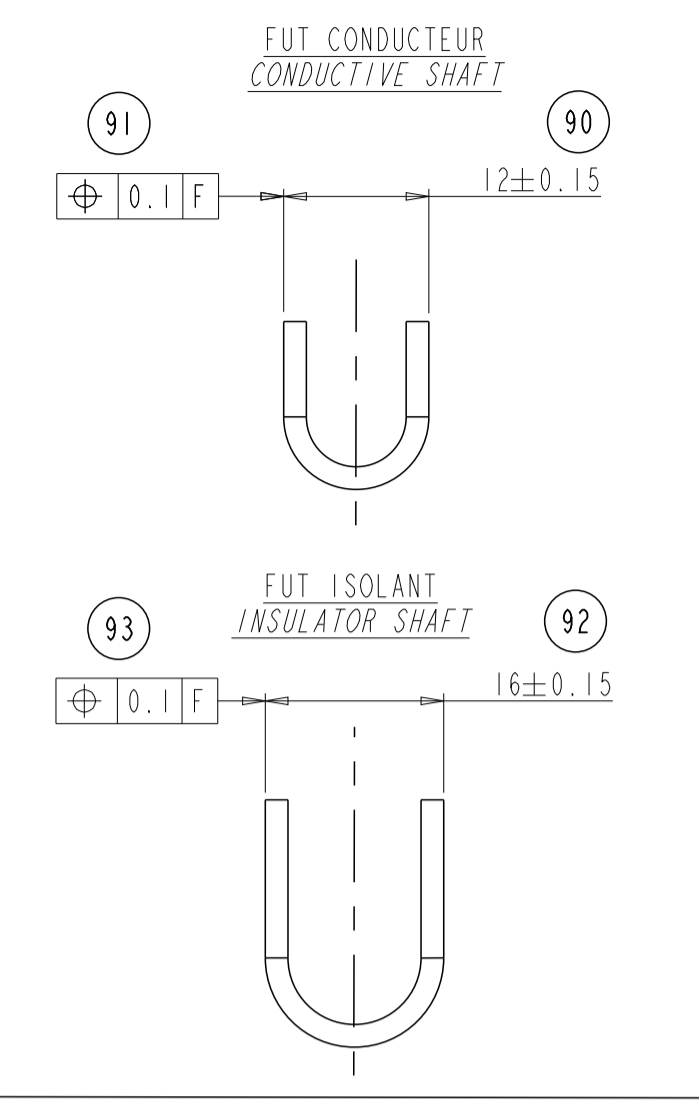


PARAMETRES DE SERTISSAGE / CRIMPING PARAMETERS
 PARAMETRES DE SERTISSAGE RESERVES POUR CETTE APPLICATION. VALEURS OBTENUES AVEC LES OUTILLAGES TYCO
 LES PARAMETRES DE FRETAGE OUTRE LES DIMENSION MAXI SONT DONNES A TITRE INDICATIF
 CRIMPING PARAMETERS FOR THIS APPLICATION ONLY. VALUES OBTAINED WITH TYCO TOOLS
 HOOPING PARAMETERS EXCEPT MAX DIMENSION ARE GIVEN FOR INFORMATION

