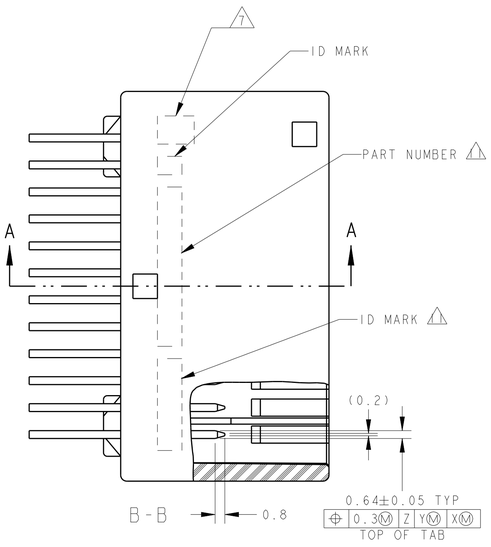
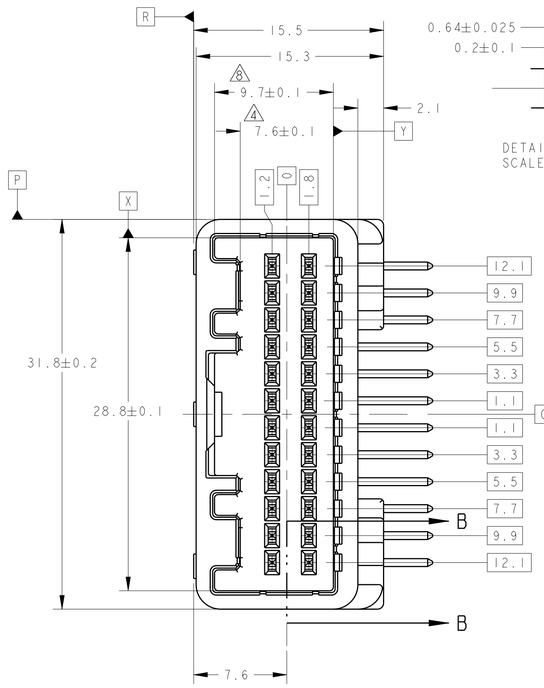
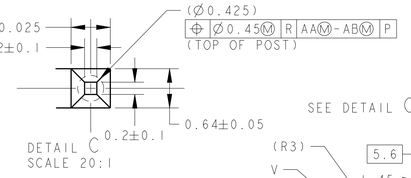
REVISIONS

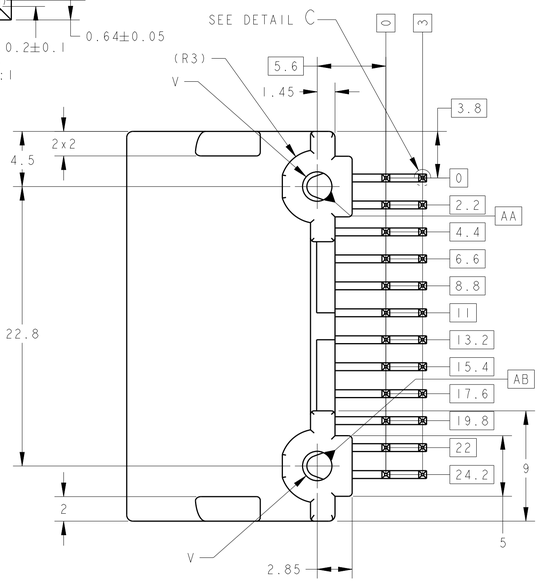
P	LTR	DESCRIPTION	DATE	DWN	APVD
	D9	ADD 3- -3 ECR-15-014505	06OCT2015	TS	HY
	D10	ADD 3- -4 ECR-16-003897	15MAR2016	TS	HY
	D11	REVISED ECR-16-003439	22MAR2017	KF	TK

