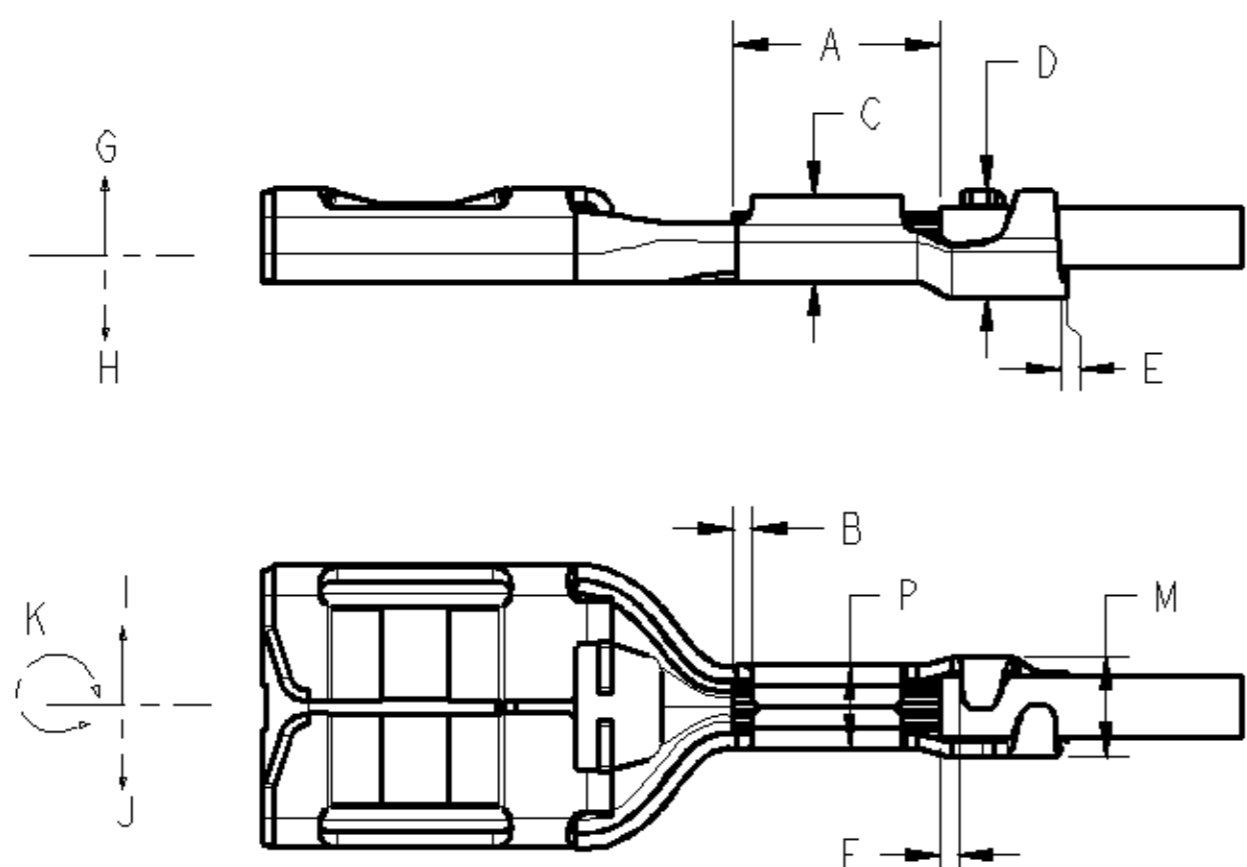


PARAMETRES DE SERTISSAGE CRIMPING PARAMETERS

SERTISSAGE DU CONDUCTEUR CONDUCTOR CRIMPING					FRETTAGE DE L'ISOLANT INSULATION CRIMPING				
DEVELOPPE : 5.8 mm LAYOUT EPAISSEUR METAL : 0.4 mm METAL THICKNESS					DEVELOPPE : 7.2 mm LAYOUT EPAISSEUR METAL : 0.4 mm METAL THICKNESS				
SECTION (mm ²)		LARGEUR POINCON CRIMPER WIDTH	HAUTEUR SERTISSAGE CRIMPED HEIGHT C ±0.05	RESISTANCE EN TRACTION PULLING FORCE (N)	DEFINITION DU FIL WIRE DEFINITION	Ø DU FIL WIRE Ø	SURFACE A FRETTER AREA TO CRIMP	LARGEUR POINCON CRIMPER WIDTH	HAUTEUR SERTISSAGE CRIMPED HEIGHT D ±0.2
CATALOGUE	REELLE REAL								
0.35	0.34	2.29	1.24	rupture > 60	0.35	1.3	1.33	2.54	2.05
0.5	0.49	2.29	1.30	rupture > 60	0.5	1.45	1.65	2.54	2.15
0.6	0.59	2.29	1.33	rupture > 100	0.6	1.8	2.54	2.54	2.45
0.75	0.79	2.29	1.40	rupture > 100	0.75	1.70	2.27	2.54	2.35
0.35 + 0.35	0.68	2.29	1.37	rupture > 60	0.35 + 0.35	1.3 + 1.3	1.33	2.54	2.39

CARACTERISTIQUES A VERIFIER CHARACTERISTICS TO CHECK	VALEUR VALUE	REPERE ITEM
FLEXION VERS LE HAUT UP BENDING	5° maxi	G
FLEXION VERS LE BAS DOWN BENDING	5° maxi	H
TORSION TWIST	8° maxi	K
DEFORMATION DANS L'AXE AXIAL DEFORMATION	6° maxi	I-J
LONGUEUR DE DENUDAGE STRIPPING LENGTH	5 maxi	A
DEPASSEMENT DU CUIVRE CONDUCTOR EXCESS	0.6 ± 0.5	B
DEPASSEMENT DE L'ISOLANT INSULATION EXCESS	(0.8)	F
TEMOIN DE DECOUPE CUTTING BURR	0.5 maxi	E

