

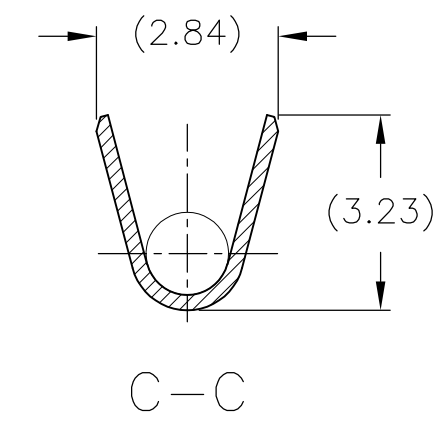
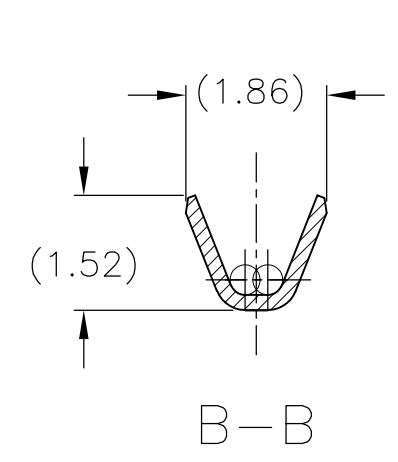
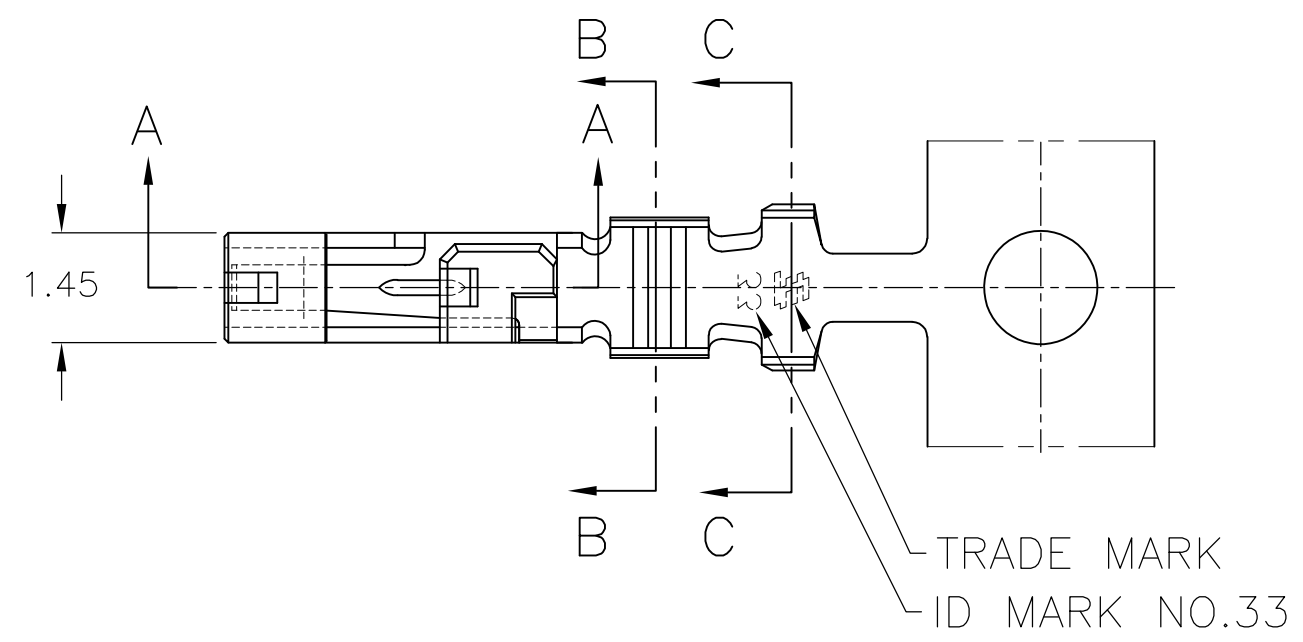
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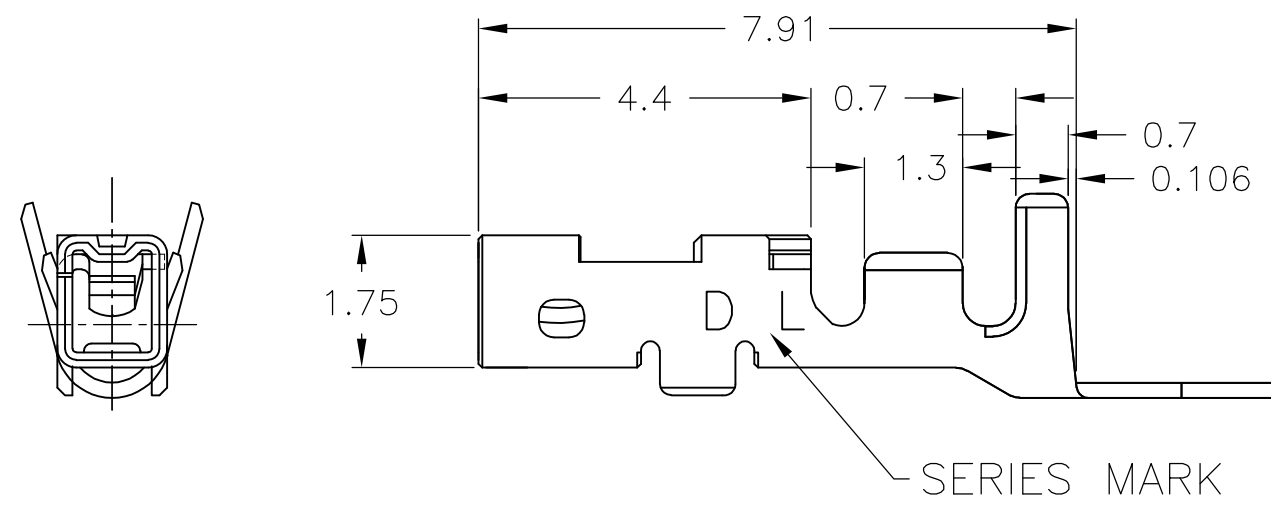
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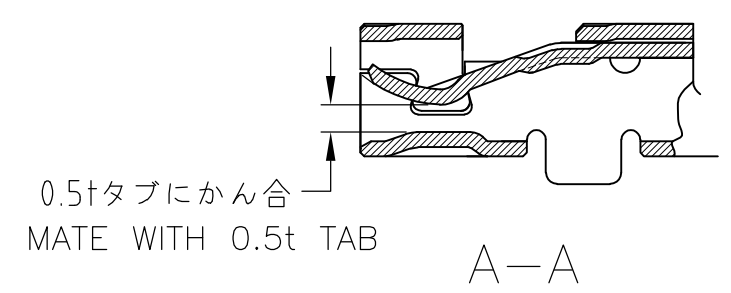
LOC	DIST	REVISIONS			
		P	LTR	DESCRIPTION	DATE
J			C	REVISED ECR-10-016584	10AUG2010



