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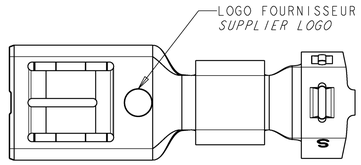
# SERTISSAGE / *CRIMPING*

| LOC | DIST |
|---|---|
| F | 00 |

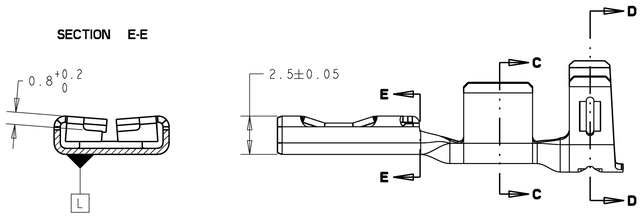
REVISIONS

| P | LTR REV | DESCRIPTION MODIFICATIONS | DATE | DWN DESS. | APVD APP. |
|---|---|---|---|---|---|
| | E | First issue | 14SEPT2005 | PFs | JDr |
| | F | PACKAGING MODIFICATION | 30OCT2007 | PFs | JDr |

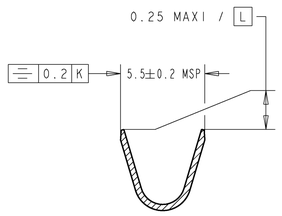



VUE SUIVANT F
F VIEW

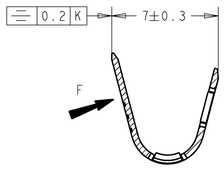
SECTION E-E

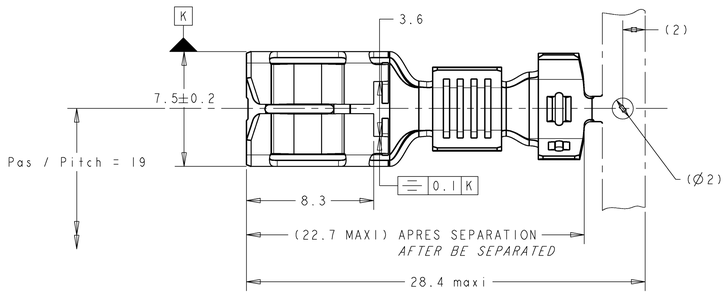



SECTION C-C




SECTION D-D



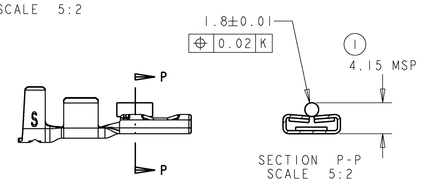




NOTA:
- ( ) = Pour information uniquement

*NOTE:*
*- ( ) = Only for information*

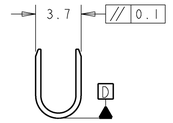
## CONTROLE COTE SUR PIGE / *DIM. CONTROL ON MEASURING ROD*

SCALE 5:2

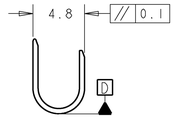



## NOTICE DE CONTROLE DU CLIP SERTI / *CONTROLE NOTICE OF CRIMPING TERMINAL*

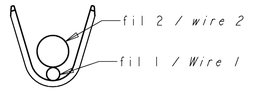
LARGEUR NATURELLE CUIVRE
*NATURAL CONDUCTOR WIDTH*

