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REVISIONS					
P	LTR	DESCRIPTION	DATE	DWN	APVD
	E	DRAWING FORMAT UPDATE + PACKAGING NOTE	12SEP2013	CPo	JDr

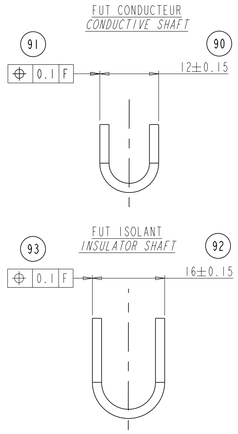
PARAMETRES DE SERTISSAGE / *CRIMPING PARAMETERS*

PARAMETRES DE SERTISSAGE RESERVES POUR CETTE APPLICATION. VALEURS OBTENUES AVEC LES OUTILLAGES TYCO
LES PARAMETRES DE FRETTAGE OUTRE LES DIMENSION MAXI SONT DONNES A TITRE INDICATIF
CRIMPING PARAMETERS FOR THIS APPLICATION ONLY. VALUES OBTAINED WITH TYCO TOOLS
HOOPING PARAMETERS EXCEPT MAX DIMENSION ARE GIVEN FOR INFORMATION

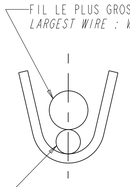
SERTISSAGE FUT CONDUCTEUR *CONDUCTIVE SHAFT CRIMPING*		LONGUEUR D'AILE : 40 mm *WING HEIGHT : 40 mm*					FRETTAGE DE L'ISOLANT *INSULATOR BINDING*		
SECTION/ *AREA*	SECTION REELLE /*REAL AREA* mm²	LARGEUR/ *WIDTH* P±0.2	HAUTEUR/ *HEIGHT* C±0.15	TRACTION (daN) FIL 1 *WIREn°1*	FIL 2 *WIREn°2*	2 FILS *2 WIRES*	Ø ISOLANT *INSULATOR Ø*	LARGEUR MAX./ *MAX. WIDTH* M	HAUTEUR MAX./ *MAX. HEIGTH* D
20 + 16	32.82 (18.38+15.44)	12.51	7.9				7.6 + 7.1	17	15.4
20 + 20	36.76 (18.38+18.38)	12.55	8.07				7.6 + 7.6	17.1	15.6
25 + 10	33.26 (23.41+9.84)	12.5	7.86				8.3 + 6.1	17	15.4
25 + 16	38.85 (23.41+15.44)	12.57	8.2				8.3 + 7.1	17.1	15.7
25 + 20	41.8 (23.41+18.38)	12.61	8.37				8.3 + 7.6	17.1	15.9
25 + 25	46.83 (23.41+23.41)	12.68	8.67				8.3 + 8.3	17.2	16.2
40	37.11	12.55	8.09				11.1	17.1	15.6
40 + 10	46.95 (37.11+9.84)	8.68	8.68				11.1 + 6.1	17.2	16.2
40 + 16	52.55 (37.11+15.44)	12.75	9.01				11.1 + 7.1	17.3	16.6
40 + 20	55.49 (37.11+18.38)	12.79	9.18				11.1 + 7.6	17.3	16.7
40 + 25	60.52 (37.11+23.41)	12.85	9.48				11.1 + 8.3	17.4	17.1
60	59.38	12.84	9.41				14	17.3	17
* 25 + 16	39.96	12.6	8.2	220	310	320	10.64	16.7	17.05
* 35(1054x0.2)	33.1	12.4	7.45	350			10.2	17.1	15.6
* 35(273x0.4)	34.3	12.4	7.35	350			10	17.1	15.05
* 40(1140x0.2)	35.81	12.6	8	340			10.6	17.0	15.55
* 40(1140x0.2) +10(143x0.29)	49.33	12.6	8.6			380	10.6 + 5.7	17.3	16.3
* 60	59.38	12.9	9.4	400			13.90	17.1	17.4
* 70(2128x0.2)	66.85	12.7	8.85	250			13.2	17.5	16.85
* 70(336*0.5)	66	12.7	9	250			13.9	17.5	16.85

