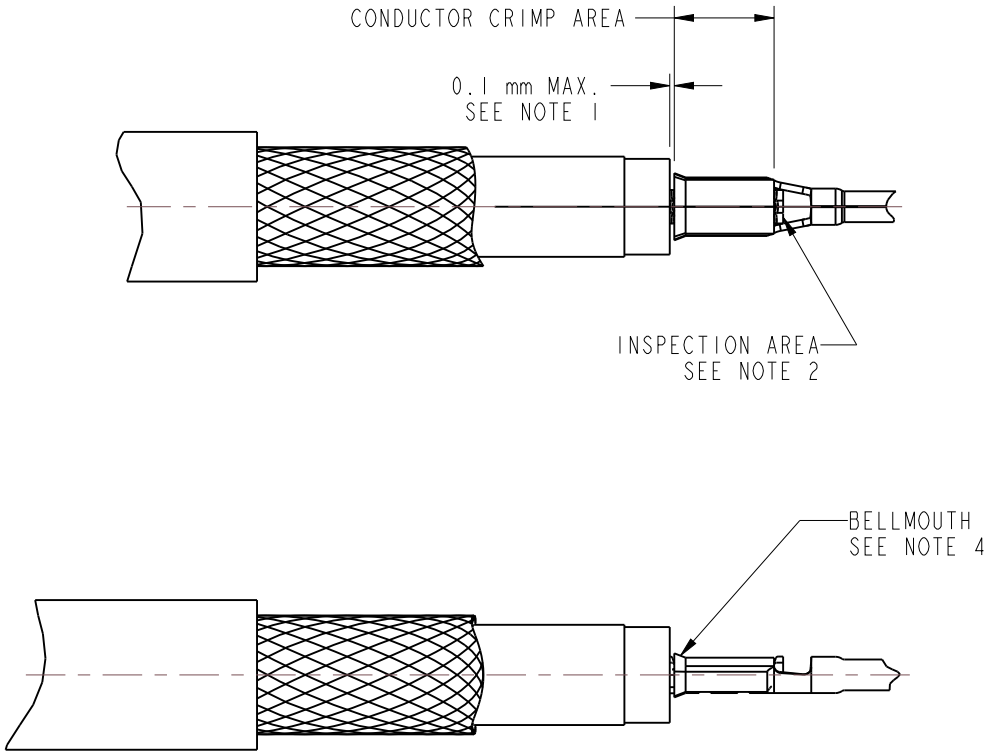


REVISIONS				
REV	DESCRIPTION	DATE	ECO	APPR
A	RELEASE TO MFG	07-Jan-22	15976	TD

SPECIFICATIONS FOR CRIMPING
STAMPED AND FORMED CONTACTS



	NAME	DATE		NAME	DATE
PROJ. ENG.	TANGOR.DENG	19-Mar-21	APPD. BY	SCOTT	11-Jan-22