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1. APPLICATION REC-HSG IS APPLIED TO THE PRODUCT OF 2.5mm PITCH OR MORE OF DYNAMIC D1000 SERIES. 2.0mm PITCH CANNOT BE USED.



AWG#28~#22 0.08~0.38mm ²	φ1.08~φ1.9	PRE-TIN COPPER ALLOY 錫めっき済銅合金	1871304-1
WIRE RANGE 導体断面積	INSULATION DIA 被覆外径	MATERIAL 材料	PART NO. 型番

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN T.KUDO	13MAY2005	Tyco Electronics Corporation Kawasaki, Japan	
DIMENSIONS: 単位: 耗 mm		CHK D.MITSUGI	13MAY2005		
TOLERANCES UNLESS OTHERWISE SPECIFIED: 一般公差		APVD D.MITSUGI	13MAY2005	NAME 名称	
0 PLC ± 0.3 1 PLC ± 2 PXC ± 3 PLC ± 4 PLC ± ANGLES ± 3deg		PRODUCT SPEC 製品規格	108-78298	DYNAMIC D1000 SERIES REC CONTACT L TYPE TIN PLATE	
MATERIAL 材料		APPLICATION SPEC 取付適用規格	114-5377	SIZE A3	CAGE CODE 00779
FINISH 仕上		WEIGHT		DRAWING NO 番号	1871304
CUSTOMER DRAWING		SCALE 尺度 10:1		SHEET 1 OF 1	REV C

Crimping requirements for DYNAMIC 1000 Series contacts

1. SCOPE

This Application specification covers the crimping requirements for DYNAMIC 1000 Series contacts

2. APPLICABLE PRODUCT PART NUMBER

See Fig.1.