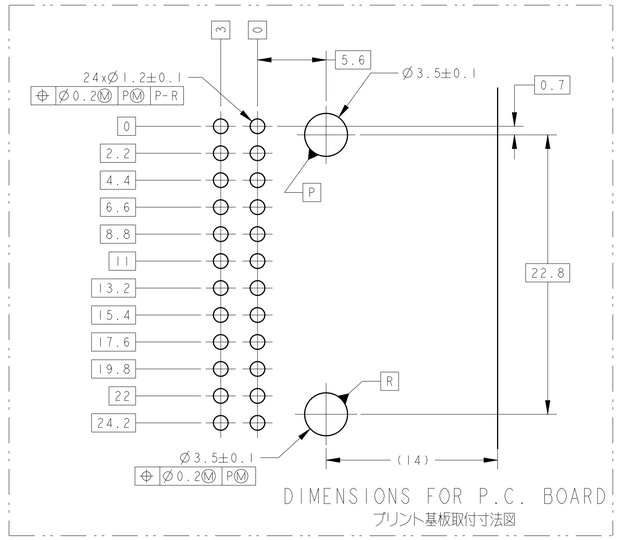
LOC J

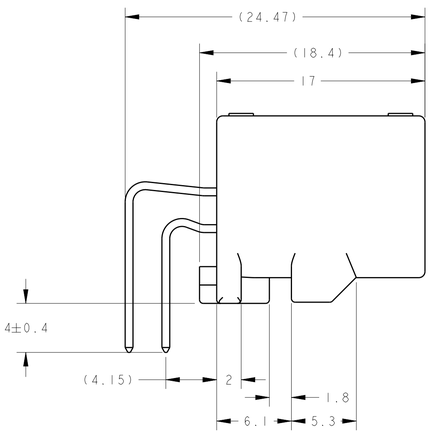


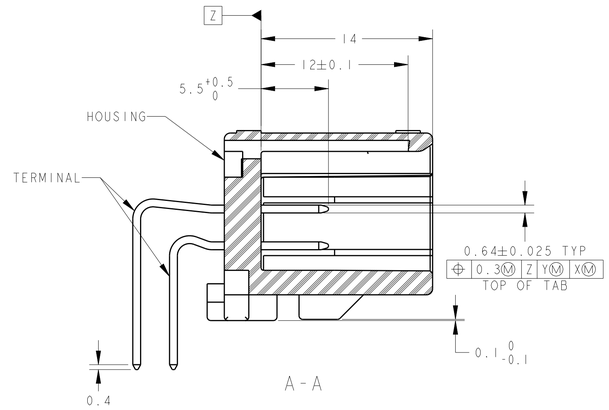


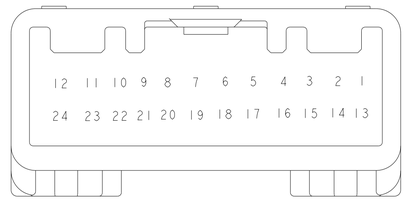












9 FIG.1 回路番号
CIRCUIT NUMBER

1 6	5.6	Ø2.63	PLASTIC BOX 透い箱	PLASTIC TUBE プラスチックチューブ	24	SELECTIVE-TIN (MATTE)	SELECTIVE-TIN × 24 (BRIGHT)	—//—	SPS GF17	NATURAL	1-1318853-7
1 10	4.5	Ø2.63	PAPER BOX ダンボール箱	PLASTIC TUBE プラスチックチューブ	12	SELECTIVE-TIN (MATTE)	SELECTIVE GOLD × 12	1,4,7,10~13 16,19,22~24	SPS GF17	BLACK	1-1318853-6
1 6	5.6	Ø2.63	PAPER BOX ダンボール箱	PLASTIC TUBE プラスチックチューブ	24	SELECTIVE-TIN (MATTE)	SELECTIVE-TIN × 24 (BRIGHT)	—//—	SPS GF17	NATURAL	1-1318853-3
5	5.1	Ø2.4	PAPER BOX ダンボール箱	PLASTIC TUBE プラスチックチューブ	12	SELECTIVE TIN	SELECTIVE GOLD × 12	1,4,7,10~13 16,19,22~24	PBT GF15	BLACK	1-1318853-1
5	5.1	Ø2.4	PAPER BOX ダンボール箱	PLASTIC TUBE プラスチックチューブ	12	SELECTIVE-TIN	SELECTIVE GOLD × 12	1,4,7,10~13 16,19,22~24	PBT GF15	NATURAL	1-1318853-0
4	5.1	Ø2.4	PLASTIC BOX 透い箱	PLASTIC TUBE プラスチックチューブ	12	SELECTIVE-TIN	SELECTIVE GOLD × 12	1,4,7,10~13 16,19,22~24	PBT GF15	BLACK	1318853-9
4	5.1	Ø2.4	PLASTIC BOX 透い箱	PLASTIC TUBE プラスチックチューブ	12	SELECTIVE-TIN	SELECTIVE GOLD × 12	1,4,7,10~13 16,19,22~24	PBT GF15	NATURAL	1318853-8