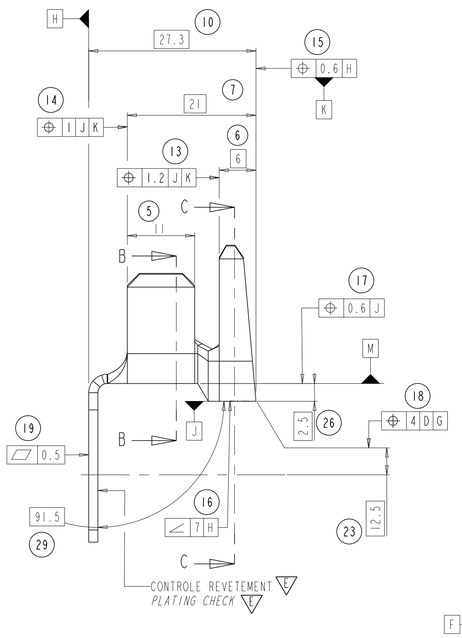
LES CONFIGURATIONS AVEC * SONT DES VALEURS VALIDEES PAR ESSAIS. VALEURS DONNEES A TITRE INDICATIF ET DOIVENT ETRE VALIDEES PAR LE CABLEUR. DESIGNATION: PAR EXEMPLE, *35(1054x0.2) SIGNIFIE: FIL DE 35mm² COMPOSE DE 1054 BRINS DE 0.2mm DE DIAMETRE.
*THE CONFIGURATIONS WITH * ARE VALIDATED BY TESTS. VALUES ARE GIVEN FOR INFORMATION AND MUST BE VALIDATED BY HARNESS MAKER*
NAMING: FOR INSTANCE, *35(1054x0.2) 1MEANS: 35mm² WIRE COMPOSED OF 1054 STRANDS WITH A DIAMETER OF 0.2mm.*