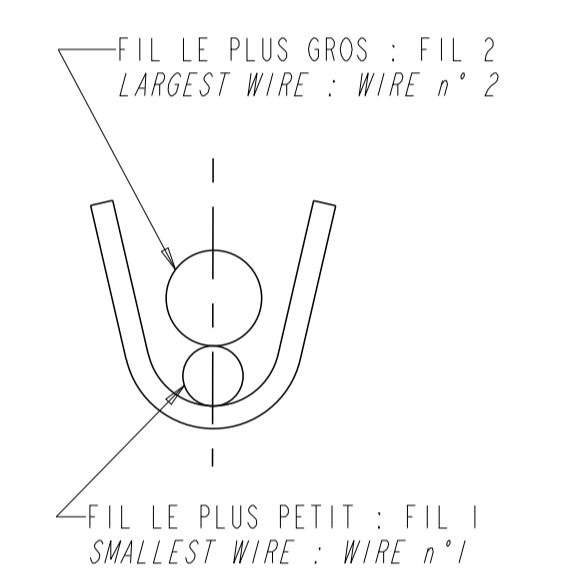
SERTISSAGE CONDUCTIVE SHAFT CRIMPING	SECTION REELLE /REAL AREA mm²	LARGEUR/ WIDTH P±0.2	HAUTEUR/ HEIGHT C±0.15	TRACTION (daN)			FRETAGE DE L'ISOLANT INSULATOR BINDING		
				FIL 1 WIRE n°1	FIL 2 WIRE n°2	2 FILS 2 WIRES	∅ ISOLANT INSULATOR ∅	LARGEUR MAX. MAX. WIDTH M	HAUTEUR MAX. MAX. HEIGHT D
20 + 16	32.82 (18.38+15.44)	12.51	7.9				7.6 + 7.1	17	15.4
20 + 20	36.76 (18.38+18.38)	12.55	8.07				7.6 + 7.6	17.1	15.6
25 + 10	33.26 (23.41+9.84)	12.5	7.86				8.3 + 6.1	17	15.4
25 + 16	38.85 (23.41+15.44)	12.57	8.2				8.3 + 7.1	17.1	15.7
25 + 20	41.8 (23.41+18.38)	12.61	8.37				8.3 + 7.6	17.1	15.9
25 + 25	46.83 (23.41+23.41)	12.68	8.67				8.3 + 8.3	17.2	16.2
40	37.11	12.55	8.09				11.1	17.1	15.6
40 + 10	46.95 (37.11+9.84)	8.68	8.68				11.1 + 6.1	17.2	16.2
40 + 16	52.55 (37.11+15.44)	12.75	9.01				11.1 + 7.1	17.3	16.6
40 + 20	55.49 (37.11+18.38)	12.79	9.18				11.1 + 7.6	17.3	16.7
40 + 25	60.52 (37.11+23.41)	12.85	9.48				11.1 + 8.3	17.4	17.1
60	59.38	12.84	9.41				14	17.3	17
• 25 + 16	39.96	12.6	8.2	220	310	320	10.64	16.7	17.05
• 35(1054x0.2)	33.1	12.4	7.45	350			10.2	17.1	15.6
• 35(273x0.4)	34.3	12.4	7.35	350			10	17.1	15.05
• 40(1140x0.2)	35.81	12.6	8	340			10.6	17.0	15.55
• 40(1140x0.2) +10(143x0.29)	49.33	12.6	8.6				10.6 + 5.7	17.3	16.3
• 60	59.38	12.9	9.4	400			13.90	17.1	17.4
• 70(2128x0.2)	66.85	12.7	8.85	250			13.2	17.5	16.85
• 70(336x0.5)	66	12.7	9	250			13.9	17.5	16.85

LES CONFIGURATIONS AVEC * SONT DES VALEURS VALIDÉES PAR ESSAIS. VALEURS DONNÉES A TITRE INDICATIF ET DOIVENT ÊTRE VALIDÉES PAR LE CABLEUR. DESIGNATION: PAR EXEMPLE, *35(1054x0.2) SIGNIFIE: FIL DE 35mm² COMPOSÉ DE 1054 BRINS DE 0.2mm DE DIAMÈTRE.
 THE CONFIGURATIONS WITH * ARE VALIDATED BY TESTS. VALUES ARE GIVEN FOR INFORMATION AND MUST BE VALIDATED BY HARNESS MAKER
 NAMING: FOR INSTANCE, *35(1054x0.2) MEANS: 35mm² WIRE COMPOSED OF 1054 STRANDS WITH A DIAMETER OF 0.2mm.