3	6.0	Ø2.4	PAPER BOX ダンボール箱	PLASTIC TUBE プラスチックチューブ	24	TIN-LEAD	SELECTIVE GOLD x 24	1~24	PBT GF15	BLACK	1318853-5
3	6.0	Ø2.4	PLASTIC BOX 透い箱	PLASTIC TUBE プラスチックチューブ	24	TIN-LEAD	SELECTIVE GOLD x 24	1~24	PBT GF15	BLACK	1318853-4
1	6.0	Ø2.4	PAPER BOX ダンボール箱	PLASTIC TUBE プラスチックチューブ	24	PRE-TIN x 24		—//—	PBT GF15	NATURAL	1318853-2
1	6.0	Ø2.4	PLASTIC BOX 透い箱	PLASTIC TUBE プラスチックチューブ	24	PRE-TIN x 24		—//—	PBT GF15	NATURAL	1318853-1
1 MARKING マーキング	WEIGHT (g) 質量	V	OUTER 外装 / PACKING STYLE 梱包形態	INNER 内装	TOTAL NUMBER OF CIRCUIT 回路総数	SOLDERING SIDE 半田付け側 / CONTACT FINISH コンタクト仕上	CONTACT SIDE 接触部側	GOLD PLATED CIRCUIT NO (金めっき回路番号) 9	MATERIAL 材料 / HOUSING ハウジング	COLOR 色	PART NUMBER 製品型番

1. PART NUMBER OF HOUSING TO BE MATE : SEE TABLE -1
   TO BE MATED SMOOTHLY WITH THE PLUG HOUSING ASSEMBLY
2. RECOMMENDED SCREW :
   PAN-HEADED TYPE 2 TAPPING SCREW, NOMINAL DIAMETER 3mm,
   LENGTH; SEE TABLE-3 (JIS B1115,B1122)
3. FASTENING TORQUE FOR SCREW : 0.392N-m MAX
4. MEASURED AT 6 mm FROM Z
5. INSTRUCTION SHEET NO : 411-5928
6. APPLIED TERMINAL : SEE TABLE -2
7. IDENTIFICATION MARK FOR THE CONTACT FINISH ; SEE TABLE
8. MEASURED AT 2 mm FROM Z
9. CIRCUIT NUMBER : SEE FIG.1
10. ~~PRELIMINARY - NOT RELEASED FOR PRODUCTION.~~
11. ID MARK, PART NUMBER INDICATED.

