



CRIMP SPECIFICATION

FCI ジャパン

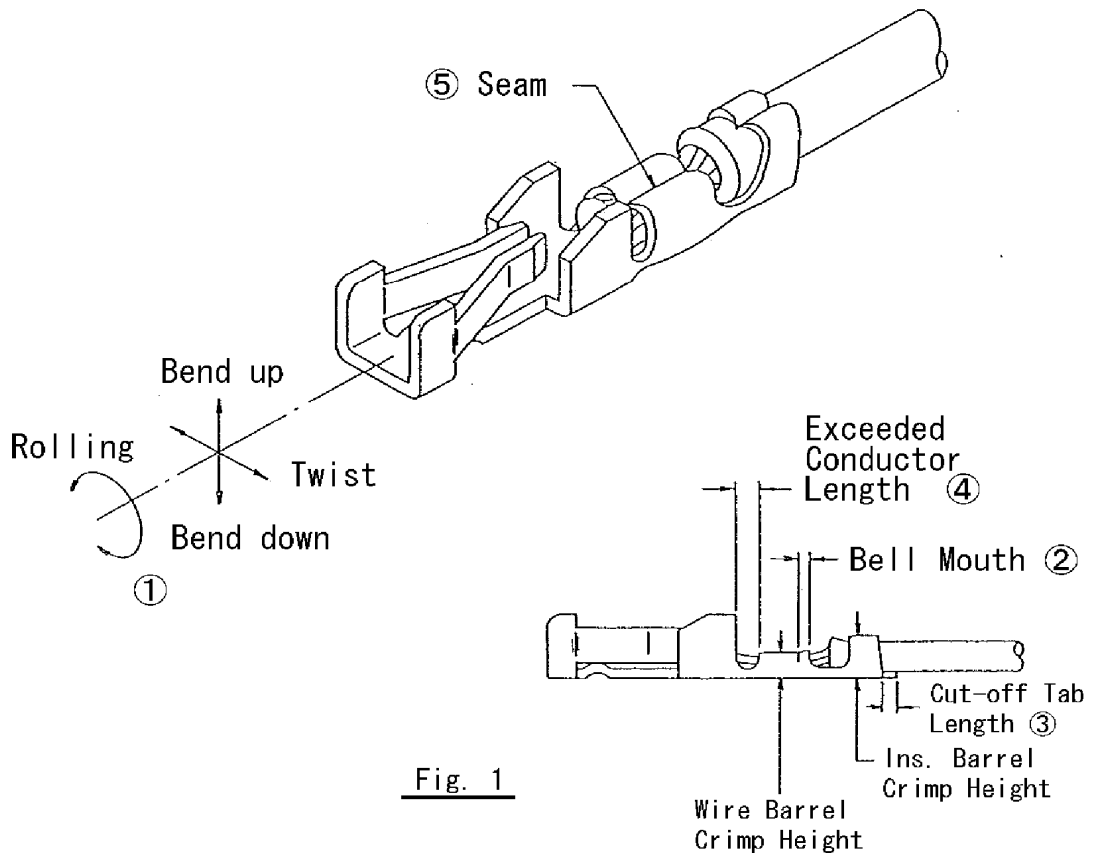
MINITEK

1. Scope

This specification is intended to cover the crimp conditions and requirements for MINITEK terminals.

Terminal P/N	Wire Range		Ins. Dia.
	AWG	mm ²	
77138-001	#26 - #30	0.13 - 0.05	φ 1.4 MAX.
77139-001	#32 - #36	0.03 - 0.01	φ 0.6 MAX.

2. Part name



				PREP'D	NO: 100-006	REV.
				BY: <i>Y.Awano</i>		E
E	New FCI logo-V06-1029	10/10/06	CL	ISS'D		
D	REVISED (ECRJ8429)	5/29/87	NY	BY: <i>Y.Awano</i>		
C	RELEASED	9/3/86	NY	APPR'D		
REV.	CONTENTS	DATE	BY	BY: <i>I.Ito</i>		

3. Crimp conditions

The wires specified by UL-1007 (AWG #26 - #30) and UL-2851 (AWG #32 - #36) or equivalent wires shall be crimped in accordance with the following conditions in Table 1 and Table 2.

3.1 Crimp conditions - Semi-automatic Crimping Machine

Table 1.

Terminal P/N	Applicator P/N	Wire Range AWG (mm ²)	Wire Barrel		Ins. Barrel		Crimp Strength (Kgf)
			Width (mm)	Height (mm)	Width (mm)	Height (mm)	
77138-001	901-026	#26 (0.13)	1.0	0.63 - 0.68	1.5 MAX.	1.4 MAX.	2.0 M N.
	901-034	#28 (0.08)		0.60 - 0.65			1.2 M N.
		#30 (0.05)		0.57 - 0.62			0.7 M N.
77139-001	901-027	#32 (0.03)	0.75	0.44 - 0.49	1.0	1.35 REF.	0.2 M N.
	901-035	#34 (0.02)		0.43 - 0.48			0.2 M N.
		#36 (0.01)		0.42 - 0.47			0.15 M N.

3.2 Crimp conditions - Manual Crimping tool

Table 2.

Terminal P/N	Hand Tool P/N	Wire Range AWG (mm ²)	Wire Barrel		Ins. Barrel		Crimp Strength (Kgf)
			Width (mm)	Height (mm)	Width (mm)	Height (mm)	
77138-001	HT-148	#26 - #28 (0.13 - 0.08)	1.0	0.60 - 0.65	1.5 MAX.	1.4 MAX.	1.2 M N.
	*HT-151	#28 - #30 (0.08 - 0.05)		0.57 - 0.62			0.7 M N.
77139-001	HT-149	#32 - #34 (0.03 - 0.02)	0.75	0.43 - 0.48	1.0	1.35 REF.	0.2 M N.
	*HT-152	#34 - #36 (0.02 - 0.01)		0.42 - 0.47			0.15 M N.

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4. Requirements (See Fig. 1)

No.	Item	Requirement
①	Bend Up	3° MAX.
	Bend Down	3° MAX.
	Twist	3° MAX.
	Rolling	8° MAX.
②	Bellmouth	0.1 - 0.4 mm
③	Cut-off tab length	0 - 0.3 mm
④	Exceeded Conductor Length	0 - 0.8 mm
⑤	Seam	No evidence of seam opening. No strands exist out of wire barrel
	Wire Strip Length (Reference)	1.2 - 2.2 mm

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