

HCI 6.2mm Pitch wire to wire & wire to board Connectors

1. SCOPE

This specification is covered the crimping requirements for HCI 6.2mm Pitch wire to wire & wire to board Connectors.

2. Applicable Products

Applicable product numbers are written below.

| Part No. | Description |
|-----------|---|
| 2408840-X | HCI 6.2mm Pitch wire to wire & wire to board socket contact |
| 2408841-X | HCI 6.2mm Pitch wire to wire pin contact |

Fig.1 Part No. list

3. Crimping Requirements

3.1 Crimping Condition

| Wire Size (AWG) | Part Number | Insulation O.D (mm) | Conductor (mm) | Insulation (mm) |
|-----------------|------------------------|---------------------|------------------|------------------|
| | | | Crimp height (A) | Crimp height (B) |
| 22 | 2408841-X 2408840-X | TBD | TBD | TBD |
| 20 | 2408841-5 | 1.9~3.4 | 1.10±0.05 | 2.9 |
| 18 | 2408840-5 | | 1.25±0.05 | 3.0 |
| 16 | 2408841-5 | | 1.45±0.05 | 3.1 |
| 14 | 2408840-5 | | 1.60±0.05 | 3.2 |
| 12 | 2408841-4 2408840-4 | 4.1 | 1.80±0.05 | 3.8 |

Fig.2 Crimping Condition List

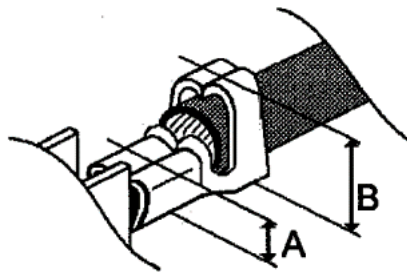


Fig.3 Crimping Image

3.2 Standard Insulation Crimping Condition

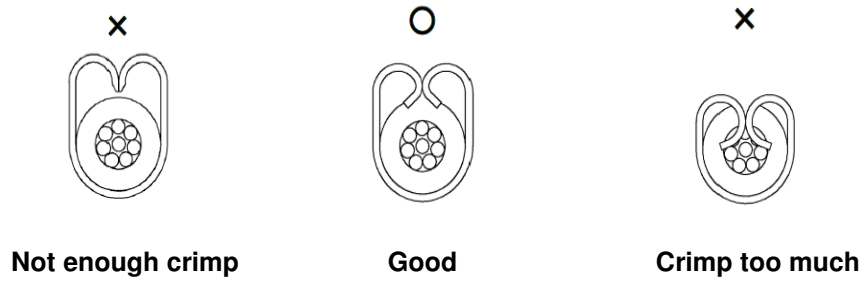


Fig.4 Insulation Crimping Image in cross

3.3 Standard Conductors Crimping



Fig.5 Conductor Crimping Image in cross section
(In case of flat bottom shape)