1. 嵌合相手ハウジングは TABLE -1参照
   プラグハウジングアッセンブリィ(PN 1318917)と
   支障なく嵌合すること
2. 推奨取付ねじ :
   JIS B1115, B1122タッピングねじ
   なべ2種 呼び径 3 , 長さ:TABLE-3参照
3. ねじ締め付けトルク : 0.392N-m最大
4. Z 面から6mmの位置で測定
5. 取扱い説明書 NO : 411-5928
6. 適応端子は TABLE -2参照
7. コンタクト仕上識別記号 ; 表参照
8. Z 面から2mmの位置で測定
9. 回路番号 : FIG.1 参照
10. ~~試作の為量産されていない。~~
11. ID MARK, PART NUMBERを表示。

TABLE -1

POS 極数	PLUG HOUSING PART NO プラグハウジング 型番
24	1318917

TABLE -2

		TERMINAL NO 端子型番	APPLICABLE WIRE RANGE (FEMALE) 適用電線(メス)
SIGNAL 025	TIN	1123343-1	AVSS/AVSSH 0.3~0.5mm²
	SELECTIVE GOLD	1123343-2	CAVS/CAVUS 0.22~0.5mm²

TABLE -3

プリント基板板厚(mm) THICKNESS OF PCB(mm)	1.2	1.6
固定用ねじ首下長さ(mm) NOMINAL LENGTH OF SCREW(mm)	5	6

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: 単位: 粍 mm
TOLERANCES UNLESS OTHERWISE SPECIFIED:
一般公差 ± 0.3
0 PLC ±
1 PLC ±0.1
2 PLC ±0.05
3 PLC ±0.025
4 PLC ±0.0001
ANGLES ±1°

MATERIAL 材料: CONTACT:BRASS HOUSING:SEE TABLE
FINISH 仕上: SEE TABLE

DWN Y. NOGUCHI 08MAR00
CHK N. SAI 10MAR00
APVD N. SAI 10MAR00
PRODUCT SPEC 製品規格: 108-5668
APPLICATION SPEC 設計適用規格: 114-5250
WEIGHT: SEE TABLE

TE Connectivity

NAME 名称: 025SERIES 24POSITION(PCB H-TYPE) CAP HOUSING ASSEMBLY

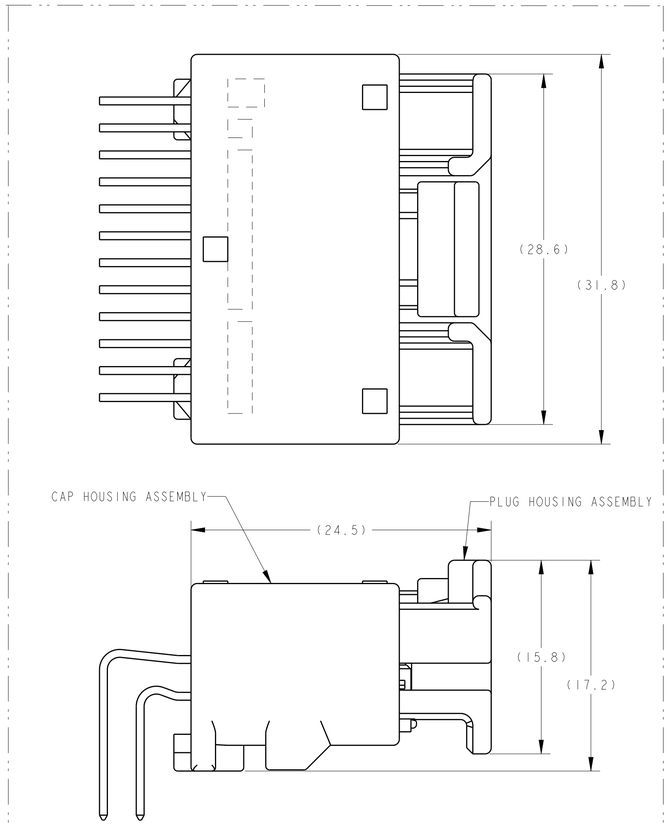
SIZE A1 | CAGE CODE 00779 | DRAWING NO 書番 C-1318853 | RESTRICTED TO