Contact Type	Size	Contact Part number L/P: Loose Piece		Plating Finish	Wire Size (AWG# REF) [mm2]	Insulation Diameter [mm]
Receptacle Contact	S	1827569-2/ *- 2367817-1 【b】	: Reel	Gold Plating	0.05～0.10 (#30～#28)	φ 0.60～φ 1.20
		1827586-2/ *-2367818-1 【b】	: L/P			
	M	1827570-2/ *-2367817-2 【b】	: Reel	Gold Plating	0.08～0.37 (#28～#22)	φ 1.08～φ 1.60
		1827587-2/ *-2367818-2 【b】	: L/P			
		1939991-2	: Reel	Gold 0.76Plating		
		1939992-2	: L/P			
		1871303-1	: Reel	Tin Plating		
		1871743-1	: L/P			
	L 【a】	1827571-2	: Reel	Gold Plating	0.08～0.37 (#28～#22)	φ 1.08～φ 1.90
		1827588-2	: L/P			
		1871304-1	: Reel	Tin Plating		
		1871744-1	: L/P			
	2L 【a】	1827572-2	: Reel	Gold Plating	0.34～0.87 (#22～#18)	φ 1.40～φ 2.20
		1827589-2	: L/P			
		1871731-1	: Reel	Tin Plating		
		1871745-1	: L/P			
	S	1903111-2/ *-2367819-1 【b】	: Reel	Gold Plating	0.05～0.10 (#30～#28)	φ 0.60～φ 1.20
		1903115-2/ *-2367820-1 【b】	: L/P			
	M	1903112-2/ *-2367819-2 【b】	: Reel	Gold Plating	0.08～0.37 (#28～#22)	φ 1.08～φ 1.60
		1903116-2/ *-2367820-2 【b】	: L/P			
		1903120-1	: Reel	Tin Plating		
		1903124-1	: L/P			
	L 【a】	1903113-2	: Reel	Gold Plating	0.08～0.37 (#28～#22)	φ 1.08～φ 1.90
		1903117-2	: L/P			
		1903121-1	: Reel	Tin Plating		
		1903125-1	: L/P			
	2L 【a】	1903114-2	: Reel	Gold Plating	0.34～0.87 (#22～#18)	φ 1.40～φ 2.20
		1903118-2	: L/P			
		1903122-1	: Reel	Tin Plating		
		1903126-1	: L/P			

Fig.1

[a]. L and 2L size are not applicable for D1100 (2.0mm Pitch) housings.

[b]. D1000 Slim Contact. It is applicable for D1000 slim housings.

3. Crimping REQUIREMENTS

See Fig.2 and Fig.3

NO.	Check Item	Specified Requirements	NO.	Check Item	Specified Requirements
①	Wire Stripping Length	2mm±0.3	⑥	Twisting	3° Max
②	Cut-Off Tab Length	0.25mm Max	⑦	Rolling	5° Max
③	Rear Bell mouth Length	0.1~0.3mm	⑧	Wire-End Protrusion Length	0.1~0.65mm
④	Bend-Up	3° Max	⑨ 【c】	Insulation Barrel Width	See Fig.4, 5
⑤	Bend-Down	3° Max	⑩ 【c】	Insulation Barrel Height	See Fig.4, 5

【c】. Insulation barrel crimping dimension ⑨ and ⑩ should be controlled under Fig.5 and Fig.6 not to interfere housings.