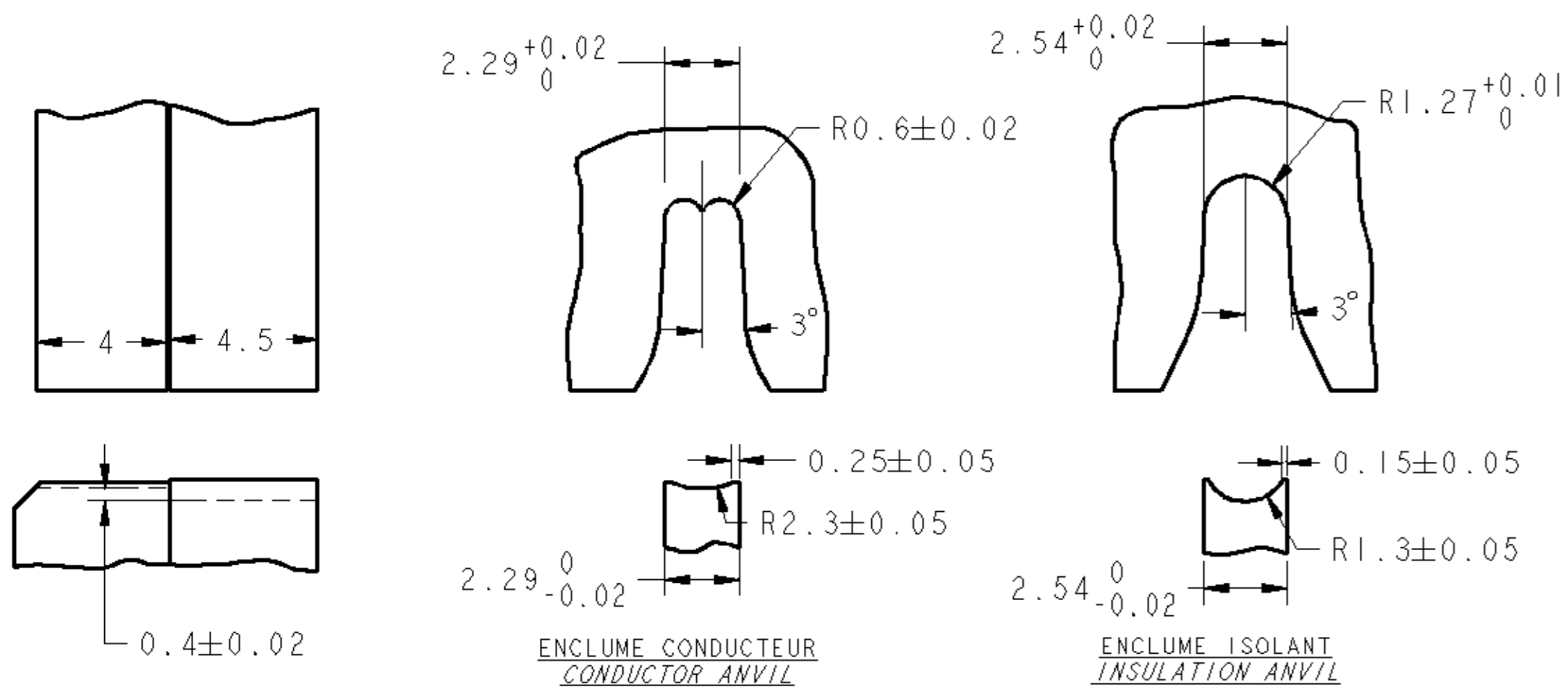


TENUE AU PLIAGE DU SERTISSAGE ISOLANT BENDING RESISTANCE OF THE INSULATION CRIMPING

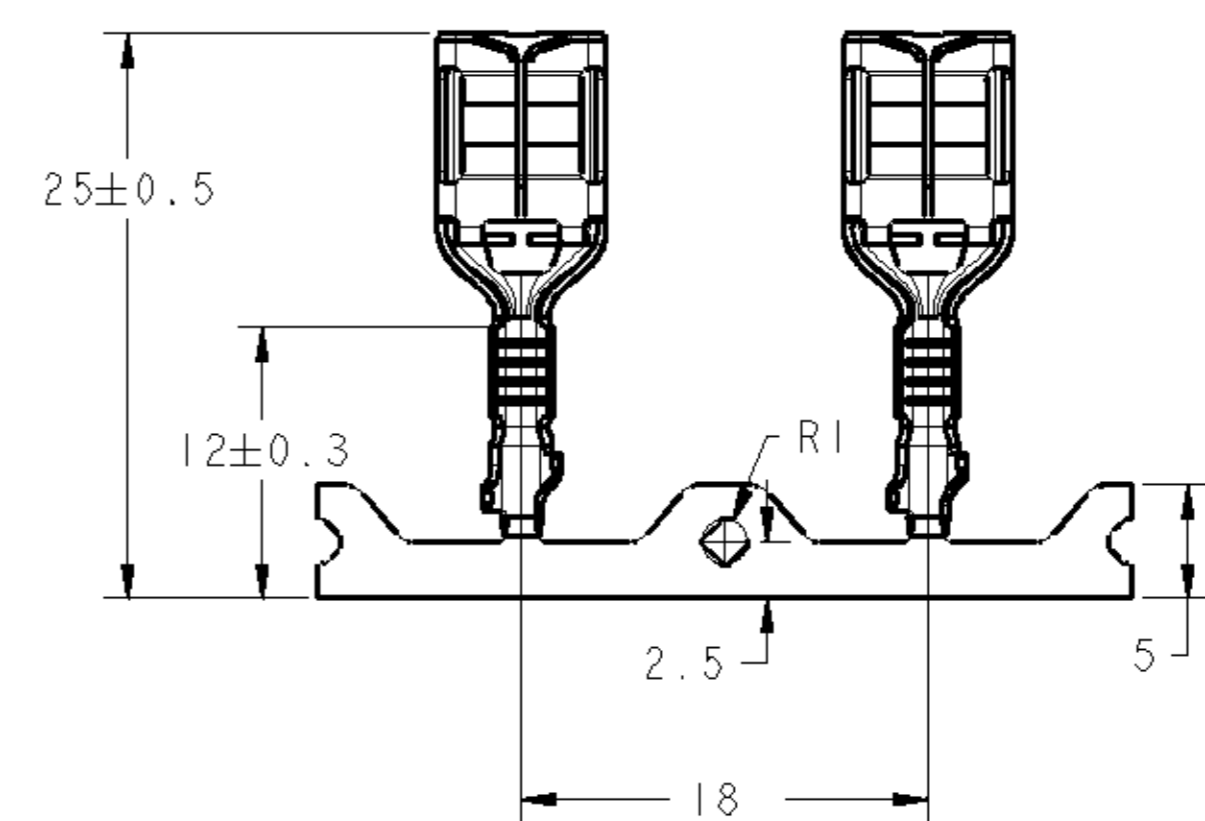
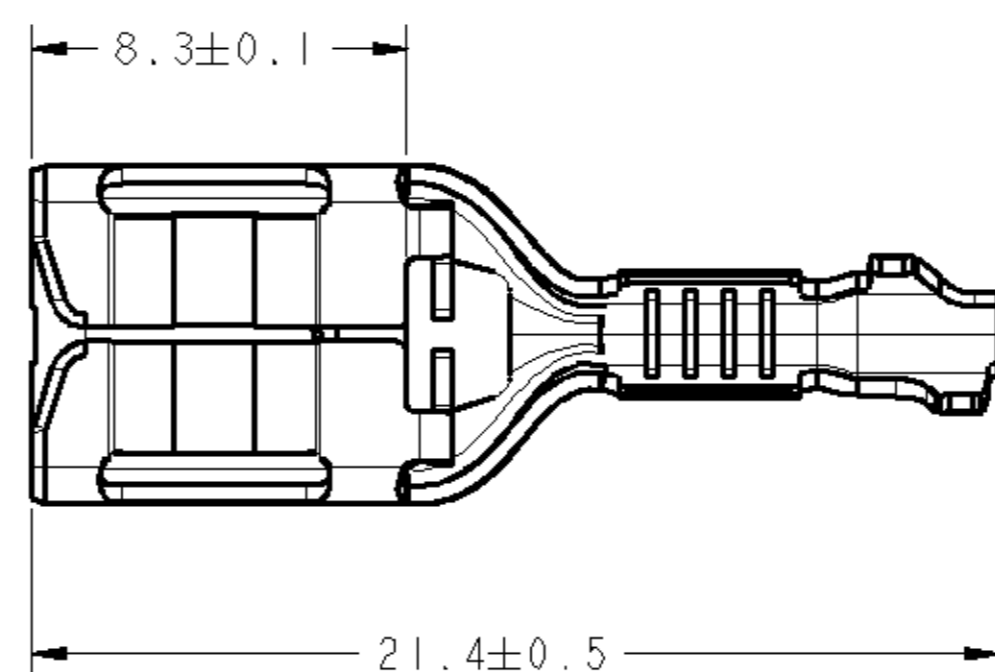
