

**NOTE**



All numerical values are in metric units [with U.S. customary units in brackets]. Dimensions are in millimeters [and inches]. Unless otherwise specified, dimensions have a tolerance of  $\pm 0.13$  [ $\pm 0.005$ ] and angles have a tolerance of  $\pm 2^\circ$ . Figures and illustrations are for identification only and are not drawn to scale.

## 1. INTRODUCTION

This specification covers the requirements for application of TE Connectivity Type II Screw Machine Pin and Socket Contacts. These requirements are applicable to hand or automatic machine crimping tools. For specific wire and insulation ranges relative to the products covered in this specification, see Figures 2 and 3.

When corresponding with TE Personnel, use the terminology provided in this specification to facilitate your inquiries for information. Basic terms and features of this product are provided in Figure 1.

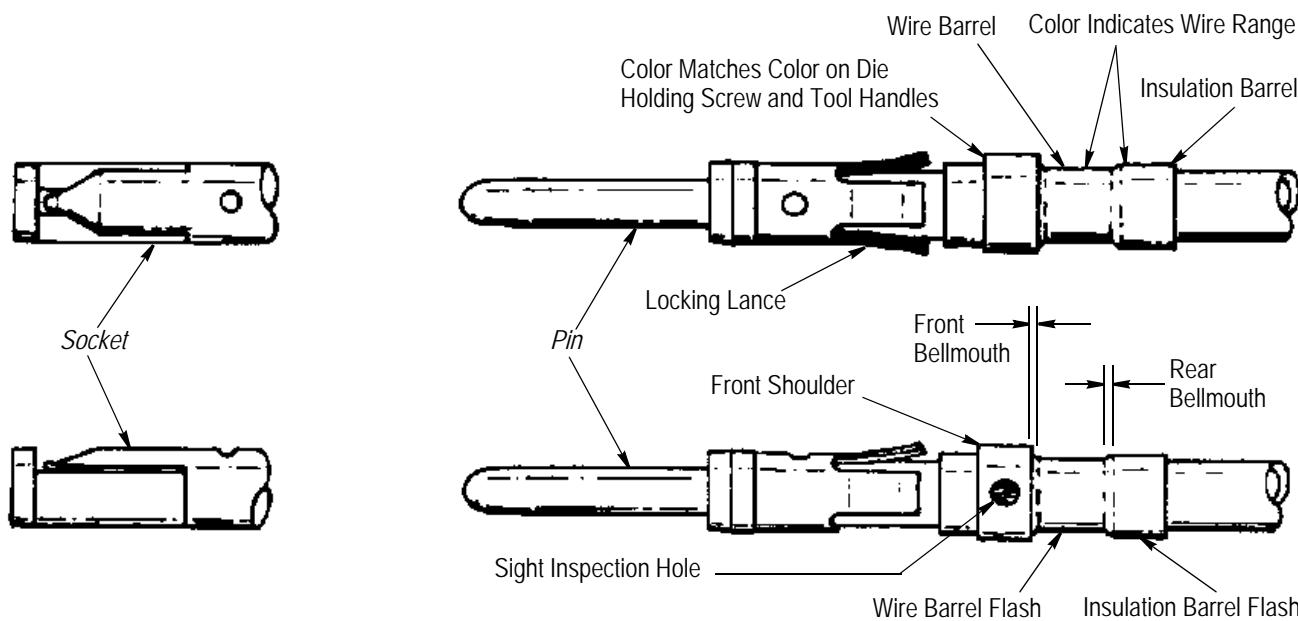


Figure 1

## 2. REFERENCE MATERIAL

### 2.1. Revision Summary

- Updated document to corporate requirements
- New logo

### 2.2. Customer Assistance

Reference Product Part Numbers 201625 and 201627 and Product Code 5021 are representative of Type II Pin and Socket Contacts. Use of these numbers will identify the product line and expedite your inquiries through a service network established to help you obtain product and tooling information. Such information can be obtained through a local TE Representative or, after purchase, by calling PRODUCT INFORMATION at the number at the bottom of this page.

### 2.3. Drawings

Customer Drawings for product part numbers are available from the service network. If there is a conflict between the information contained in the Customer Drawings and this specification or with any other technical documentation supplied, call PRODUCT INFORMATION at the number at the bottom of this page.

## 2.4. Specifications

Refer to Product Specification 108-10039 for product performance and test information.

## 3. REQUIREMENTS

### 3.1. Safety

Do not stack product shipping containers so high that the containers buckle or deform.

### 3.2. Storage

#### A. Ultraviolet Light

Prolonged exposure to ultraviolet light may deteriorate the chemical composition used in the contacts.

#### B. Shelf Life

The contacts should remain in the shipping containers until ready for use to prevent deformation to the contacts. The contacts should be used on a first in, first out basis to avoid storage contamination that could adversely affect performance.

#### C. Chemical Exposure

Do not store contacts near any chemical listed below as they may cause stress corrosion cracking in the contacts.

