

Work Instruction for #8&2.5mm&16#&20# Machined Contacts

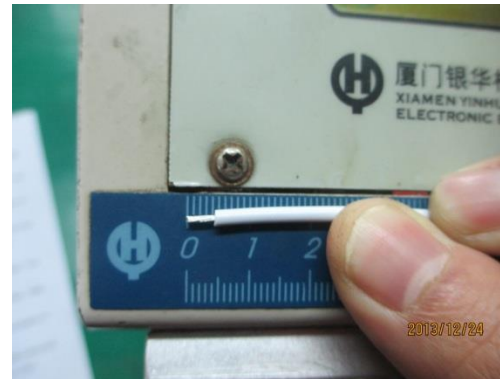
Step 1: Stripp insulator, length refer to below table:

Contacts P/N	MS10A23F	MS10B23F MP10B23F	MS14M23F MP14M23F	MS16M23F MP16M23F	MS20M23F MP20M23F	MS24M23F MP24M23F
	SC000519S MP10A23F SC000518S					
Length	9.0mm	9.0mm	8.0mm	8.0mm	6.5mm	6.5mm

Contacts P/N	MS20W23F MP20W23F	MS24W23F MP24W23F	MS28W23F MP28W23F
Length	6.5mm	6.5mm	6.5mm



Picture 1

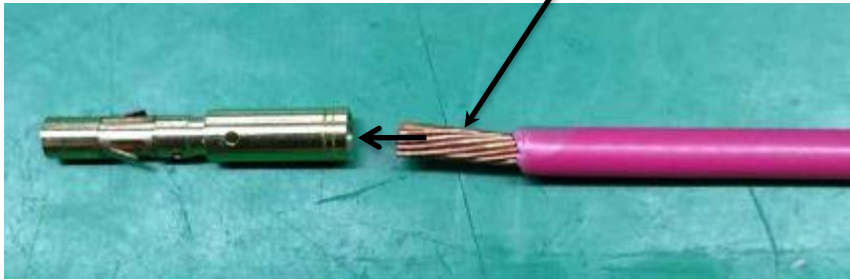


Picture 2

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Step 2: Crimp contacts

Conductor into contact

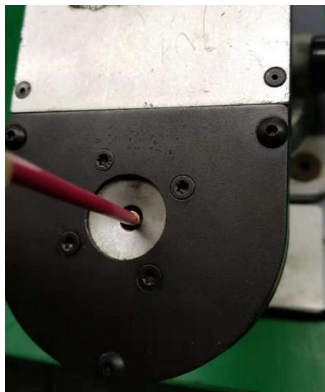


Check conductor loading

Clearance of insulation



Crimp contacts



After crimp contacts



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Step 3: Pull force test, Requirement as follow table (IPC-WHMA-A-620A):

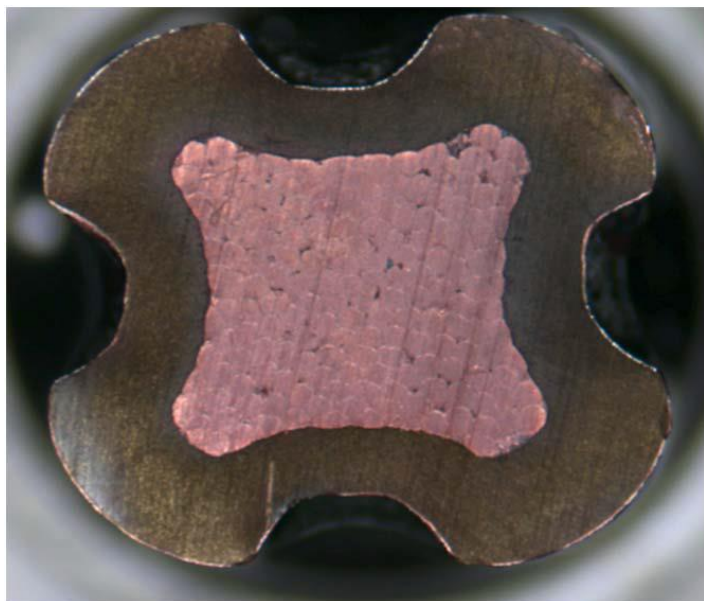
Contacts P/N	MS10A23F	MS10B23F MP10B23F	MS14M23F MP14M23F	MS16M23F MP16M23F	MS20M23F MP20M23F	MS24M23F MP24M23F
	SC000519S MP10A23F SC000518S					
Pull force	10AWG ≥80lbf	10AWG ≥80lbf	14AWG ≥50lbf	16AWG ≥30lbf	20AWG ≥13lbf	24AWG ≥5lbf
	12AWG ≥70lbf	12AWG ≥70lbf	16AWG ≥30lbf	18AWG ≥20lbf	22AWG ≥8lbf	26AWG ≥3lbf
Contacts P/N	MS20W23F	MS24W23F MP24W23F	MS28W23F MP28W23F			
	MP20W23F					
Pull force	20AWG ≥13lbf	24AWG ≥5lbf	28AWG ≥2lbf			
	22AWG ≥8lbf	26AWG ≥3lbf	30AWG ≥1.5lbf			



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Step 4: Contact Cross Section

Section



standard

	名称	数值	标准
	Name	Value	Standard
测试结果	端子是否有裂纹	无裂纹	不得有裂纹
	If contact has crackle		No Crackle
	端子是否有毛刺	无毛刺	不得有毛刺
	If contact has burr		No Crackle
	端子与线间是否有间隙	无间隙	端子与线需压接紧密
	If contact and wire has gap		Contact and line need to be pressed tightly
	线与线间是否有间隙	无间隙	线与线需压接紧密
	If wire and wire has gap		wire and line need to be pressed tightly
备注			