CUSTOMER DRAWING | SCALE 4:1 | SHEET 1 OF 2 | REV D11

LOC	DIST
J	-

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	-	SEE SHEET 1	-	-	-



CAP ASSEMBLY & PLUG ASSEMBLY ENGAGEMENT VIEW
キャップアッセンブリ&プラグアッセンブリ嵌合図

MARKING マーキング	WEIGHT (g) 質量	V	OUTER 外装 / PACKING STYLE 梱包形態	INNER 内装 / PACKING STYLE 梱包形態	TOTAL NUMBER OF CIRCUIT 回路総数	SOLDERING SIDE 半田付け側	CONTACT SIDE 接触部側 / CONTACT FINISH コンタクト仕上	GOLD PLATED CIRCUIT NO (金めっき回路番号)	MATERIAL 材料	COLOR 色	PART NUMBER 製品型番
-	6.0	Ø2.4	PAPER BOX ダンボール箱	PLASTIC TUBE プラスチックチューブ	24	SELECTIVE-TIN (MATTE)	SELECTIVE GOLD x 24	1~24	PBT GF15	NATURAL	1-6318853-2
△12	6.0	Ø2.4	PAPER BOX ダンボール箱	PLASTIC TUBE プラスチックチューブ	24	SELECTIVE-TIN (MATTE)	SELECTIVE-TIN × 24 (BRIGHT)	〃	PBT GF15	NATURAL	3-1318853-5
SEE DWG 3-1318853-3											3-1318853-3
1	6.0	Ø2.4	PAPER BOX ダンボール箱	PLASTIC TUBE プラスチックチューブ	24	PRE-TIN x 24		〃	PBT GF15	BLACK	3-1318853-1
△9	5.6	Ø2.63	PLASTIC BOX 通い箱	PLASTIC TUBE プラスチックチューブ	24	SELECTIVE-TIN (MATTE)	SELECTIVE GOLD x 24	1~24	SPS GF17	NATURAL	2-1318853-7
△11	5.6	Ø2.63	PLASTIC BOX 通い箱	PLASTIC TUBE プラスチックチューブ	24	SELECTIVE-TIN (MATTE)	SELECTIVE GOLD x 4 SELECTIVE-TIN(BRIGHT) x 20	3~6	SPS GF17	NATURAL	2-1318853-4
△10	4.5	Ø2.63	PAPER BOX ダンボール箱	PLASTIC TUBE プラスチックチューブ	12	SELECTIVE-TIN (MATTE)	SELECTIVE GOLD × 12	1,4,7,10~13 16,19,22~24	SPS GF17	NATURAL	2-1318853-1
8	5.1	Ø2.4	PLASTIC BOX 通い箱	PLASTIC TUBE プラスチックチューブ	12	SELECTIVE-TIN (MATTE)	SELECTIVE GOLD × 12	1,4,7,10~13 16,19,22~24	PBT GF15	BLACK	2-1318853-0
8	5.1	Ø2.4	PLASTIC BOX 通い箱	PLASTIC TUBE プラスチックチューブ	12	SELECTIVE-TIN (MATTE)	SELECTIVE GOLD × 12	1,4,7,10~13 16,19,22~24	PBT GF15	NATURAL	1-1318853-9
△9	5.6	Ø2.63	PAPER BOX ダンボール箱	PLASTIC TUBE プラスチックチューブ	24	SELECTIVE-TIN (MATTE)	SELECTIVE GOLD x 24	1~24	SPS GF17	NATURAL	1-1318853-8
63	6.0	Ø2.4	PAPER BOX ダンボール箱	PLASTIC TUBE プラスチックチューブ	24	SELECTIVE-TIN (MATTE)	SELECTIVE GOLD x 24	1~24	PBT GF15	BLACK	6318853-5
63	6.0	Ø2.4	PLASTIC BOX 通い箱	PLASTIC TUBE プラスチックチューブ	24	SELECTIVE-TIN (MATTE)	SELECTIVE GOLD x 24	1~24	PBT GF15	BLACK	6318853-4
62	6.0	Ø2.4	PLASTIC BOX 通い箱	PLASTIC TUBE プラスチックチューブ	24	SELECTIVE-TIN (MATTE)	SELECTIVE GOLD x 4 SELECTIVE-TIN(BRIGHT) x 20	3~6	PBT GF15	NATURAL	6318853-3