Alkalies	Ammonia	Citrates	Phosphates	Citrates	Sulfur Compounds
Amines	Carbonates	Nitrites	Sulfur	Nitrites	Tartrates

### 3.3. Wire Preparation

#### A. Strip Length

Insulation shall be stripped as indicated in Figures 2 and 3.

#### B. Workmanship

Reasonable care shall be taken not to nick, scrape, or cut any strands or the solid wire during the stripping process.

### 3.4. Wire Barrel Crimp

#### A. Crimp Dimensions

Crimp height and width shall be as shown in Figures 2 and 3.

#### B. Wire Barrel Flash

Wire barrel flash shall not exceed 0.20 mm [.008 in.].

#### C. Bellmouth

Front and rear bellmouth length shall be 0.64 mm [.025 in.] minimum.

#### D. Conductor Location

Conductor shall be visible through the sight inspection hole.

#### E. Workmanship

Front shoulder shall not be deformed during the crimping operation.

### 3.5. Insulation Barrel Crimp

#### A. Crimp Dimensions

Crimp width shall be as shown in Figures 2 and 3.

## B. Insulation Barrel Flash

Insulation barrel flash shall not exceed 0.25 mm [.010 in.].

## C. Workmanship

Reasonable care shall be taken not to cut or break the insulation during the crimping operation.

### 3.6. Locking Lance

Locking lance shall not be deformed.

### 3.7. Alignment

The axial concentricity of the crimped product shall fall into an area defined by a 3.40 mm [.134 in.] diameter circle whose center is the centerline of the contact.

HAND TOOL WIRE CIRMP DIMENSIONS												
PART NO.		COLOR BAND		WIRE		INSULATION DIAMETER	STRIP LENGTH	WIRE BARREL CRIMP		INSUL BARREL CRIMP WIDTH	HAND TOOL	
PIN	SKT	BARREL	SHOULDER	QTY	SIZE			WIDTH +0.13/-0.03 [.005/-0.001]	HEIGHT ±0.05 [.002]		PART NO.	HANDLE COLOR
201625	201627	White	Red	1	32-30	0.76-1.22 [.030-.048]	5.16 [.203]	1.88 [.074]	1.09 [.043]	2.29 [.090]	45099 or 90118†	Red
201555	201554				28-24	0.89-1.40 [.035-.055]						
201607	201609	Red				1.22-1.65 [.048-.065]						
201649	201613	1		2.41-2.79 [.095-.110]		1.09 [.043]		1.09 [.043]	2.64 [.104]	90093	Green	
201611	201613			4.02-4.57 [.040-.062]								
204189	201353			4.40-5.216 [.055-.085]								
201354	201332	Green†	Yellow	1	24-20					18-16	45099 or 90118†	Red
201334	202189				22-18							
202410	202411				18							
201582	201584				---							
201647	201580				---							
201578	200331	Blue	Blue†	1	14	---	6.35 [.250]	2.51 [.099]	1.60 [.063]	---	45098	Blue
200334	200679				---							
201330	201328				---							
204188	---				---							
---	201751				---							
202725	202726	Violet†	Blue†	1	---	---	---	---	---	---	---	---
201591	201589				---							
200335	200681				---							
200336	204274				---							
204219	---				---							
201645	201570	201568	Violet†	1	14	---						
206029	206029				---							

†Hand tool 90118 does not crimp insulation barrel. ‡No insulation crimp.

Figure 2

## AUTOMATIC MACHINE WIRE CIRMP DIMENSIONS

PART NO.		COLOR BAND		WIRE		INSULATION DIAMETER	STRIP LENGTH	WIRE BARREL CRIMP		INSUL BARREL CRIMP WIDTH	CRIMPING DIE								
PIN	SKT	BARREL	SHOULDER	QTY	SIZE			WIDTH +0.13/-0.03 [+.005/-001]	HEIGHT ±0.05 [.002]		ASSY. NO.	SCREW COLOR							
201334	201332	Red	Red	1	28-24	1.22-1.65 [.048-.065]	5.16 [.203]	1.88 [.074]	1.09 [.043]	2.54 [.100]	90249-1	Red							
201354	201353					0.89-1.40 [.035-.055]													
201607	201609			1	24-20	1.40-1.90 [.055-.075]													
201611						1.40-2.16 [.055-.085]													
201649	201613			1	24-20	1.22-1.57 [.040-.062]													
204189																			
200334	200331	Yellow	Yellow	1	24-20		5.16 [.203]	1.88 [.074]	1.09 [.043]	2.54 [.100]	90249-1	Red							
200679																			
201330	201328			1	24-20														
204188																			
201582	201584			1	18-16														
201578																			
201647	201580																		
200335		Blue†	Blue	1	18-16	---	6.35 [.250]	2.51 [.099]	1.60 [.063]	---	90250-1	Blue							
200336																			
200681	200333			2	18														
204274																			
201591	201589			1	14														
202725	202726																		
201570		201568	Violett	1	18-16	90250-3	5.16 [.203]	1.88 [.074]	1.09 [.043]	2.54 [.100]	90250-1	Blue							
201645																			
206029																			
204219	---	Bluet†																	

†No insulation crimp.

Figure 3