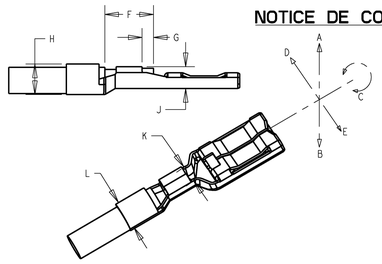



LARGEUR NATURELLE ISOLANT
*NATURAL INSULATION WIDTH*




MARIAGE DE FILS
*SEVERAL WIRES*




| CARACTERISTIQUES A VERIFIER / *CHARACTERISTICS TO CHECK* | | VALEUR *VALUE* | REPERE *ITEM* |
|---|---|---|---|
| DEFORMATION APRES SERTISSAGE *DEFORMATION AFTER CRIMPING* | FLEXION VERS LE HAUT / *UP BENDING* | 2° | A |
| | FLEXION VERS LE BAS / *DOWN BENDING* | 2° | B |
| | TORSION / *TWIST* | 5° | C |
| DEFORMATION SUIVANT L'AXE DE LA PIECE / *AXIAL DEFORMATION* | | 2° | D - E |
| LONGUEUR DE DENUDAGE / *STRIPPING LENGTH* | | $6.5^{+0.5}_{0}$ | F |
| DEPASSEMENT DU FIL / *WIRE EXCESS* | | $0.3^{+0.5}_{0}$ | G |

TENUE EN TRACTION DU SERTISSAGE CUIVRE:

- LA TENUE EN TRACTION DU SERTISSAGE CUIVRE EST MESUREE APRES 10 SECONDES D'APPLICATION DE L'EFFORT MENTIONNE AU TABLEAU "PARAMETRES DE SERTISSAGE" EFFORT APPLIQUE SUIVANT L'AXE DU CLIP; SERTISSAGE SUR ISOLANT NEUTRALISE.
- A L'ISSUE DE L'ESSAI ON NE DOIT AVOIR CONSTATE AUCUN GLISSEMENT DE L'AME DU FIL. LE NON RESPECT DE CETTE SANCTION ENTRAINE LE REFUS DU LOT CONSIDERE.
- L'OPERATION DE SERTISSAGE NE DOIT EN AUCUN CAS MODIFIER LA VALEUR DE LA COTE : (1)

*PULLING FORCE OF CONDUCTOR CRIMPING:*

*- THE PULLING FORCE OF CONDUCTOR CRIMPING IS MEASURED AFTER 10 SECOND OF THE "CRIMPING PARAMETERS" TABLE FORCE. FORCE IN THE TERMINAL AXIS DIRECTION, WITHOUT INSULATION CRIMPING.*
*- AFTER THE TEST, CONTROL THE UNSLIDING OF CONDUCTOR FROM WIRE. NO RESPECT OF THIS ISSUE WILL INVOLVE THE REJECTION OT THE SET*
*- THE CRIMPING OPERATION MUST NOT AFFECT THE DIMENSION : (1)*

TENUE AU PLIAGE DU SERTISSAGE ISOLANT :

L'essai est realisé dans les conditions suivantes :
Le contact etant maintenu immobilisé, le conducteur subit 10 fois le cycle suivant :
- position initiale : conducteur/contact alignes
- pliage du conducteur a 45°
- pliage du conducteur a 45° opposé
- retour a la position initiale.

Le conducteur est tenu, sans traction excessive, a une distance correspondant a 20 fois son diametre avec un minimum de 60 mm.

A L'ISSUE DU TEST ON NE DOIT OBSERVER AUCUN RETRAIT DE L'ISOLANT SOUS LES AILLETTES DE SERTISSAGE OU OUVERTURE DU DIT SERTISSAGE.

LE NON RESPECT DE CES SANCTIONS ENTRAINE LE REFUS DU LOT CONSIDERE.

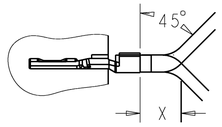
*INSULATOR BARREL BENDING RESISTANCE*

*The test is performed as following :*
*Receptacle maintain in position, the wire suffer 10 cycles as :*
*- initial position : conductor/wire horizontal*
*- wire bending to 45°*
*- wire bending to 45° oposite*
*- return to initial position.*

*The wire is maintain without extreme traction effort, at a distance corresponding to 20 diameter with a minimum of 60 mm*