Fig 2

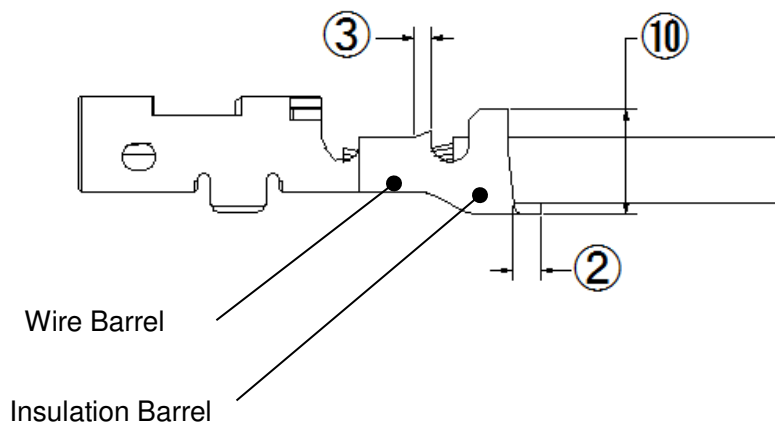
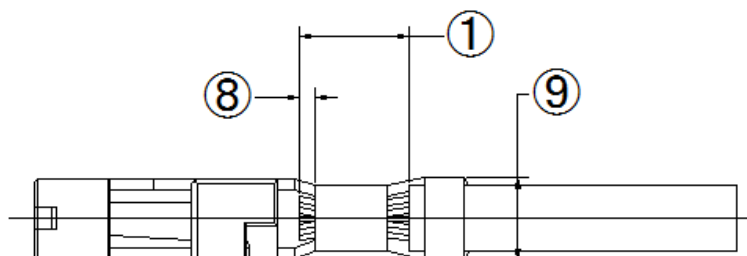