CHK. BY	TANGOR.DENG	11-Jan-22	DATE ISSUED		

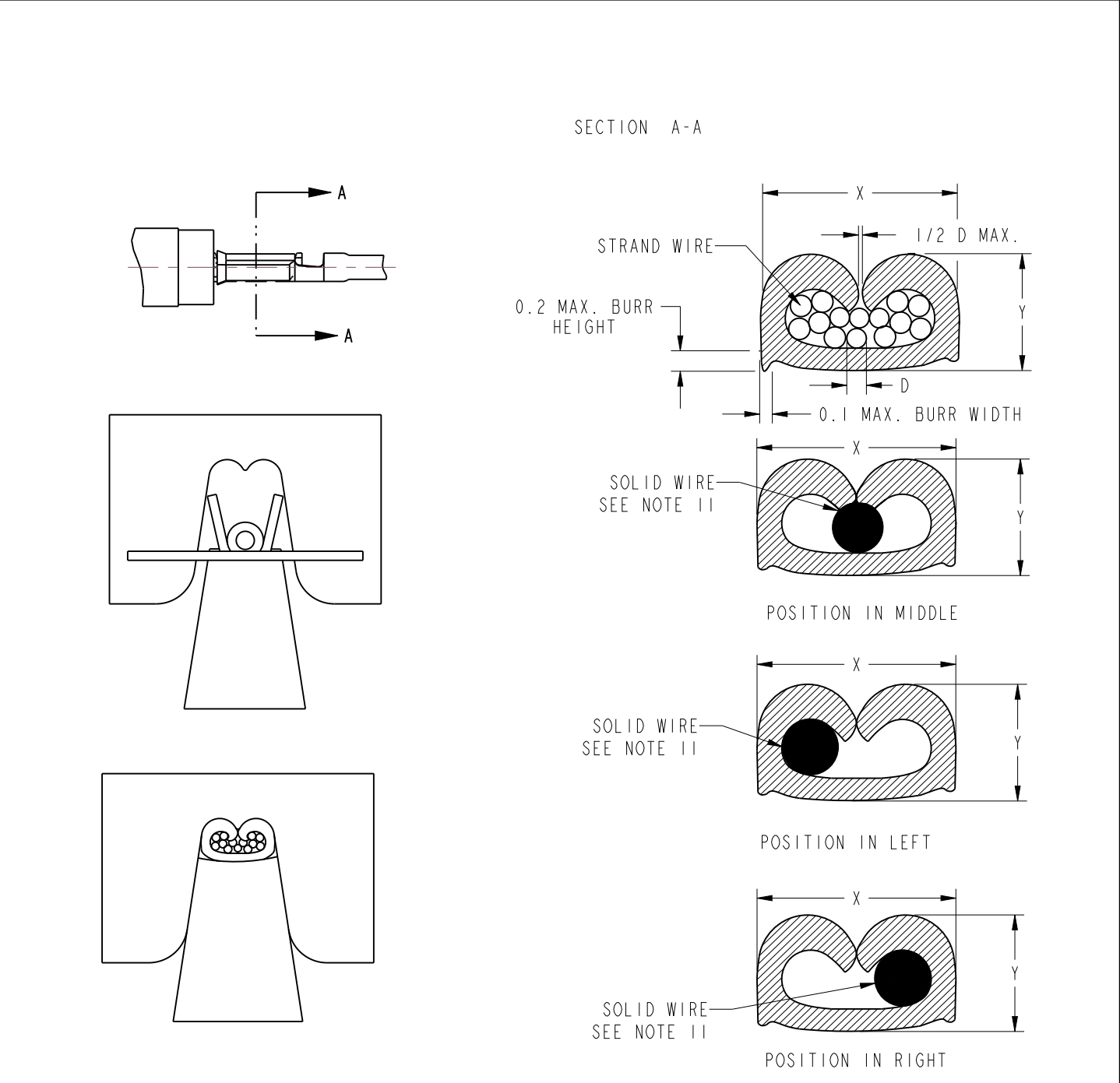
AMPHENOL CORPORATION DANBURY, CONN.					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE: FRACTIONS DECIMALS ANGLES ± 1/64 ± .005 ± 1°		CODE IDENT.	349-50950		REV A
		74868	SHEET 1 OF 6		
SCALE: NONE					

