	SW	T204	SW	Γ201	SWT201		SWT201						
Bellmouth [mm]													
Crimp height [mm]		ım]		m]		m]	[mm]		[m	nm]	[m	nm]	
1 [mm]	0,	70	0,	77	0,	75	0,	72					
Crimp width [mm]	[m	ım]	[m	m]		m]	[m	[mm]		[mm]		nm]	
1 [mm]	1,	25	1,:	26	1,25		1,25						
Insulation height [mm]	[m	ım]	[mm]		[mm]		[mm]		[mm]		[mm]		
1 [mm]	1,	50	1,50		1,51		1,48						
Insulation width [mm]	[m	ım]	[m	m]	[m	m]	[mm]		[mm]		[mm]		
1 [mm]	1,70		1,	56	1,	57	1,	1,56					
Tensile test / fail. mode 1)	[N]	P/W/C	[N]	P/W/C	[N]	P/W/C	[N]	P/W/C	[N]	P/W/C	[N]	P/W/C	
1 [N]	35,5	W	53,5	W	38,5	W	21	W					
2 [N]	38	W	56,5	W	38,5	W	20	W					
3 [N]	38,5	W	56,5	W	37,5	W	23	W					
according to customer		7,6	26,	,47	17	7,6	9	,8		•		-	
Comments – nest													
Comments – tool													

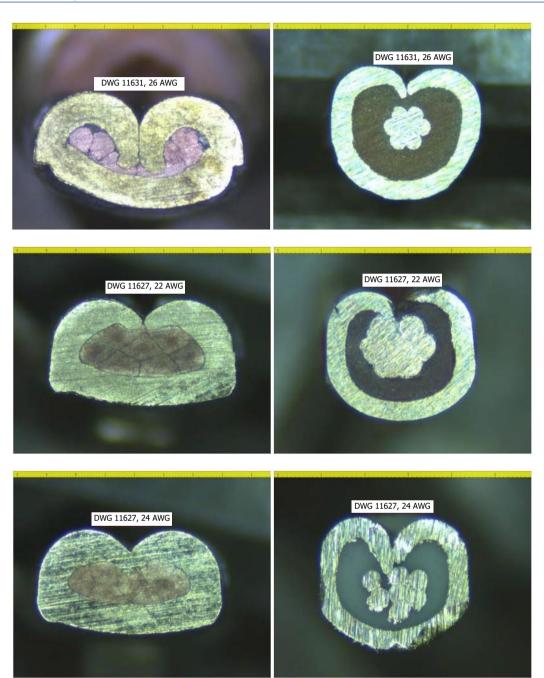
<sup>1)</sup> Records from the tensile tests are maximum pull-off value and failure mode. P = wire pull off from contact / terminal; W = wire break; C = connector / terminal break.

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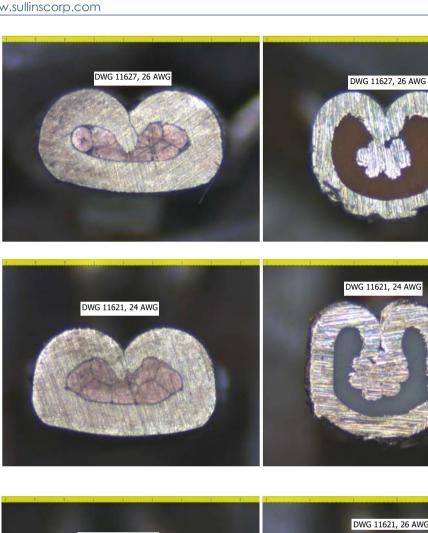
# **Cross Section Pictures:**



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# **Conclusion:**

Cross section pictures of the insulation shows that the wings go through the insulation and hit the conductor. This happen even if the specification regarding height and width are fulfilled.

Form QF-7.3.6-13 Rev A Date: 06/20/14 **SULLINS CONNECTOR SOLUTIONS** 801 East Mission Road San Marcos, CA 92069 760-744-0125 www.sullinscorp.com NOTES:

1. MATERIAL: SEE PART NUMBER CODING.
2. PLATING: SEE PART NUMBER CODING.
3. WIRE RANGE: AWG #20 - #26.
4. INSULATION O.D.: Ø 1.35mm ~ Ø 1.90mm.
5. QUANTITY PER REEL = 10,000 PIECES.
6. USED IN SWH2SY SERIES HOUSING.
7. PLATING BEFORE STAMPING/FORMING. PART NUMBER CODING SWT25X-U,\_C-S01-UU-UU 0.20±0.03[.008±.001] . MATERIAL & PLATING

RT = BRASS, .000015" MIN NICKEL UNDERPLATE, .000040" MIN PURE TIN, BRIGHT OVERALL (NOTE 7).

PT = PHOSPHOR BRONZE, .000015" MIN NICKEL UNDERPLATE, .000040" MIN PURE TIN, BRIGHT OVERALL (NOTE 7). RP = BRASS, ... .000040" MIN NICKEL UNDERPLATE, GOLD FLASH OVERALL. 1.50[,059] 1.30[.051] GOLD AREA В 9.80[.386] 2.00[.079] 3.40[.134] 0.60±0.15[ 3,10±0,20 1.90±0.15[.075±.006] Rohs compliant .122±,008] .024±.006] UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MM/INCHES A REV. ECO. NO 2237 2.20[.087] CO 2235,2236,2237\2237, WAFER 25X W&N|1631, SV1725X-UR\_C-501-UU-UU PRMI: 8/26/201 1.80[.071] REVISIONS DESCRIPTION INITIAL RELEASE SECTION A-A SECTION B-B CRIMP TERMINAL - SWH25X SW125X-U\_\_C-S01-UU-UU 1.80[.071] 11631 05/24/2011 2.10 DATE 도 쭈

Form QF-7.3.6-13 Rev A Date: 06/20/14 **SULLINS CONNECTOR SOLUTIONS** 801 East Mission Road San Marcos, CA 92069 760-744-0125 www.sullinscorp.com NOTES:

1. MATERIAL: PHOSPHOR BRONZE

2. PLATING: SEE PART NUMBER CODING,

3. WIRE RANGE: AWG #22 - #26.

4. INSULATION O.D.: Ø 1.35mm ~ Ø 1.70mm,

5. QUANTITY PER REEL = 10,000 PIECES,

6. USED IN SWH204 SERIES HOUSING,

7. PLATING BEFORE STAMPING/FORMING. SWT204-UP\_ N-S01-UU-UU PART NUMBER CODING 0.20±0.03[.008±.001] P = .000040" MIN NICKEL UNDERPLATE, GOLD FLASH OVERALL. T = .000015" MIN NICKEL UNDERPLATE, .000040" MIN PURE TIN, BRIGHT OVERALL (NOTE 7) PLATING 0.85[.033] 0.70[.028] 1.30[.051] GOLD PLATING AREA ---6.60[.260] В 3.20[.126] 3.15[.124] \_\_\_1,50±0,15[,059±,006] -R0,60[.024]REF  $-0.40\pm0.10[.016\pm.004]$ 1,50±0,20[,059±,008] 1.10±0.10[.043±.004] 0,20±0,10[,008±,004] Rohs Compliant REV. ECO, NO 2236 1,80[,071] DESCRIPTION
INITIAL RELEASE 1,45[.057] C 54453 REVISIONS SECTION B-B SECTION A-A CRIMP TERMINAL - SWH 204 SULLING SULLING SWT204-UP\_N-S01-UU-UU 1.30 051 2.50 .098 SHEET 1 OF 1 DATE 05/24/2011 11627 略 Ξ Page 9 of 10

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