LARGEURS NATURELLES
 NATIVE WIDTH



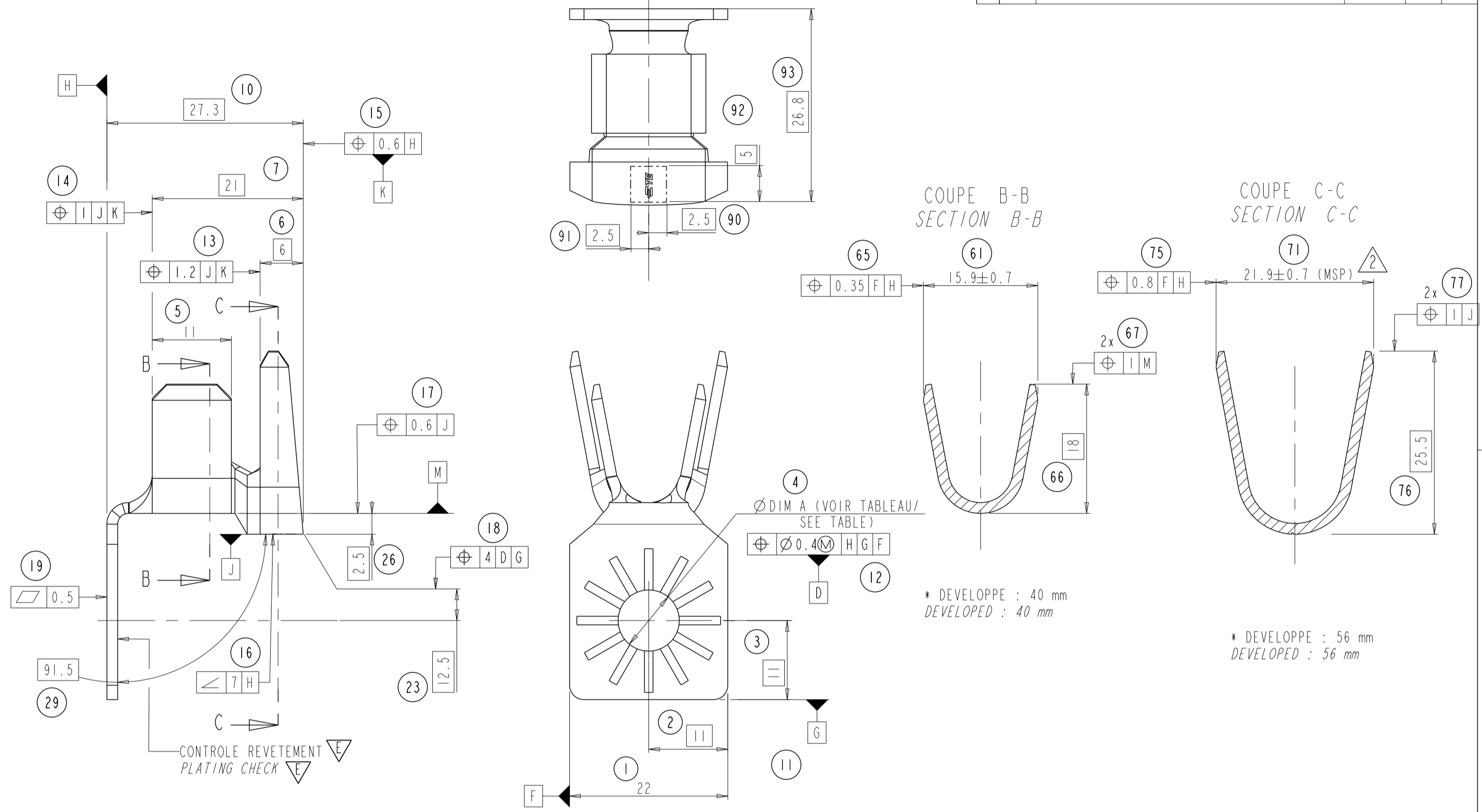
MARIAGE DE FILS
 WIRES COMBINATION



REVISIONS

P	LTN	DESCRIPTION	DATE	DMN	APVD
E		DRAWING FORMAT UPDATE + PACKAGING NOTE	12SEP2013	CPo	JDr

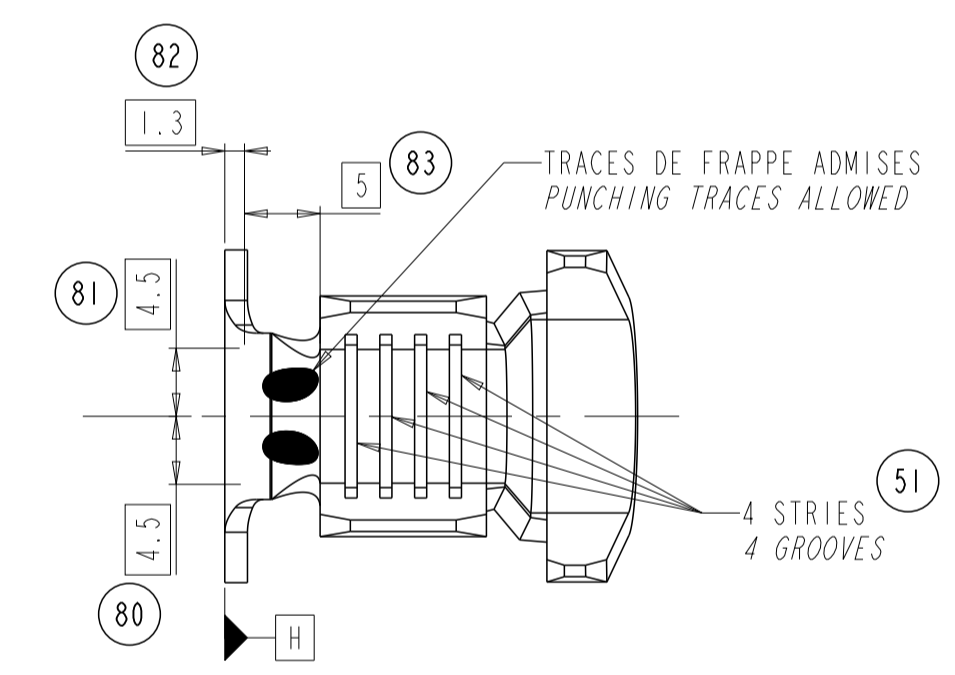
LOGO FOURNISSEUR, ∅ 1.5 mm, PROFONDEUR 0.1^{+0.1}₀ mm
 SUPPLIER'S LOGO, ∅ 1.5 mm, DEPTH 0.1^{+0.1}₀ mm



CARACTERISTIQUES A VERIFIER
 DIMENSIONS TO CHECK

	VALEUR A MESURER CHECKING VALUE	REPÈRE MARKER
DEFORMATION APRES SERTISSAGE DEFORMATION AFTER CRIMPING	FLEXION VERS LE HAUT UPPER FLEXION: 2° maxi	G
	FLEXION VERS LE BAS DOWN FLEXION: 2° maxi	H
	TORSION / TWISTING: 3° maxi	K
DEFORMATION SUIVANT L'AXE DE LA PIÈCE PART'S AXIAL DEFORMATION	2° maxi	I-J
LONGUEUR DE DENUDAGE / LAYING BARE LENGTH	15	A
DEPASSEMENT DU FIL / WIRE'S STICK OUT	2	B

TENUE DE L'ISOLANT : DOUBLE FLEXION A 90° SELON G-H ET I-J
 INSULATOR MECHANICAL ABILITY : DOUBLE FLEXION AT 90° FOLLOWING G-H AND I-J



