

**Crimping of 0.64 III Receptacle Contact**

The performance of applicable product is guaranteed only when processed by proper application tooling and condition described in this specification and/or TE recognized ones.  
 No product is guaranteed when processed with the other tool or condition.

**1. SCOPE**

This specification covers the requirements for crimping of 0.64 III Receptacle Contact.

**2. APPLICABLE CONTACTS**

| TE Part Numbers (Strip Form) | NAME                            | Finish         | Applicable Wires  |
|------------------------------|---------------------------------|----------------|---|
| 1674936-5                    | 0.64 III RECEPTACLE CONTACT (S) | Pre-Tin        | CHFUS 0.22  |
| 1674936-6                    |                                 | Selective Gold |   |
| 1674311-7                    | 0.64 III RECEPTACLE CONTACT (M) | Pre-Tin        | AVSS 0.3-0.5<br>CAVUS 0.3 CAVS 0.3-0.5<br>CHFUS 0.35-0.5<br>AVSS/AVSSH 0.3f-0.5f<br>HFSS 0.35f-0.5f |
| 1674311-8                    |                                 | Selective Gold |   |

**3. NOMENCLATURE**

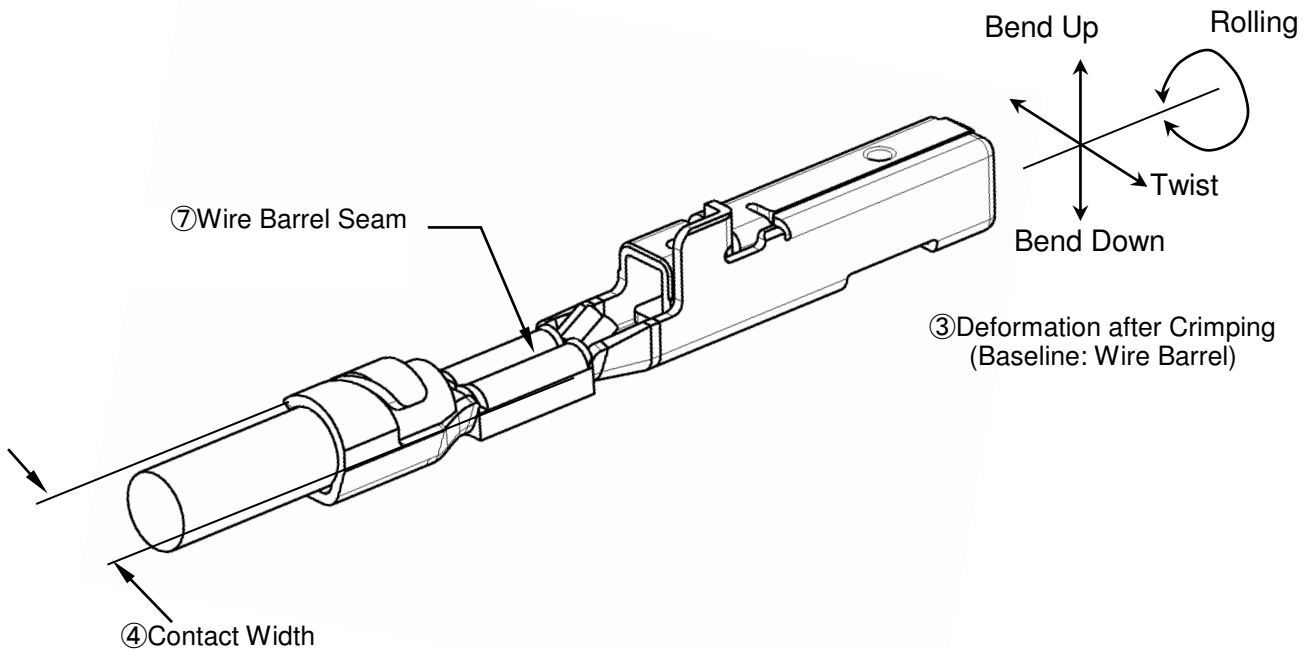


Fig.1 (To be continued)