LARGEURS NATURELLES
NATIVE WIDTH

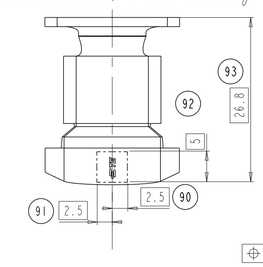


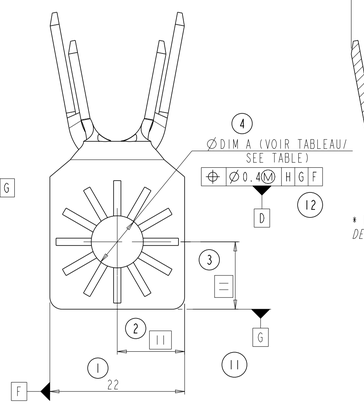
MARIAGE DE FILS
WIRES COMBINATION



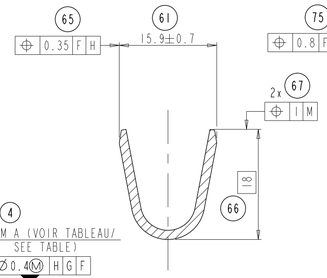


LOGO FOURNISSEUR , Ø 1.5 mm, PROFONDEUR 0.1 +0.1 0 mm
SUPPLIER'S LOGO, Ø 1.5 mm, DEPTH 0.1 +0.1 0 mm



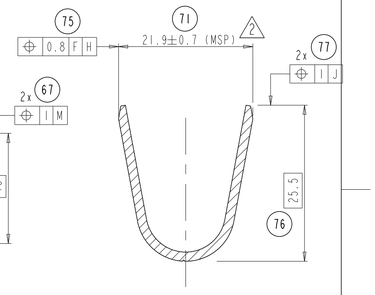


COUPE B-B
SECTION B-B

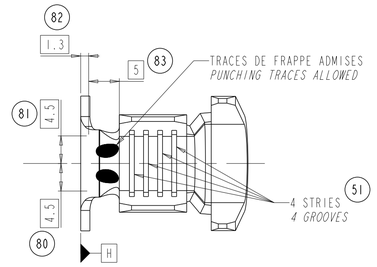


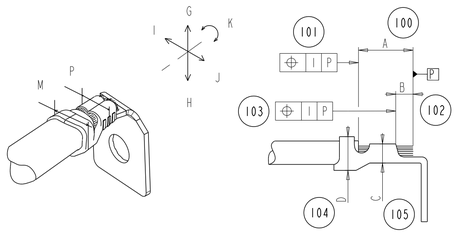
* DEVELOPPE : 40 mm
DEVELOPED : 40 mm

COUPE C-C
SECTION C-C



* DEVELOPPE : 56 mm
DEVELOPED : 56 mm

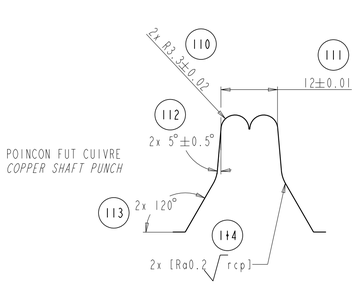




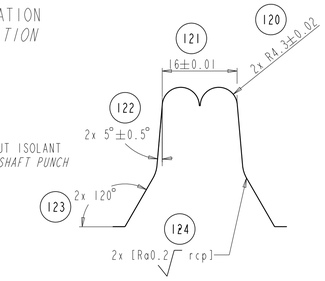
CARACTERISTIQUES A VERIFIER *DIMENSIONS TO CHECK*		VALEUR A MESURER *CHECKING VALUE*	REPERE *MARKER*
DEFORMATION APRES SERTISSAGE *DEFORMATION AFTER CRIMPING*	FLEXION VERS LE HAUT *UPPER FLEXION*	2° maxi	G
	FLEXION VERS LE BAS *DOWN FLEXION*	2° maxi	H
	TORSION / *TWISTING*	3° maxi	K
DEFORMATION SUIVANT L'AXE DE LA PIECE *PART'S AXIAL DEFORMATION*		2° maxi	I-J
LONGUEUR DE DENUDAGE / *LAYING BARE LENGTH*		15	A
DEPASSEMENT DU FIL / *WIRE'S STICK OUT*		2	B

TENUE DE L'ISOLANT : DOUBLE FLEXION A 90° SELON G-H ET I-J
INSULATOR MECHANICAL ABILITY : DOUBLE FLEXION AT 90° FOLLOWING G-H AND I-J

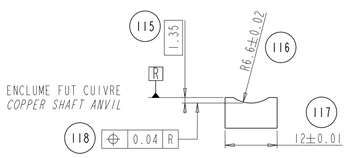
POUR INFORMATION
FOR INFORMATION



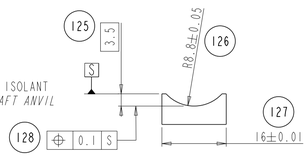
POINCON FUT CUIVRE
COPPER SHAFT PUNCH



POINCON FUT ISOLANT
INSULATOR SHAFT PUNCH



ENCLUME FUT CUIVRE
COPPER SHAFT ANVIL



ENCLUME FUT ISOLANT
INSULATOR SHAFT ANVIL

TRAITEMENT ENCLUMES : 52-54 Hrc
ANVIL'S TREATMENT : 52-54 Hrc

TRAITEMENT POINCONS : 56-58 Hrc
PUNCH'S TREATMENT : 56-58 Hrc

ETAT DE SURFACE SUR LES PARTIES ACTIVES DES OUTILS : POLIE MIROIR
SURFACE STATE ON WORKING TOOLS AREAS : MIRROR POLISH

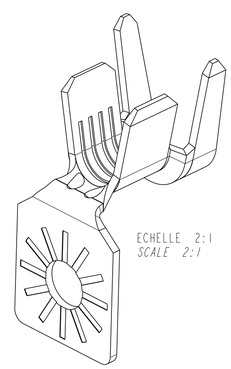
EPAISSEUR MAT. : 1.5±0.05 PROTECTION INCLUSE
MATERIAL THICKNESS : 1.5±0.05 MM, PLATING INCLUDED

