

Crimping Ring Tongue Terminals

1. SCOPE

This specification covers the crimp requirements of Ring Tongue Terminal 626034 , all terminal have insulation support .

2. NOMENCLATURE

Figure 1 illustrates the various features defined in the following paragraphs .

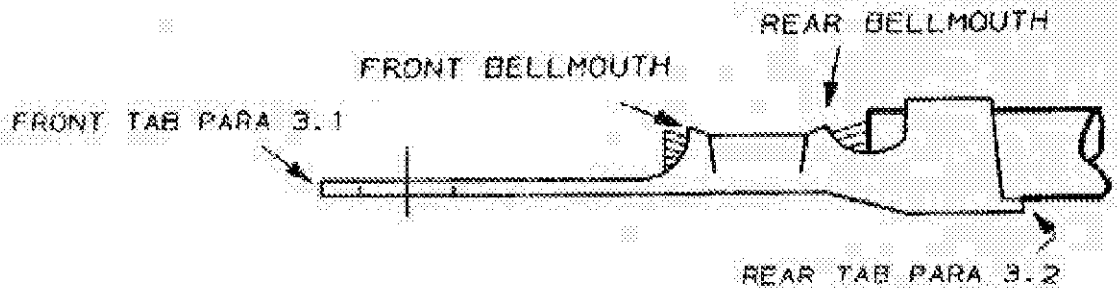


Figure 1

3. CRIMP REQUIREMENTS

3.1 Tab on front of terminal shall be 0.40mm MAXIMUM.

3.2 Tab on back of terminal shall be 0.75mm MAXIMUM.

3.3 Crimp heights and crimp widths of the wire barrel for are shown in the following tables :

Terminal	Wire Size mm ²	Wire Crimp Height ± .002" (0,05)		Wire Crimp Width "F" Type	Ins. Crimp Width	
		Imperial	Metric		Normal Cable "F" Type	Thin Wall Cable Over Lap Crimp
626034	1.00	.081"	2.05	.130" (3.30)	.160" (4.06)	.160" (4.06)
	1.50	.086"	2.18	.130" (3.30)	.160" (4.06)	.160" (4.06)
	2.00	.090"	2.29	.130" (3.30)	.160" (4.06)	.160" (4.06)
	2.50	.095"	2.41	.130" (3.30)	.160" (4.06)	.160" (4.06)

In accordance with log sheets P/N's 571921 -0 and 571921-5

3.4 Bellmouth and conductor location .

3.4.1 Front bellmouth shall not exceed 0,75mm , rear bellmouth length shall be 0,50 to 1,50mm .

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- 3.5 Wire shall lay flat and must extend through the wire barrel by no more than 1,50mm
MAXIMUM OVERHANG.
- 3.6 Both insulation and conductor shall be visible between the insulation barrel and the wire barrel
care shall be taken not to allow insulation to be crimped in the wire barrel.
- 3.7 Wire barrel flash shall not exceed 0,13mm.
- 3.8 Wire barrel seam shall be completely closed and there shall be no evidence of loose wire
strands or wire strands visible in the seam.

4. WIRE PREPARATION

4.1 Strip Length

Note : Wire barrels differ from corporate standards .

Terminal	Wire Barrel Length	Wire Strip Length
626034	4,06mm	4,82 ~ 5,58mm

4.2 Workmanship

Reasonable care shall be taken not to nick , scrape or cut any strands or the solid wire during
the stripping operation . Filaments of insulation material remaining after stripping should be
avoided and shall never extend among the bare conductors .

5. ALIGNMENT

A Straightness

- 5.1 The contact , including the cut off tab and burr shall not be bent above or below the
datum line more than the amount shown in Figure 2 .