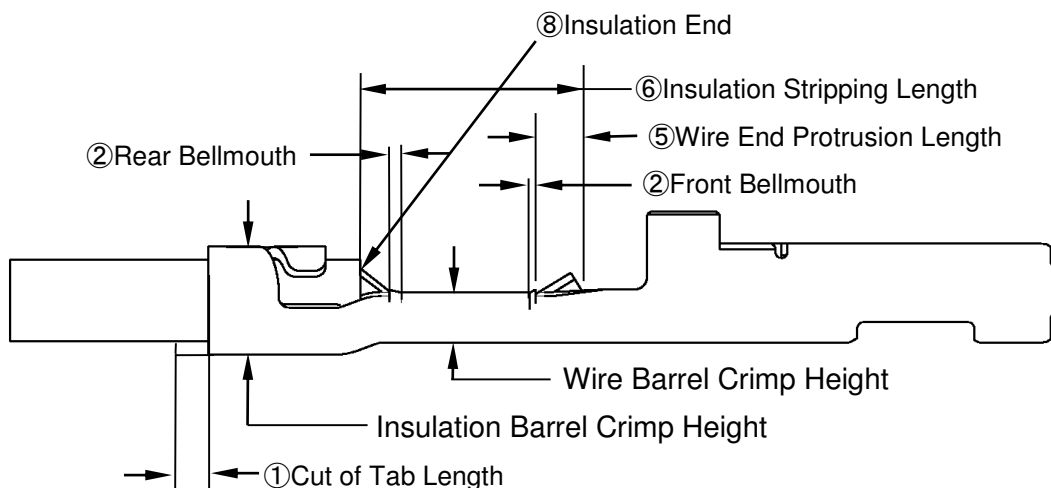


Fig.1 (End)

#### 4. CRIMPING CONDITION

##### Applicator Crimp

| Check Items |  | Requirements   | Remarks      |
|-------------|--|--|--------------|
| 1           | Cut-off Tab Length                                 | 0.1–0.5 mm   | Fig.1–①      |
| 2           | Bellmouth  | Front  | 0.2 mm Max.  |
|             |  | Rear   | 0.1–0.5 mm   |
| 3           | Deformation after Crimping (Baseline: Wire Barrel) | Bend   | –1°, +2°Max. |
|             |  | Twist  | ±4°Max.      |
|             |  | Rolling  | ±10°Max.     |
| 4           | Contact Width after Crimping                       | 1.7mm Max.   | Fig.1–④      |
| 5           | Wire End Protrusion Length                         | 0–1.0 mm   | Fig.1–⑤      |
| 6           | Insulation Stripping Length                        | 3.0–3.5 mm (Before Crimping)                                     | Fig.1–⑥      |
| 7           | Wire Barrel Seam                                   | Seam must be closed (No strand looses out of the seam)           | Fig.1–⑦      |
| 8           | Insulation End                                     | Insulation End must be between Wire Barrel and Insulation Barrel | Fig.1–⑧      |