*TEST ISSUE : NO SLIPPING OF INSULATOR OR OPENING OF THE BARREL*

*NO RESPECT OF THIS ISSUE WILL INVOLVE THE REJECTION OT THE SET*




| SECTION | X mini |
|---|---|
| 2.5mm2 | 60 mm |
| 6mm2 | 120 mm |

NOTA / *NOTE :*

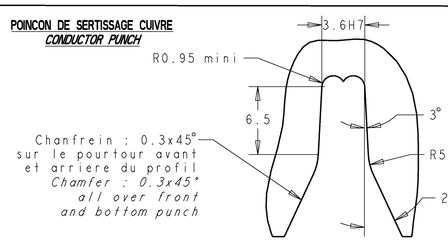
- Ce produit devra être conforme au sous-paragraphe "prohibition et restriction de substance" de la norme TSZ0001G.
- *This part shall conform to sub-paragraph "substance prohibition and restriction" in TSZ0001G.*

| Tyco Electronics PN | 1544133-1 |
|---|---|
| CUSTOMER PN | |

# MISE EN BANDE ET CONDITIONNEMENT / *PACKAGING*

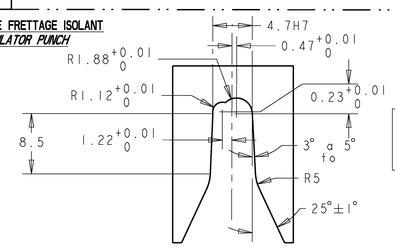
VOIR SPEC 107-15606 /
*SEE SPECIFICATION 107-15606*