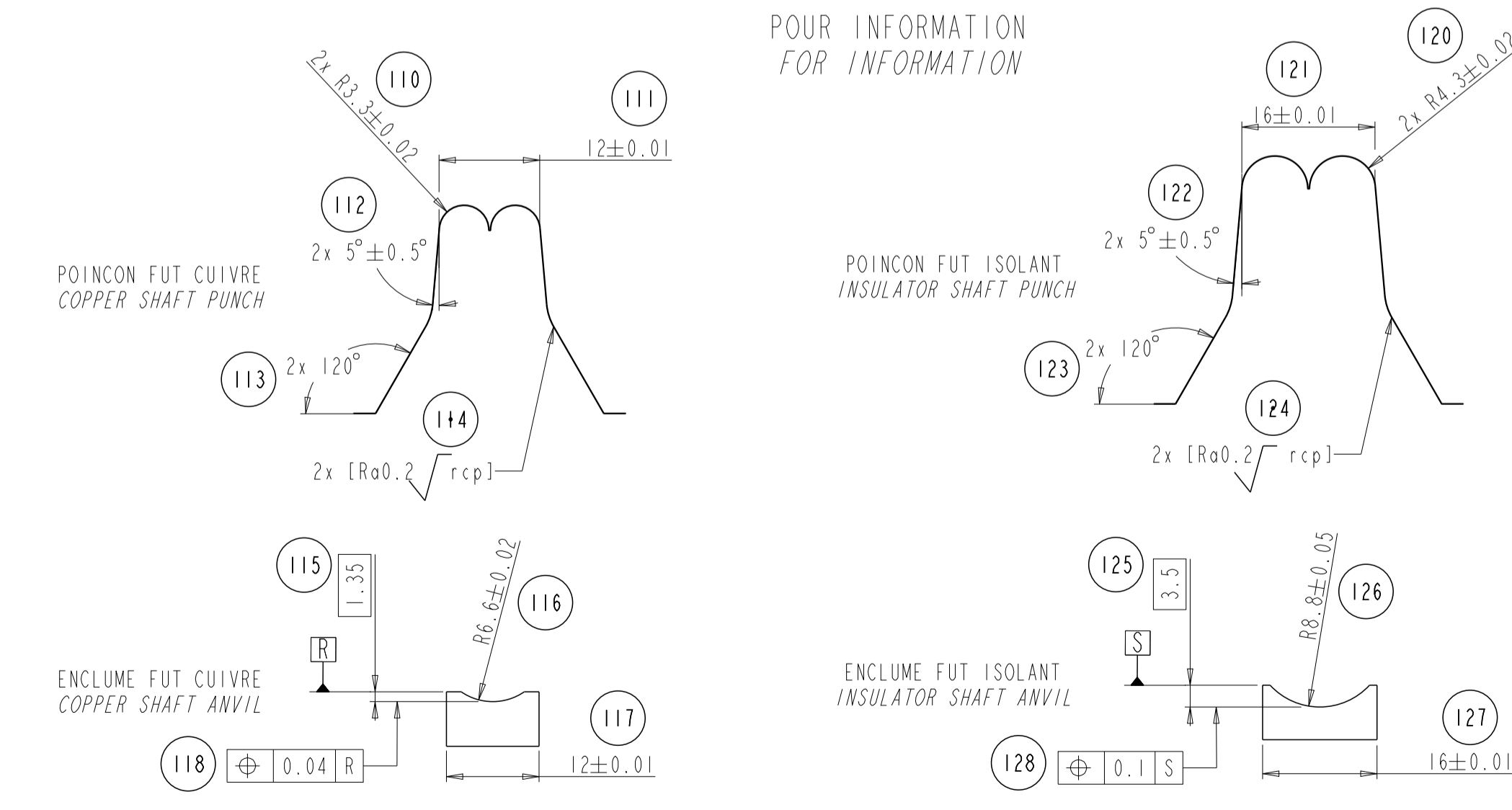
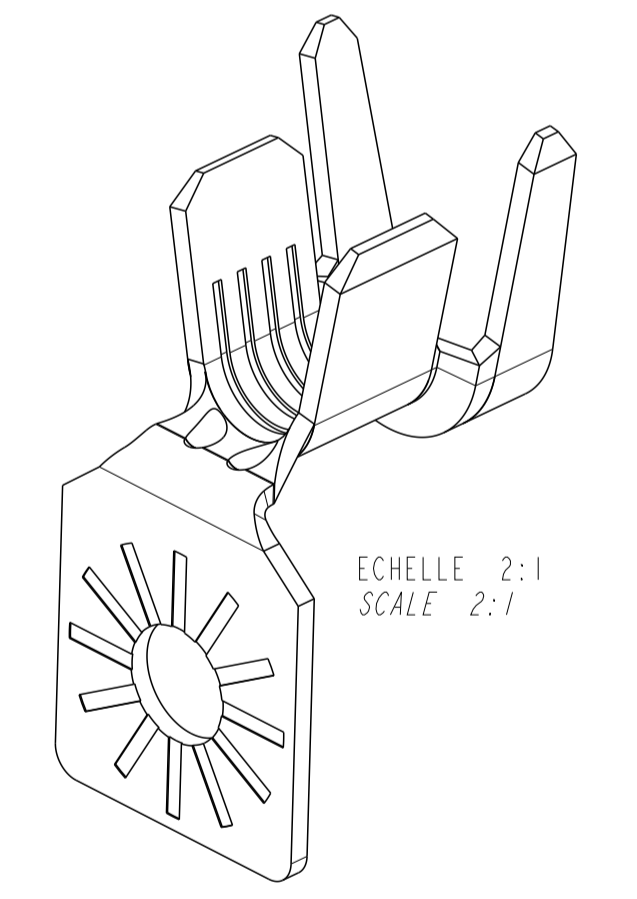
EPAISSEUR MAT. : 1.5±0.05 PROTECTION INCLUSE
 MATERIAL THICKNESS : 1.5±0.05 MM, PLATING INCLUDED