## 5. CRIMP DATA

### Applicator Crimp

| Contact Part Number (Strip Form) | Applicator Part Number | Wire Type | Wire Size (Nominal) | Wire Barrel Crimp (mm) |                     |           | Insulation Barrel Crimp (mm) |              |                  | Crimp Tensile Strength (N) |
|----------------------------------|------------------------|-----------|---------------------|------------------------|---------------------|-----------|------------------------------|--------------|------------------|----------------------------|
|                                  |                        |           |                     | Width <sup>(2)</sup>   | Height              | Disk Ltr. | Width <sup>(2)</sup>         | Height       | Disk Ltr. (Ref.) |                            |
| 1674936-5<br>1674936-6           | 1729145-2              | CHFUS     | 0.22                | 1.16<br>"F"            | 0.73 <sup>(1)</sup> | A         | 1.4<br>"O"                   | 1.3<br>±0.1  | 5                | 30Min.                     |
| 1674311-7<br>1674311-8           | 1596731-2              | AVSS      | 0.3<br>0.3f         | 1.4<br>"F"             | 0.76 <sup>(1)</sup> | B         | 1.4<br>"O"                   | 1.85<br>±0.1 | 5                | 50Min.                     |
|                                  |                        |           | 0.5<br>0.5f         |                        | 0.86 <sup>(1)</sup> | A         |                              |              |                  | 70Min.                     |
|                                  |                        | AVSSH     | 0.3f                | 1.4<br>"F"             | 0.76 <sup>(1)</sup> | B         | 1.4<br>"O"                   | 1.85<br>±0.1 | 5                | 50Min.                     |
|                                  |                        |           | 0.5f                |                        | 0.86 <sup>(1)</sup> | A         |                              |              |                  | 70Min.                     |
|                                  |                        | CAVUS     | 0.3                 | 1.4<br>"F"             | 0.76 <sup>(1)</sup> | B         | 1.4<br>"O"                   | 1.5<br>±0.1  | 5                | 50Min.                     |
|                                  |                        | CAVS      | 0.3                 | 1.4<br>"F"             | 0.76 <sup>(1)</sup> | B         | 1.4<br>"O"                   | 1.85<br>±0.1 | 5                | 50Min.                     |
|                                  |                        |           | 0.5                 |                        | 0.86 <sup>(1)</sup> | A         |                              |              |                  | 70Min.                     |
|                                  |                        | CHFUS     | 0.35                | 1.4<br>"F"             | 0.76 <sup>(1)</sup> | B         | 1.4<br>"O"                   | 1.5<br>±0.1  | -                | 50Min.                     |
|                                  |                        |           | 0.5                 |                        | 0.82 <sup>(1)</sup> | -         |                              | 1.7<br>±0.1  | -                | 70Min.                     |
|                                  |                        | HFSS      | 0.35f               | 1.4<br>"F"             | 0.76 <sup>(1)</sup> | B         | 1.4<br>"O"                   | 1.7<br>±0.1  | -                | 50Min.                     |
| 0.5f                             | 0.82 <sup>(1)</sup>    |           | -                   |                        | 1.85<br>±0.1        | -         |                              | 70Min.       |                  |                            |



NOTE (1) Wire Barrel Crimp Height to be within ±0.05mm.

(2) Crimp Width dimensions are not the product width after crimping, but given by the width of crimper slot for reference.

## 6. APPLICABLE WIRE DATA

### 1) JASO WIRE

| Wire Size (Nominal) | Number /Diameter (mm) of Conductor | Calculated Cross sectional Area (mm <sup>2</sup> ) | Insulation Diameter (mm) |      |      |      |       |      |
|---------------------|------------------------------------|--|--------------------------|------|------|------|-------|------|
|                     |                                    |  | AVSS/AVSSH               |      | CAVS |      | CAVUS |      |
|                     |                                    |  | STD.                     | Max. | STD. | Max. | STD.  | Max. |
| 0.3                 | 7/0.26                             | 0.3716   | 1.4                      | 1.5  | 1.4  | 1.5  | 1.1   | 1.2  |
| 0.3f                | 19/0.16                            | 0.3821   | 1.4                      | 1.5  | -    | -    | -     | -    |
| 0.5                 | 7/0.32                             | 0.5629   | 1.6                      | 1.7  | 1.6  | 1.7  | -     | -    |
| 0.5f                | 19/0.19                            | 0.5387   | 1.6                      | 1.7  | -    | -    | -     | -    |

### 2) ISO WIRE

| Wire Size (Nominal) | Number /Diameter (mm) of Conductor | Calculated Cross sectional Area (mm <sup>2</sup> ) | Perimeter of conductor (mm) | Insulation Diameter (mm) |      |      |      |
|---------------------|------------------------------------|--|-----------------------------|--------------------------|------|------|------|
|                     |                                    |  |                             | CHFUS                    |      | HFSS |      |
|                     |                                    |  |                             | STD.                     | Max. | STD. | Max. |
| 0.22                | 7/ circular compression            | 0.2199   | 0.55                        | 0.95                     | 1.05 | -    | -    |
| 0.35                | 7/ circular compression            | 0.3436   | 0.7                         | 1.1                      | 1.2  | -    | -    |
| 0.35f               | 19/0.155                           | 0.3585   | 0.8                         | -                        | -    | 1.3  | 1.4  |
| 0.5                 | 7/ circular compression            | 0.4948   | 0.85                        | 1.25                     | 1.4  | -    | -    |
| 0.5f                | 19/0.185                           | 0.5107   | 0.95                        | -                        | -    | 1.5  | 1.7  |

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