TARGETS FOR AN ACCEPTABLE CRIMP

- CONTACT TO BE FLUSH TO 0.1 MM FROM DIELECTRIC.
- CONDUCTOR TO EXTEND TO MIDDLE OF INSPECTON AREA. MINIMUM FLUSH TO CONDUCTOR CRIMP AREA.
- NO CONDUCTOR STRANDS BROKEN, FOLDED BACK INTO CONDUCTOR CRIMP AREA. OR NOT CAPTURED BY THE CONDUCTOR CRIMP TABS. IT IS PERMISSIBLE TO HAVE A SLIGHT GAP AT THE CRIMP SEAM PROVIDED IT DOES NOT EXCEED 1/2 OF THE DIAMETER OF A SINGLE STRAND PROVIDED THE CRIMP MEETS THE REQUIREMENTS OF NOTE 9.
(ON STRANDED CENTER CONDUCTOR CABLE)
- CRIMP CENTERED ON THE CONDUCTOR CRIMP AREA WITH CORRECT BELLMOUTH. BELLMOUTH AT EACH END OF THE CONDUCTOR CRIMP AREA. MINIMUM BELLMOUTH AT CONDUCTOR ENTRY END OF THE CONDUCTOR CRIMP AREA. BELLMOUTH HEIGHT AT THE CONDUCTOR ENTRY END IS 2x THE THICKNESS OF THE METAL.
- CRIMP INDENTATIONS UNIFORM.
- NO DEFORMATION OF CONTACT SUCH AS BANANA SHAPE AFTER CRIMPING.
- CONDUCTOR STRANDS NOT TWISTED, CUT OR MODIFIED TO FIT INTO THE CONTACT.
(ON STRANDED CENTER CONDUCTOR CABLE)
- CONDUCTOR STRANDS NOT TO FLARE OUT LARGER THAN THE OUTER DIAMETER OF THE CONTACT.
(ON STRANDED CENTER CONDUCTOR CABLE)
- CONTACT RETENTION TO BE 5 POUNDS (22.2 NEWTONS) MINIMUM.
- CRIMP THE CENTER CONTACT WITH CRIMPING DIES AS DESCRIBED, USING STANDARD APPLICATOR. CHECK THE CRIMPING HEIGHT Y AND THE CRIMPING WIDTH X OF THE CENTER CONTACT (SEE TABLE 12.1).
- SOLID WIRE IS ALLOWED TO POSITION IN LEFT, RIGHT OR MIDDLE OF THE CONTACT AS SHOWN AFTER CRIMPED. RETENTION FORCE IN ALL POSITIONS HAVE TO MEET MIN 5 LBS.

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		74868	SHEET 2 OF 6		
SCALE: NONE					

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FRACTIONS DECIMALS ANGLES		74868			
± 1/64 ± .005 ± 1°		SCALE: NONE	SHEET 3 OF 6		

12. CRIMPING SPECIFICATION: **

TABLE 12.1

CABLE GROUP	CABLE TYPES	X DIM (mm) CRIMP WIDTH	Y DIM (mm) CRIMP HEIGHT
C30	302LL-TFCXIM	1.29±0.03	0.79±0.03
	RTK-031-CCXIM	1.29±0.03	0.79±0.03
	LEONI-302XIM	1.29±0.03	0.79±0.03
C01	RG-174HT-TFCXIM, RG-AM200-TFCXIM	1±0.03	0.66±0.03
	1.5DS-QFB-TAXIM	1±0.03	0.67±0.03
	1.5DS-GXC-SPXIM	1±0.03	0.68±0.03
	LEONI-462XIM	1±0.03	0.66±0.03
	LEONI-462-2XIM	1±0.03	0.66±0.03

** DIMENSIONS NOTED ON TABLE 12.1 FOR CRIMP HEIGHT AND WIDTH MAY NEED TO BE ADJUSTED DEPENDING ON CENTER CONDUCTOR SIZE AND CONFIGURATION TO ACHIEVE THE 5 POUNDS (22.2 NEWTONS) CONTACT RETENTION AND ELECTRICAL SPECIFICATIONS.