NOTICE DE CONTROLE / CONTROL NOTES

- AU PIED A COULISSE OU AU PROJECTEUR DE PROFIL, VERIFIER LES COTES FIGURANT SUR LE DESSIN CI-DESSUS.
 CHECK ALL DIMENSIONS ON THIS DRAWING WITH SHADOW PROJECTOR OR SLIDE CALIPER.
- TOUTE COTE (MSP), FIGURANT SUR CE PLAN, NON RESPECTEE SUR UN LOT FERA L'OBJET D'UN REFUS PAR RAPPORT AU CONTRAT QUALITE COMPOSANT.
 ALL SCP (MSP) DIMENSION, INCLUDED ON THIS DRAWING, AND NOT RESPECTED IN ONE BATCH WILL RESULT IN A REFUSAL IN ACCORDANCE WITH THE QUALITY COMPOSANT AGREEMENT.
- CE PLAN DE CONTROLE ETANT EXTRAIT DU PLAN DE DEFINITION, ON FERA REFERENCE AU PLAN DE DEFINITION 1544368 EN CAS DE LITIGE.
 AS THIS CONTROL DRAWING IS EXTRACT FROM THE DEFINITION DRAWING, THE REFERENCE IN CASE OF LITIGATION WILL BE THE DRAWING NUMBER : 1544368.

- COTE THEORIQUE AVANT FRAPPE DES CHAMFREINS
 THEORETICAL DIMENSION BEFORE CHAMFER PUNCHING
- () COTE DONNEE POUR INFORMATION
 INFORMATION DIMENSION
- (MSP) COTE SUIVIE EN MSP
 (MSP) DIMENSION FOLLOWED BY SPC

LES PIÈCES SONT MANIPULÉES ET CONDITIONNÉES EN VRAC. CE TYPE DE CONDITIONNEMENT PEUT AFFECTER DIMENSIONNELLEMENT LE PRODUIT. TE N'EST PAS RESPONSABLE DE L'USAGE DE PIÈCES AFFECTÉES.
 PARTS ARE HANDLED AND PACKED AS BULK. THIS CONDITION CAN DIMENSIONALLY AFFECT THE PRODUCT. THE USE OF AFFECTED PARTS IS OUT OF TE RESPONSIBILITY



TRAITEMENT ENCLUMES : 52-54 Hrc
 ANVIL'S TREATMENT : 52-54 Hrc

TRAITEMENT POINCONS : 56-58 Hrc
 PUNCH'S TREATMENT : 56-58 Hrc

ETAT DE SURFACE SUR LES PARTIES ACTIVES DES OUTILS :
 POLIE MIROIR
 SURFACE STATE ON WORKING TOOLS AREAS :
 MIRROR POLISH

∅ A	REF TE TE P/N	REF PRONER COMATEL PRONER COMATEL P/N	MASSE (g) WEIGHT (g)
∅8.5 mm	1544368-1	P40 100 94 8241	17.5
∅6.5 mm	1544368-4	/	17.8

THIS DRAWING IS A CONTROLLED DOCUMENT. DMN E_SAPET 30MAR2006
 CHK P_CHARLES 30MAR2006
 APVD J_DAHER 30MAR2006

DIMENSIONS: mm TOLERANCES UNLESS OTHERWISE SPECIFIED: ±0.2

MATERIAL: CuZn 15 FINISH: POST ETAME / POST TIN PLATED

WEIGHT: SEE TABLE

Customer Drawing

NAME: COSSE COUDEE A 90 DEG - G13
 TERMINAL BENT AT 90 DEG - G13

SIZE: A1 CAGE CODE: DRAWING NO: 1544368 RESTRICTED TO: -

SCALE: 2:1 SHEET 1 OF 1 REV E

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