Fig 3

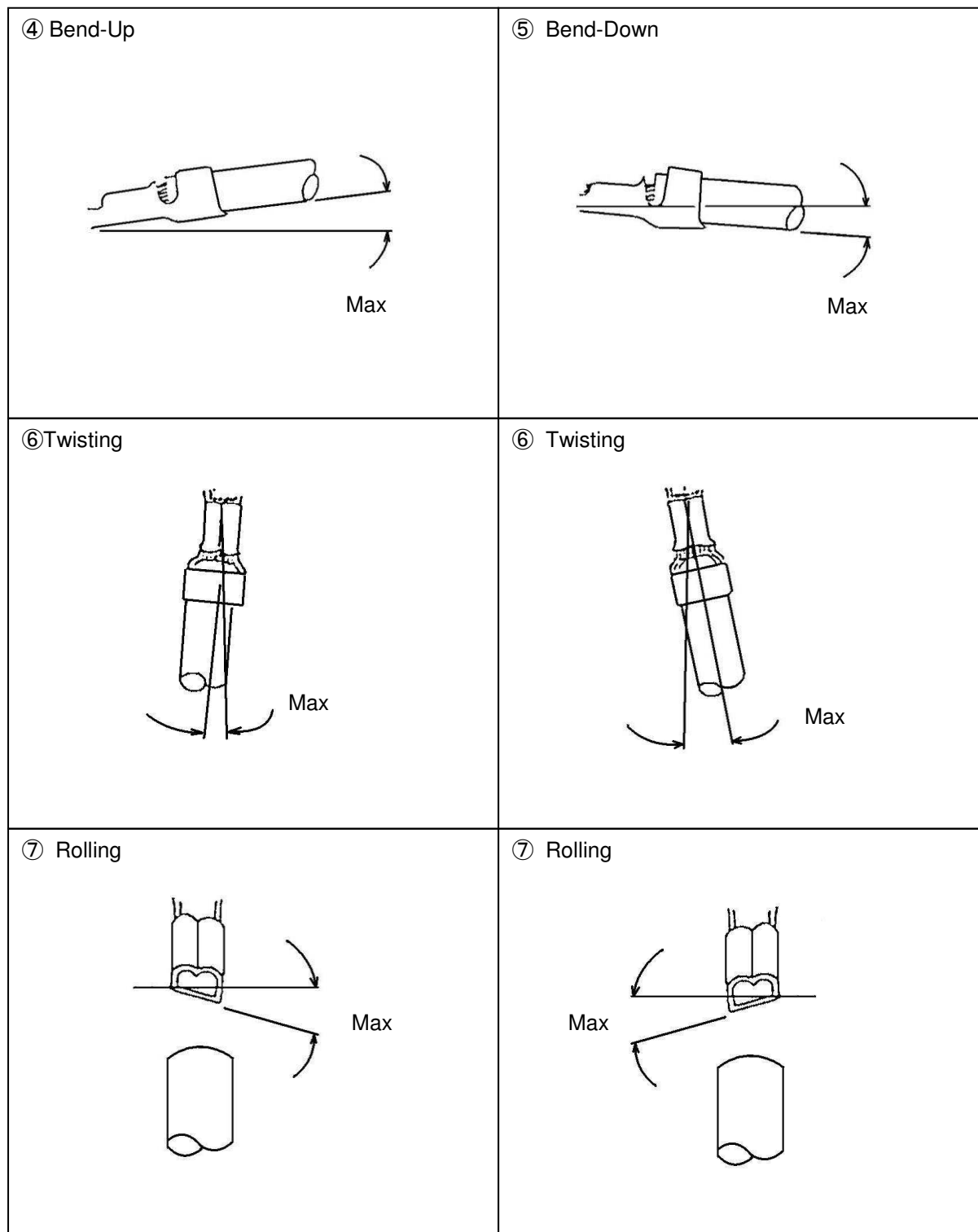


Fig.4

4. CRIMPING DATA

4.1 Applicator

See Fig.5

Reel Contact Part No		Applicator Number	Wire Size		Insulation Stripping Length [mm]	Wire Crimp		Insulation		Finished Insulation Diameter [mm]	Crimp Tensile Strength [Kg MIN]
			No. of Con-ductor 【e】	Cross Section [mm ²] (AWG) 【f】		Width [mm]	Crimp Height [mm]	⑨ Barrel Width [mm]	⑩ Crimp Height [mm]		
D1000 contact 【g】											
S	1827569-2 1903111-2	2151110-1	1	0.05~ 0.06(#30)	2.0±0.3	0.90 (REF)	0.54±0.03	1.5MAX “ F ”	1.4~ 1.8MAX	φ0.60~ φ1.20	0.5
			1	0.08~ 0.10(#28)			0.57±0.03				1.0
M	1827570-2 1871303-1 1903112-2 1903120-1 1939991-2	2151082-1	1	0.08~ 0.10(#28)	2.0±0.3	1.16 (REF)	0.64±0.03	1.5MAX “ F ”	1.6~ 2.2MAX	φ1.08~ φ1.60	1.0
			1	0.12~ 0.15(#26)			0.67±0.03				2.0
			1	0.21~ 0.23(#24)			0.73±0.03				3.0
			1	0.34~ 0.37(#22)			0.80±0.03				4.5
L 【d】	1827571-2 1871304-1 1903113-2 1903121-1	2151111-1	1	0.08 0.10(#28)	2.0±0.3	1.16 (REF)	0.64±0.03	2.1MAX “ F ”	1.6~ 2.4MAX	φ1.08~ φ1.90	1.0
			1	0.12~ 0.15(#26)			0.67±0.03				2.0
			1	0.21~ 0.23(#24)			0.73±0.03				3.0
			1	0.34~ 0.37(#22)			0.80±0.03				4.5
2L 【d】	1827572-2 1871731-1 1903114-2 1903122-1	2151083-1	1	0.34~ 0.37(#22)	2.0±0.3	1.40 (REF)	0.85±0.03	2.1MAX “ F ”	2.0~ 2.4MAX	φ1.40~ φ2.20	4.5
			1	0.51~ 0.53(#20)			1.00±0.03				6.5
			1	0.85~ 0.87(#18)			1.15±0.03				6.5
D1000 Slim contact 【g】											
S	*-2367817-1 *-2367819-1	2151110-1	1	0.05~ 0.06(#30)	2.0±0.3	0.90 (REF)	0.49-0.55	1.5MAX “ F ”	1.4~ 1.8MAX	φ0.60~ φ1.20	0.5
			1	0.08~ 0.10(#28)			0.52-0.57				1.0
M	*-2367817-2 *-2367819-2	2151082-1	1	0.08~ 0.10(#28)	2.0±0.3	1.16 (REF)	0.64±0.03	1.5MAX “ F ”	1.6~ 2.2MAX	φ1.08~ φ1.60	1.0
			1	0.12~ 0.15(#26)			0.67±0.03				2.0
			1	0.21~ 0.23(#24)			0.73±0.03				3.0
			1	0.34~ 0.37(#22)			0.80±0.03				4.5

See Fig.5

[d]. L and 2L size are not applicable for D1100 (2.0mm Pitch) housings

[e]. The contacts are not applicable for crimping multi wires. The strand diameter should be over ϕ 0.1mm.