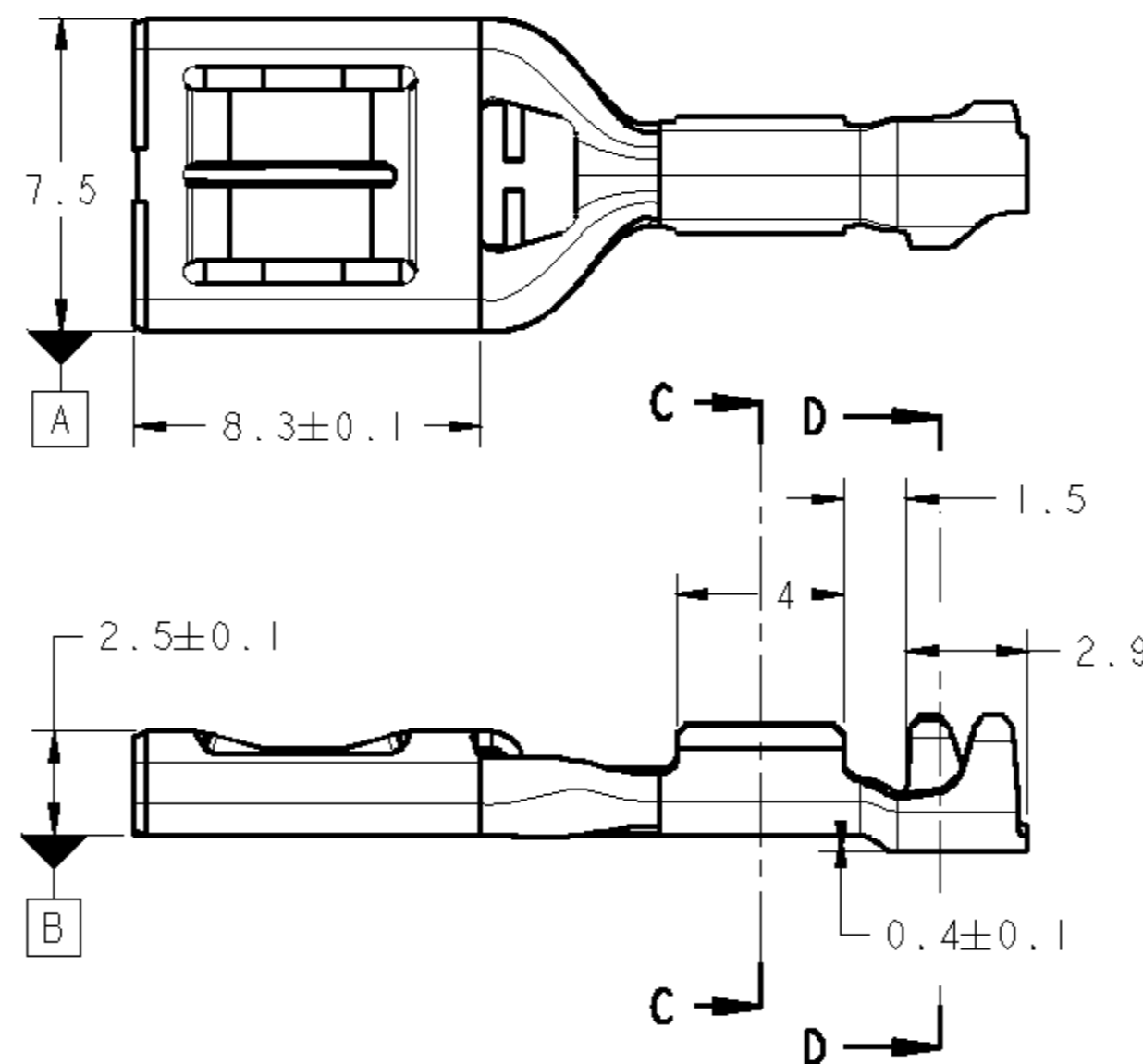
TENUE DE L'ISOLANT APRES 2 PLIAGES A 45° SELON LES AXES I, J, H ET G
(essai effectué à une distance mini de 60mm du fut isolant)
L'ISOLANT NE DOIT PAS AVOIR GLISSE HORS DES AILES DE FRETTAGE
INSULATION RETENTION AFTER 2 BENDINGS AT 45 DEGREES ON AXIS I, J, H & G
(test carried out at a minimum distance of 60 mm from the insulation barrels)
INSULATION MAY NOT HAVE SLIPPED OUT OF INSULATION BARREL