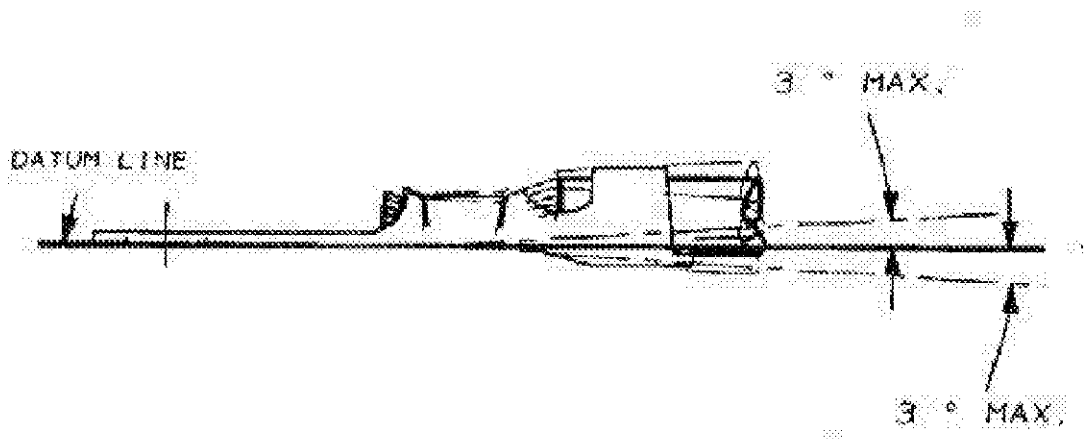


Figure 2

5.2 The side to side bending of the contact shall not exceed the limits specified in Figure 3 .

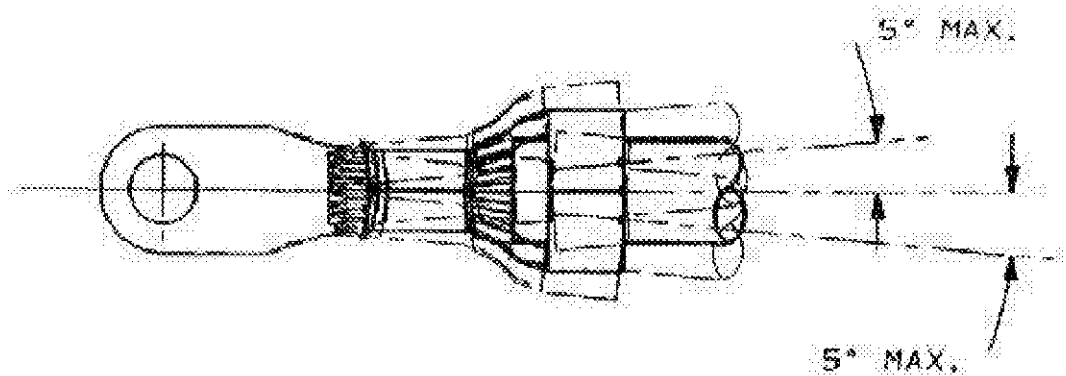


Figure 3

B Twist or Roll

5.3 Twist or roll of the crimped contact shall not exceed the limits specified in Figure 4 .

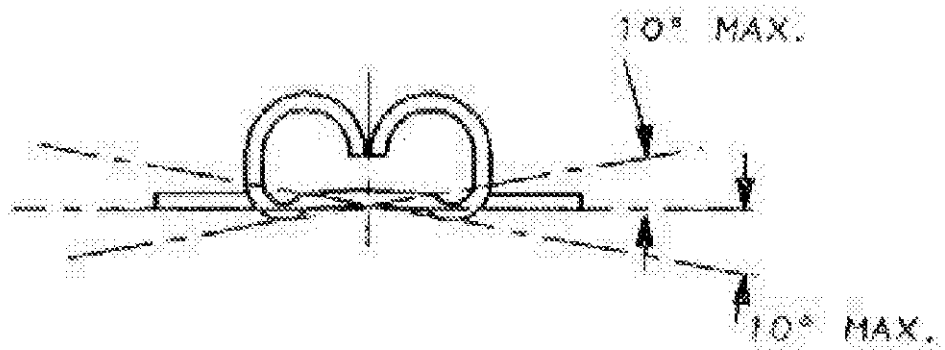


Figure 4

6. TENSILES

6.1 Tensiles to be in line with spec 108-37017.

Revision Record		
Revision	Date	Description
O	16-Feb-2001	Released