13. CROSS-SECTION VIEW OF CABLE INNER CONDUCTOR CRIMP.

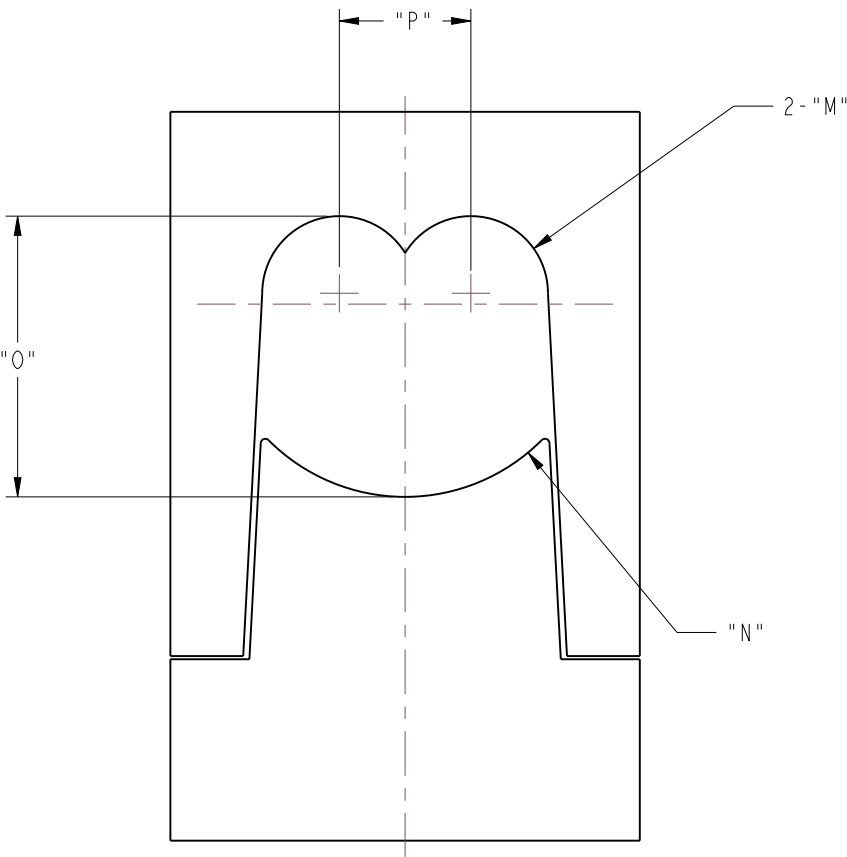


C30 - 302LL-TFCXIM CABLE
(FOR REFERENCE)

AMPHENOL CORPORATION		DANBURY, CONN.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE:		CODE IDENT.	349-50950		REV A
FRACTIONS DECIMALS ANGLES		74868			
± 1/64 ± .005 ± 1°		SCALE: NONE	SHEET 4 OF 6		

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14. SUGGESTED CRIMP DIE DIMENSIONS: ***



	NAME	DATE		NAME	DATE
PROJ. ENG.	TANGOR.DENG	19-Mar-21	APPD. BY	SCOTT	11-Jan-22
CHK. BY	TANGOR.DENG	11-Jan-22	DATE ISSUED		

AMPHENOL CORPORATION		DANBURY, CONN.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE: FRACTIONS DECIMALS ANGLES ± 1/64 ± .005 ± 1°		CODE IDENT.	349-50950		REV A
		74868	SCALE: NONE		SHEET 5 OF 6

TABLE 14.1

CABLE GROUP	CRIMP DIE DIMENSIONS (mm)			
	M	N	O	P
C30	R0.34	R0.91	0.77	0.56
C01	R0.27	R0.97	0.66	0.39

*** RECOMMENDED DIMENSIONS FOR CRIMP TOOLING ARE ONLY FOR REFERENCE ONLY AND SHOULD BE USED AS A STARTING POINT FOR TOOLING DEVELOPMENT AND VALIDATION. CRIMP DIMENSIONS, CONFIGURATION, SHAPE AND PERFORMANCE MUST CONFORM TO RECOMMENDED AFTER CRIMP DIMENSIONS ALONG WITH MECHANICAL AND ELECTRICAL SPECIFICATIONS.

AMPHENOL CORPORATION		DANBURY, CONN.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES: AND TOLERANCES ARE: FRACTIONS DECIMALS ANGLES ± 1/64 ± .005 ± 1°		CODE IDENT.	349-50950		REV A
		74868	SCALE: NONE		SHEET 6 OF 6