NOTICE DE CONTROLE / *CONTROL NOTES*

- AU PIED A COULISSE OU AU PROJECTEUR DE PROFIL, VERIFIER LES COTES FIGURANT SUR LE DESSIN CI-DESSUS.
  CHECK ALL DIMENSIONS ON THIS DRAWING WITH SHADOW PROJECTOR OR SLIDE CALIPER.
- TOUTE COTE (MSP), FIGURANT SUR CE PLAN, NON RESPECTEE SUR UN LOT FERA L'OBJET D'UN REFUS PAR RAPPORT AU CONTRAT QUALITE COMPOSANT.
  ALL SCP (MSP) DIMENSION, INCLUDED ON THIS DRAWING, AND NOT RESPECTED IN ONE BATCH WILL RESULT IN A REFUSAL IN ACCORDANCE WITH THE QUALITY COMPOSANT AGREEMENT.
- CE PLAN DE CONTROLE ETANT EXTRAIT DU PLAN DE DEFINITION, ON FERA REFERENCE AU PLAN DE DEFINITION **1544368** EN CAS DE LITIGE.
  AS THIS CONTROL DRAWING IS EXTRACT FROM THE DEFINITION DRAWING, THE REFERENCE IN CASE OF LITIGATION WILL BE THE DRAWING NUMBER : **1544368**.

* COTE THEORIQUE AVANT FRAPPE DES CHANFREINS
** THEORICAL DIMENSION BEFORE CHAMFER PUNCHING*
( ) COTE DONNEE POUR INFORMATION
( ) INFORMATION DIMENSION
(MSP) COTE SUIVIE EN MSP
(MSP) DIMENSION FOLLOWED BY SPC

LES PIECES SONT MANIPULEES ET CONDITIONNEES EN VRAC. CE TYPE DE CONDITIONNEMENT PEUT AFFECTER DIMENSIONELLEMENT LE PRODUIT. TE N'EST PAS RESPONSABLE DE L'USAGE DE PIECES AFFECTEES.
PARTS ARE HANDLED AND PACKED AS BULK. THIS CONDITION CAN DIMENSIONALLY AFFECT THE PRODUCT. THE USE OF AFFECTED PARTS IS OUT OF TE RESPONSIBILITY



ECHELLE 2:1
SCALE 2:1

Ø A / Ø A	REF TE / *TE P/N*	REF PRONER COMATEL / *PRONER COMATEL P/N*	MASSE (g) / *WEIGTH (g)*
Ø8.5 mm	1544368-1	P40 100 94 8241	17.5
Ø6.5 mm	1544368-4	/	17.8

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: mm
TOLERANCES UNLESS OTHERWISE SPECIFIED: ±- ±0.2 ±- ±- ±- ANGLES ±2°
MATERIAL: CuZn 15
FINISH: POST ETAME / POST TIN PLATED

DWN F.SAPET 30MAR2006
CHK P.CHARLES 30MAR2006
APVD J.DAHER 30MAR2006
PRODUCT SPEC -
APPLICATION SPEC -
WEIGHT SEE TABLE

TE Connectivity

NAME: COSSE COUDEE A 90 DEG - GI3
TERMINAL BENT AT 90 DEG - GI3
-

SIZE A1 | CAGE CODE - | DRAWING NO C-1544368 | RESTRICTED TO -

Customer Drawing | SCALE 2:1 | SHEET 1 OF 1 | REV E

4805 (3/13)