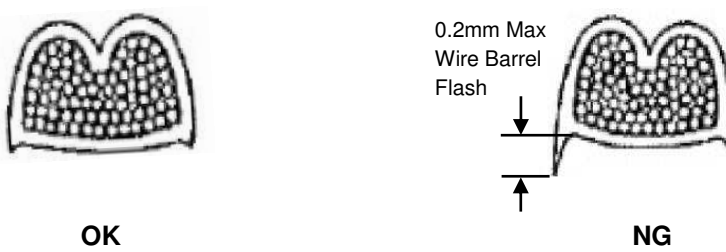
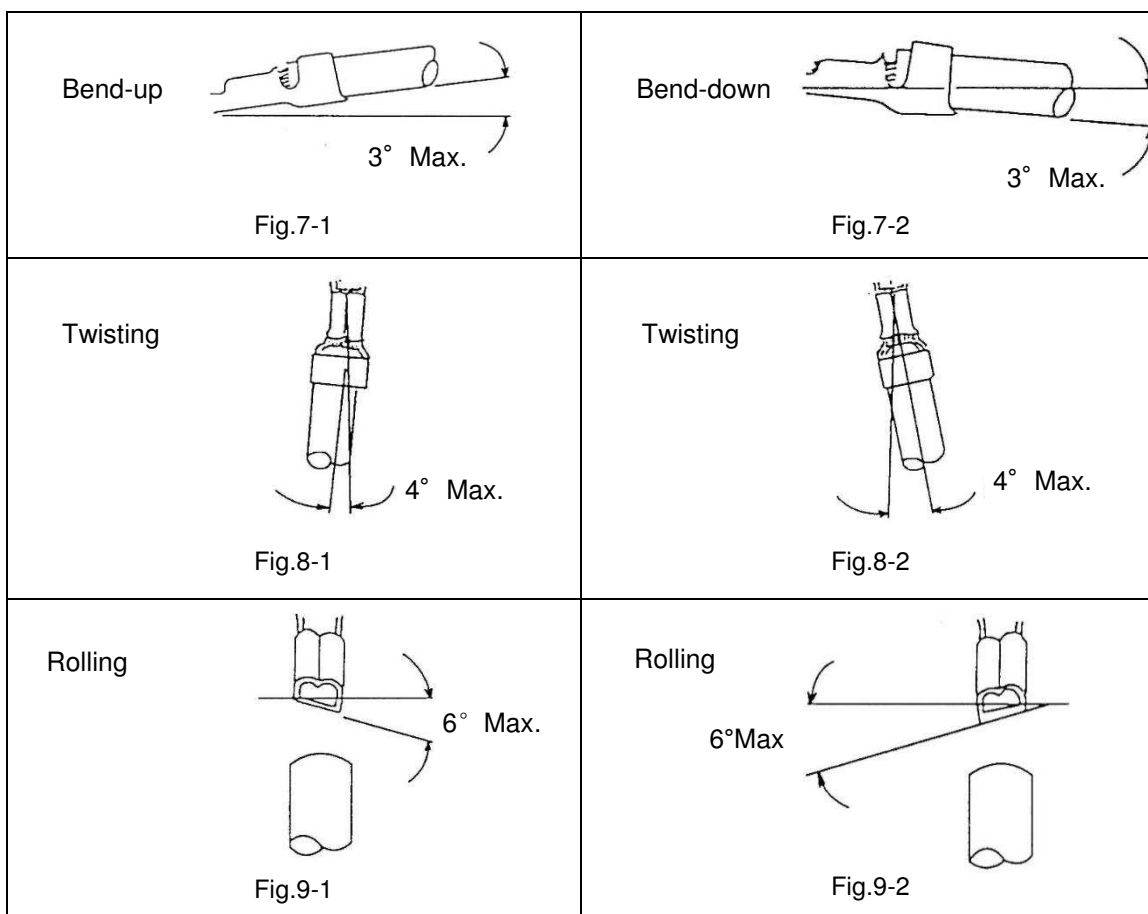
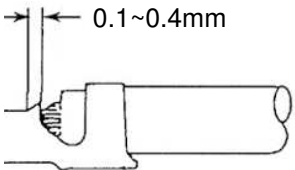
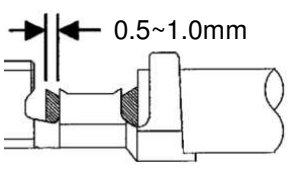
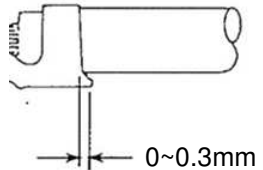


Fig.6 Conductor Crimping Image in cross section
(In case of not flat bottom shape)

3.4 Standard Terminal Crimping

| Item | Range (Ref) |
|----------------------------|-------------|
| Bend-up (Max.) | 3° |
| Bend-down (Max.) | 3° |
| Twist (Max.) | 4° |
| Rolling (Max.) | 6° |
| Bellmouth length | 0.1~0.4mm |
| Carrier cut off length | 0~0.3mm |
| Wire-End Protrusion Length | 0.5~1mm |



| | |
|---|--|
| <p>Bellmouth Length</p>  <p>Fig.10</p> | <p>Wire-End Protrusion Length</p>  <p>Fig.11</p> |
| <p>Carrier Cut-Off Length</p>  <p>Fig.12</p> | |