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: 単位: 耗 mm

TOLERANCES UNLESS OTHERWISE SPECIFIED:
一般公差 ± 0.3
0 PLC ±
1 PLC ±0.1
2 PLC ±0.05
3 PLC ±0.025
4 PLC ±0.0001
ANGLES ±°

MATERIAL 材料: CONTACT:BRASS HOUSING:SEE TABLE
FINISH 仕上: SEE TABLE

DWN	Y. NOGUCHI 08MAR00
CHK	N. SAI 10MAR00
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PRODUCT SPEC 製品規格	108-5668
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WEIGHT	SEE TABLE

TE Connectivity

NAME 名称: 025SERIES 24POSITION(PCB H-TYPE) CAP HOUSING ASSEMBLY

SIZE	CAGE CODE	DRAWING NO 書番	RESTRICTED TO
A1	00779	C-1318853	-

CUSTOMER DRAWING | SCALE 尺度 4:1 | SHEET 2 OF 2 | REV D11

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 .025 Receptacle Contact.

2. Applicable Contacts

TE Part Numbers		Finish	Applicable Wires
Strip Form	Loose Piece		
1123343-1	1318143-1	Pre-Tin	AVSS/AVSSH/AESSX 0.3-0.5 CAVUS/ CAVS 0.22-0.5 TWP 0.35-0.5
1123343-2	1318143-2	Selective Gold	