[f]. Solid wire is not applied.

[g]. After crimped, check that the crimped sample can be inserted into the housing.

2 Hand Tool

See Fig.6

Loose Piece Contact Part No		Hand Tool Number	Wire Size		Insulation Stripping Length [mm]	Wire Crimp		Insulation		Finished Insulation Diameter [mm]	Crimp Tensile Strength [Kg MIN]
			No. of Conductor 【i】	Cross Section [mm ²] (AWG) 【j】		Width [mm]	Crimp Height [mm]	⑨ Barrel Width [mm]	⑩ Crimp Height [mm]		
D1000 contact 【I】											
S	1827586-2 1903115-2	2119144-1	1	0.05~ 0.06(#30)	2.0±0.3	0.90 (REF)	0.49~0.59	1.5MAX “ F ”	1.3(REF)	φ0.60~ φ1.00	0.5
			1	0.08~ 0.10(#28)			0.52~0.62		1.5(REF)	φ0.80~ φ1.20	1.0
M	1827587-2 1871743-1 1903116-2 1903124-1 1939992-2	2119141-1	1	0.08~ 0.10(#28)	2.0±0.3	1.16 (REF)	0.59~0.69	1.5MAX “ F ”	1.95(REF)	φ1.08~ φ1.40	1.0
			1	0.12~ 0.15(#26)			0.59~0.69				2.0
			1	0.21~ 0.23(#24)			0.69~0.79		2.1(REF)	φ1.20~ φ1.60	3.0
			1	0.34~ 0.37(#22)			0.69~0.79				4.5
L 【h】	1827588-2 1871744-1 1903117-2 1903125-1	2119143-1	1	0.08~ 0.10(#28)	2.0±0.3	1.16 (REF)	0.59~0.69	2.1MAX “ F ”	2.05(REF)	φ1.08~ φ1.40	1.0
			1	0.12~ 0.15(#26)			0.59~0.69		2.2(REF)	φ1.20~ φ1.90	2.0
			1	0.21~ 0.23(#24)			0.69~0.79				3.0
			1	0.34~ 0.37(#22)			0.69~0.79				4.5
2L 【h】	1827589-2 1871745-1 1903118-2 1903126-1	2119142-1	1	0.34~ 0.37(#22)	2.0±0.3	1.40 (REF)	0.80~0.90	2.1MAX “ F ”	2.1(REF)	φ1.40~ φ2.00	4.5
			1	0.51~ 0.53(#20)			0.80~0.90				6.5
			1	0.85~ 0.87(#18)			1.10~1.20		2.4(REF)	φ1.80~ φ2.20	6.5
D1000 Slim contact 【I】											
S	*-2367818-1 *-2367820-1	2381707-2 【m】	1	0.05~ 0.06(#30)	2.0±0.3	0.90 (REF)	0.49-0.55	1.5MAX “ F ”	1.3(REF)	φ0.60~ φ1.00	0.5
		2381707-2 【n】	1	0.08~ 0.10(#28)			0.52-0.57		1.5(REF)	φ0.80~ φ1.20	1.0
M	*-2367818-2 *-2367820-2	2381748-1 (2119141-1 with 2381710-1) 【k】	1	0.08~ 0.10(#28)	2.0±0.3	1.16 (REF)	0.59~0.69	1.5MAX “ F ”	1.95(REF)	φ1.08~ φ1.40	1.0
			1	0.12~ 0.15(#26)			0.59~0.69				2.0
			1	0.21~ 0.23(#24)			0.69~0.79		2.1(REF)	φ1.20~ φ1.60	3.0
			1	0.34~ 0.37(#22)			0.69~0.79				4.5

Fig.6

【h】. L and 2L size are not applicable for D1100 (2.0mm Pitch) housings

【i】. The contacts are not applicable for crimping multi wires. The strand diameter should be over φ0.1mm.

【j】. Solid wire is not applied.

【k】. Apply to use D1000 Hand tool with 2381710-1 by exchange flip locator

【l】. After crimped, check that the crimped sample can be inserted into the housing.

【m】. 2119144-1 with 2381710-1 can be used for crimping if it can be crimped with crimp height 0.49-0.55 mm

【n】. 2119144-1 with 2381710-1 can be used for crimping if it can be crimped with crimp height 0.52-0.57 mm