POINCON DE SERTISSAGE CUIVRE
*CONDUCTOR PUNCH*



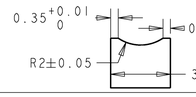

Largeur poincon
*Punch width*
4.5±0.02

POINCON DE FRETTAGE ISOLANT
*INSULATOR PUNCH*



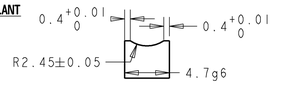

Largeur poincon
*Punch width*
5±0.02

ENCLUME DE SERTISSAGE CUIVRE
*CONDUCTOR ANVIL*




Largeur enclume
*Anvil width*
5.1±0.02

ENCLUME DE FRETTAGE ISOLANT
*INSULATOR ANVIL*




Largeur enclume
*Anvil width*
5.5±0.02

## PARAMETRES DE SERTISSAGE / *CRIMPING PARAMETRES*

| SERTISSAGE DU CUIVRE *CONDUCTOR CRIMPING* | LONGUEUR D'AILE / *LAYOUT* : 12.2 EPAISSEUR METAL / *METAL THICKNESS* : 0.4 | | | | | | FRETTAGE DE L'ISOLANT (par recouvrement) *INSULATOR CRIMPING (Overlapping)* | LONGUEUR D'AILE / *LAYOUT* : 15.8 EPAISSEUR METAL / *METAL THICKNESS* : 0.4 | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| SECTION | REELLE *REAL* | LARGEUR *WIDTH* | HAUTEUR *HEIGHT* | TRACTION (N) *TRACTION EFFORT (N)* | | | CONFIGURATION | ISOLANT *INSULATOR* | SURFACE | LARGEUR *WIDTH* | HAUTEUR *HEIGHT* |
| TYPE DE FIL *WIRE TYPE* | mm2 | K±0.1 | J±0.05 | FIL 1 *WIRE 1* | FIL 2 *WIRE 2* | FIL 1+2 *WIRE 1+2* | TYPE DE FIL *WIRE TYPE* | Ø EQUIVALENT $^{+0.1}_{-0.05}$ | A FRETTER *TO CRIMP* | L±0.1 | H±0.1 |
| 1R1 + 2R1 | 2.76 | 3.68 | 2.25 | >140 | >220 | >300 | 1R1 + 2R1 | 3.3 | 8.55 | 4.84 | 4.50 |
| 3R1 | 3.02 | 3.68 | 2.30 | >300 | - | - | 3R1 | 3.2 | 8.04 | 4.81 | 4.45 |
| 1.4R1 + 2R1 | 3.17 | 3.69 | 2.32 | >180 | >220 | >340 | 1.4R1 + 2R1 | 3.5 | 9.62 | 4.86 | 4.60 |
| 3R1S / 3R3S / 3R4S | 3.18 | 3.69 | 2.35 | >300 | - | - | 3R1S / 3R3S / 3R4S | 3.2 | 8.04 | 4.80 | 4.45 |
| 0.6R1 +3R1 | 3.61 | 3.70 | 2.40 | >100 | >280 | >360 | 0.6R1 +3R1 | / | / | 4.87 | 4.65 |
| 2R1 + 2R1 | 3.64 | 3.70 | 2.41 | >220 | >220 | >400 | 2R1 + 2R1 | 3.7 | 10.75 | 4.85 | 4.65 |
| 1R1 + 3R1 | 3.95 | 3.71 | 2.41 | >140 | >280 | >400 | 1R1 + 3R1 | 3.8 | 11.34 | 4.88 | 4.70 |
| 4R3S | 3.95 | 3.71 | 2.41 | >400 | - | - | 4R3S | 3.6 | 10.18 | 4.83 | 4.70 |
| 1.4R1 + 3R1 | 4.36 | 3.71 | 2.47 | >180 | >280 | >440 | 1.4R1 + 3R1 | 3.9 | 11.95 | 4.92 | 4.70 |
| 5R1S / 5R3S / 5R4S | 4.95 | 3.72 | 2.57 | >450 | - | - | 5R1S / 5R3S / 5R4S | 3.9 | 11.94 | 4.85 | 4.72 |
| 3N1 | 3.02 | 3.68 | 2.30 | >300 | - | - | 3N1 | 3.7 | 10.75 | 4.85 | 4.65 |
| 4N1 | / | / | / | / | / | / | 4N1 | / | / | / | / |
| 5N1 | 4.65 | 3.72 | 2.52 | >450 | - | - | 5N1 | 4.4 | 15.20 | 4.90 | 4.85 |
| 6□ | 5.45 | 3.72 | 2.63 | - | - | - | 6□ | 4.1 | 13.2 | 4.88 | 5.02 |
| 2.5 ID ZH | 2.62 | 3.70 | 2.20 | - | | | 2.5 ID ZH | 2.8 | 6.16 | 4.80 | 3.95 |
| 1 + 2.5 ID ZH | 3.55 | 3.70 | 2.38 | - | - | - | 1 + 2.5 ID ZH | 3.5 | 9.62 | 4.86 | 4.60 |
| 4 ID ZH | 3.96 | 3.71 | 2.41 | >400 | - | - | 4 ID ZH | 3.8 | 11.34 | 4.83 | 4.70 |
| 6 ID ZH | 5.94 | 3.74 | 2.70 | - | - | - | 6 ID ZH | 4.1 | 13.2 | 4.87 | 5.02 |

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DIMENSIONS: mm

TOLERANCES UNLESS OTHERWISE SPECIFIED
TOLERANCES NON SPECIFIEES
(SUIV. NB DE DECIMALES):
1 PLC/DEC ±1
2 PLC/DEC ±0.1
3 PLC/DEC ±0.05
ANGLES ±2°

MATERIAL MATIERE Cu µ allier
FINISH FINITION - QP0024-04 or 06
WEIGHT MASSE APPROX. 0.00093kg

| | | |
|---|---|---|
| DWN/DESSINE | P. FLORES | 14sep05 |
| CHK/VERIFIE | L. CORONELLI | 14sep05 |
| APVD/APPROUVE | J. DAHER | 16sep05 |

PRODUCT SPEC SPEC. PRODUIT -
APPLICATION SPEC SPEC. APPLICATION -

Tyco Electronics
Tyco Electronics France SAS
RN 90, 38530 Chaparellan

NAME TITRE: CLIP 6.35 NGI GAMME 2.5 A 6mm²
6.35 NGI TERMINAL RANGE 2.5 to 6mm²

SIZE FORMAT A1 | CAGE CODE 00779 | DRAWING NO C-1544133 | No PLAN - | RESTRICTED TO -

CUSTOMER DRAWING /PLAN CLIENT UNIQUEMENT POUR REFERANCE | SCALE ECHELLE 5:1 | SHEET FEUILLE 1 OF DE 1 | REV F