3. Nomenclature

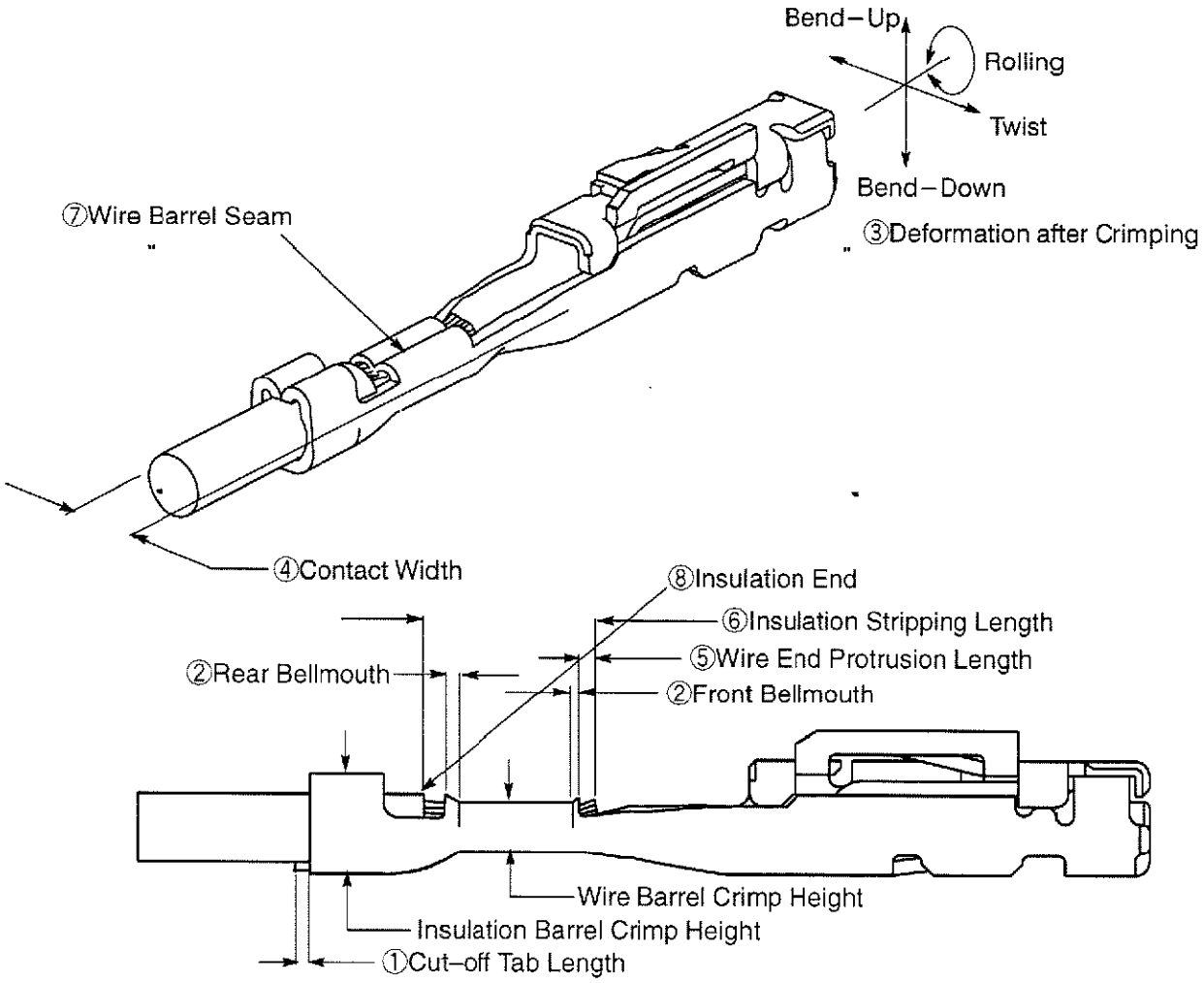

Fig.1

4. Crimping Condition

4.1 Applicator Crimp

Check Items			AVSS/AVSSH/AESSX 0.3 CAVUS 0.22-0.5 CAVS 0.22-0.3 TWP 0.35	AVSS/CAVS/AVSSH/ AESSX 0.5 TWP 0.5	Remarks
1	Cut-off Tab Length		0.1-0.5mm		Fig.1-①
2	Bellmouth	Front	0.2mm Max.		Fig.1-②
		Rear	0.1-0.4mm		
3	Deformation after Crimping	Bend	-1° , + 2°Max.		Fig.1-③
		Twist	±4°Max.		
		Rolling	±10°Max.		
4	Contact Width after Crimping		1.6mm Max.	1.8mm Max.	Fig.1-④
5	Wire End Protrusion Length		0-1mm		Fig.1-⑤
6	Insulation Stripping Length		3.0-3.5mm (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

4.2 Hand Tool Crimp

Check Item			AVSS/CAVS 0.3 AVSSH/AESSX 0.3 CAVUS 0.3-0.5	AVSS/CAVS/ AVSSH/AESSX 0.5	Remarks
1	Cut-off Tab Length		0.1-0.5mm		Fig.1-①
2	Bellmouth	Front	0.2mm Max.		Fig.1-②
		Rear	0.1-0.4mm		
3	Deformation after Crimping	Bend	±4°Max.		Fig.1-③
		Twist	±4°Max.		
		Rolling	±10°Max.		
4	Contact Width after Crimping(1)		1.6mm Max.	1.8mm Max.	Fig.1-④
5	Wire End Protrusion Length		0-1mm		Fig.1-⑤
6	Insulation Stripping Length		3.0-3.5mm (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

NOTE (1); Dimensions after crimping vary by skill of operators.
Make sure that flashes on the bottom of wire barrel are 0.25 mm max, and the contacts can be inserted into housing smoothly.