POINCON CONDUCTEUR
CONDUCTOR PUNCH

POINCON ISOLANT
INSULATION PUNCH

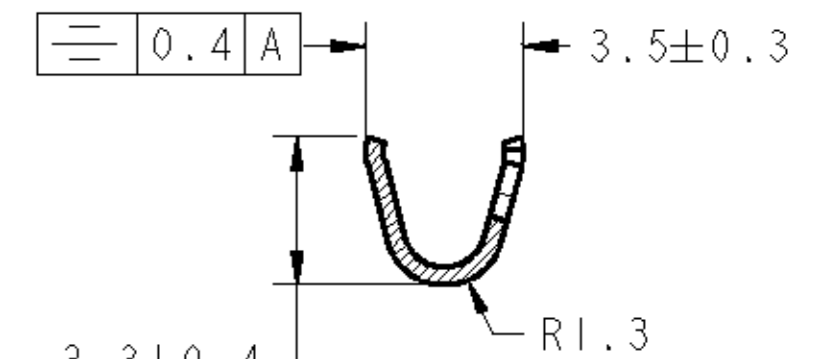
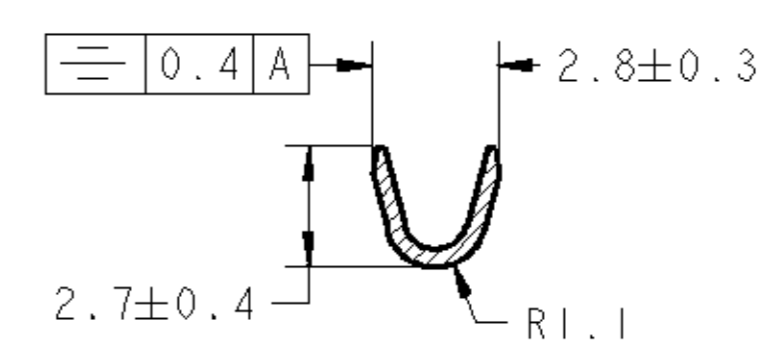


