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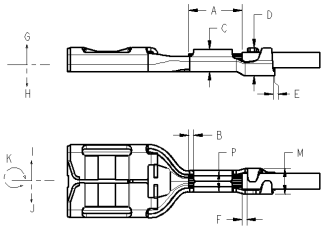
PARAMETRES DE SERTISSAGE
CRIMPING PARAMETERS

SERTISSAGE DU CONDUCTEUR *CONDUCTOR CRIMPING*			DEVELOPPE : 5.8 mm *LAYOUT* EPAISSEUR METAL : 0.4 mm *METAL THICKNESS*		FRETTAGE DE L'ISOLANT *INSULATION CRIMPING*		DEVELOPPE : 7.2 mm *LAYOUT* EPAISSEUR METAL : 0.4 mm *METAL THICKNESS*		
SECTION (mm2) CATALOGUE	SECTION (mm2) REELLE *REAL*	LARGEUR POINCON *CRIMPER WIDTH*	HAUTEUR SERTISSAGE *CRIMPED HEIGHT* C ±0.05	RESISTANCE EN TRACTION *PULLING FORCE* (N)	DEFINITION DU FIL *WIRE DEFEINITION*	Ø DU FIL *WIRE Ø*	SURFACE A FRETTER *AREA TO CRIMP*	LARGEUR POINCON *CRIMPER WIDTH*	HAUTEUR SERTISSAGE *CRIMPED HEIGHT* D ±0.2
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



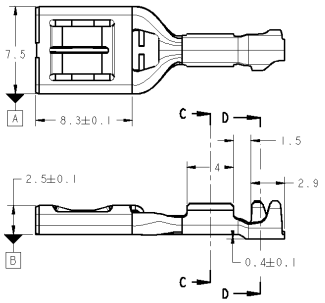
TENUE AU PLIAGE DU SERTISSAGE ISOLANT
BENDING RESISTANCE OF THE INSULATION CRIMPING

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 DEGRES ON AXIS I,J,H & G
(test carried out at a minimum distance of 60 mm from the insulation barrel)
INSULATION MAY NOT HAVE SLIPPED OUT OF INSULATION BARREL

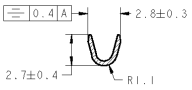
SOC	STAT
F	00

REVISIONS

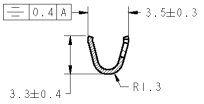
F	LTR	DESCRIPTION *NOTIFICATION*	DATE	DWN	APVD
	0	FIRST ISSUE	10SEP12002	CAH	JBr
	A	Twin crimping parameter added	07-aug-04	PCa	JBr

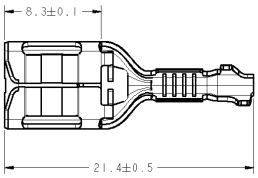


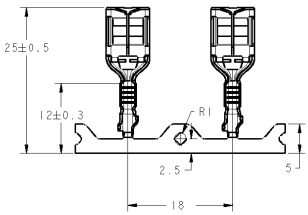
COUPE **C-C**



COUPE **D-D**

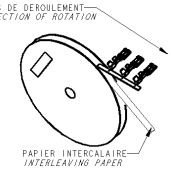


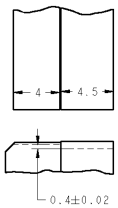




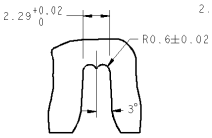
CONDITIONNEMENT
PACKAGING

CONDITIONNEMENT GALETTE CARTON
PANCAKE REEL PACKAGING

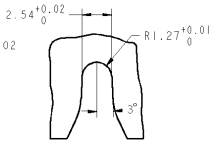


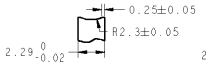


POINCON CONDUCTEUR
CONDUCTOR PUNCH

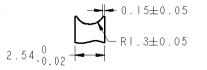


POINCON ISOLANT
INSULATION PUNCH





ENCLUME CONDUCTEUR
CONDUCTOR ANVIL



ENCLUME ISOLANT
INSULATION ANVIL

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

NOTICE DE CONTROLE
(CONTROLE 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/mm2	PRE ETAME *PRE TINNED* Sn 1.5 to 3 µm

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OF TYCO ELECTRONICS CORPORATION.

DIMENSIONS: mm

MATERIAL AND FINISH: VOIR TABLEAU / SEE TABLE

DEFINITION: VOIR TABLEAU / SEE TABLE

UNLESS OTHERWISE SPECIFIED TOLERANCES SHOULD BE VALIDATED NON-DEDICATED TOOLS ARE:
1 PLC INCC ±0.2
2 PLC INCC ±-
3 PLC INCC ±-
4 PLC INCC ±-
ANGLES INCC ±-
MATERIAL THICKNESS ±-

DWN ISSUE: 10SEP12002 G. GINET
CHK INDUS: 10SEP12002 J. BARRIER
APVD CUSTOMER: 10SEP12002 J. BARRIER

PRODUCT SPEC
SPEC PRODUCT: 108-15076
APPLICATION SPEC
SPEC APPLICATION: 114-15095

WEIGHT
MASSE APPROX. 0.0007 kg

TYCO ELECTRONICS France SAS
BP 39, 95301 CERGY-PONTOISE Cedex

NAME
TITRE: CLIP 6.35 NG1 0.35 à 0.75mm2
6.35 NG1 RECEPTACLE 0.35 to 0.75mm2

SIZE FORMAT: A | CODE CODE: 00779 | DRAWING NO DESSIN: 1544615 | RESTRICTED TO REGIONS A: -

CUSTOMER DRAWING / PLAN CLIENT | ENVIRONMENT MEA REFERENCE | SCALE ECHELLE 6:1 | SHEET FEUILLE 1 | OF DE 1 | REV A

AMP 4895 REV 31MAR2060

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