5. Crimp Data

5.1 Applicator Crimp

Contact Part Number (Strip Form)	Wire Size (Nominal)	Applicator Part Number	Wire Barrel Crimp			Insulation Barrel Crimp			Crimp Tensile Strength (N)
			Width(2) (mm)	Height(1) (mm)	Disk Ltr.	Width(2) (mm)	Height (mm)	Disk Ltr.	
1123343-1 1123343-2	0.22	937767-2	1.4 " F "	0.84	C	1.4 " F "	See Para. 6		39 Min. (3)
	0.3 0.3f			0.96	B				70 Min. (3)
	0.5 0.5f			1.06	A				90 Min.
	TWP 0.35			0.76	C				70 Min. (3)
	TWP 0.5			0.91	B				90 Min.

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.
(3); Crimp Tensile Strength of 0.22-0.35 wire includes the wire grip of insulation barrel

5.2 Hand Tool Crimp

Contact Part Number (Loose Piece)	Wire Size (Nominal)	Hand Tool Part Number	Insulation Diameter (mm)	Crimp Symbol		Wire Barrel (1) Crimp Height (mm)	Crimp Tensile Strength (N)
				Wire	Insulation		
1318143-1 1318143-2	0.3 0.3f	1276652-1 1463260-1(3)	1.1-1.7	20-22	INS	0.84-1.00	50 Min. (2)
	0.5 0.5f						63 Min.

NOTE
(1); This tool is for maintenance. The different dimension may be caused according to the ability of operator. Except for the purpose above, you should use the applicator.
(2); Crimp Tensile Strength of 0.3 wire includes the wire grip of insulation barrel crimp.
(3); Common hand tool for receptacle and tab.

6. Insulation Barrel Crimp Data

Contact Part Number (Strip Form)	Wire Size (Nominal)	AVSSH/AVSS		CAVUS		CAVS		AESSX		TWP	
		Height (mm)	Disk Ltr. (Ref.)	Height (mm)	Disk Ltr. (Ref.)	Height (mm)	Disk Ltr. (Ref.)	Height (mm)	Disk Ltr. (Ref.)	Height (mm)	Disk Ltr. (Ref.)
1123343-1 1123343-2	0.22	-	-	1.63(1)	4	-		1.75(1)	3	-	-
	0.3 0.3f	1.85(1)	4	1.75(1)	5	1.85(1)	4	1.85(1)	4	-	-
	0.35	-	-	-	-	-	-	-	-	1.87(1)	4
	0.5 0.5f	1.85(2)	4	1.85(2)	4	1.85(2)	4	1.85(2)	4	2.00(2)	3

NOTE
(1); Insulation Barrel Crimp Height to be within ±0.1mm.
(2); Insulation Barrel Crimp Height to be within +0.13/-0.10 mm.

7. Applicable Wire Data

Wire Size (Nominal)	Number /Diameter (mm) of Conductor	Calculated Cross sectional Area (mm^2)	Insulation Diameter (mm)									
			AVSSH /AVSS		CAVUS		CAVS		AESSX		TWP	
			STD.	Max.	STD.	Max.	STD.	Max.	STD.	Max.	STD.	Max.
0.22	7/Compressed	0.2199	-	-	0.95	1.05	1.25	1.35	-	-	-	-
0.3	7/0.26	0.3716	1.4	1.5	1.1	1.2	1.4	1.5	-	-	-	-
0.3f	19/0.16	0.3821	1.4	1.5	-	-	1.4	1.5	1.4	1.5	-	-
0.35	7/0.26	0.3716	-	-	-	-	-	-	-	-	1.55	1.63
0.5	7/0.32	0.5629	1.6	1.7	1.3	1.4	1.6	1.7	-	-	-	-
	7/0.31	0.5283	-	-	-	-	-	-	-	-	1.72	1.80
0.5f	19/0.19	0.5387	-	-	-	-	-	-	1.6	1.7	-	-