DESSIN DES ENCLUMES ET POINCONS DE SERTISSAGE POUR INFORMATION
ANVILS AND CRIMPERS DEFINITION FOR INFORMATION



COUPE C-C

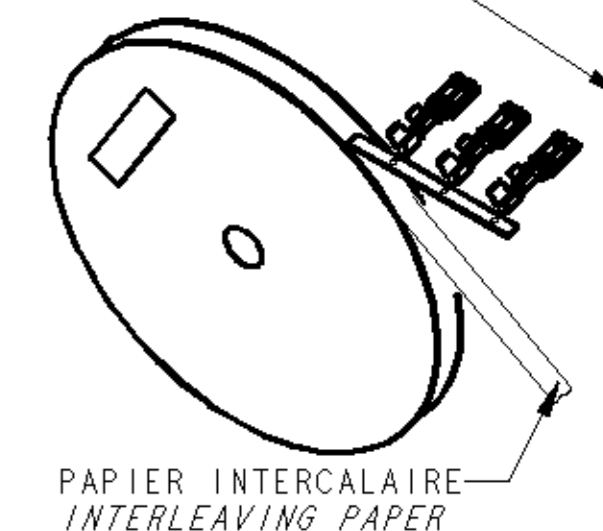
COUPE D-D



CONDITIONNEMENT PACKAGING

CONDITIONNEMENT GALETTE CARTON
PANCAKE REEL PACKAGING

SENS DE DEROULEMENT
DIRECTION OF ROTATION



PAPIER INTERCALAIRE
INTERLEAVING PAPER

NOTICE DE CONTROLE
(CONTROL NOTICE)
VERIFIER LES COTES INDIQUEES SUR LE DESSIN
CHECK DIMENSIONS ON DRAWING

REMARQUES
REMARKS
POUR TOUT LITIGE, ON FERA REFERENCE AU PLAN DE DEFINITION
DEFINITION DRAWING MAKES PRECEDENCE FOR ALL ISSUE

REFERENCE TYCO TYCO PART NUMBER	MATIERE MATERIAL	PROTECTION FINITION
1544615-1	UZ15 440 < Rm < 510 N/mm ²	PRE ETAME PRE TINNED Sn 1.5 to 3 µm

TYCO ELECTRONICS France SAS BP 39, 95301 CERST-PONTOISE Cedex	TYCO ELECTRONICS France SAS BP 39, 95301 CERST-PONTOISE Cedex
DATE: 10SEPT2002 REV: 00	DATE: 10SEPT2002 REV: 00
DESCRIPTION: CLIP 6.35 NG1 0.35 à 0.75mm ²	DESCRIPTION: CLIP 6.35 NG1 0.35 à 0.75mm ²
REVISIONS:	REVISIONS:
NO. LTR. REV. DESCRIPTION	NO. LTR. REV. DESCRIPTION
0 FIRST ISSUE	0 FIRST ISSUE
A Twin crimping parameter added	A Twin crimping parameter added
DATE: 09-aug-04	DATE: 09-aug-04
PC: JDr	PC: JDr
APPROVED:	APPROVED:
DATE: 11SEPT2002	DATE: 11SEPT2002
BY: P.FLORES	BY: P.FLORES
PRODUCT SPEC: 108-15276	PRODUCT SPEC: 108-15276
APPLICATION SPEC: 114-15095	APPLICATION SPEC: 114-15095
WEIGHT: 0.0007 kg	WEIGHT: 0.0007 kg
CUSTOMER DRAWING	CUSTOMER DRAWING
SCALE: 6:1	SCALE: 6:1
SHEET: 1 OF 1	SHEET: 1 OF 1
REV: A	REV: A

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