

Work Instruction for M23 & M40 & M17 series contacts crimping

Stripp insulator, length refer to below table:

Contacts P/N	SC000261 SC000259	SC000262 SC000260	SC000263 SC000264	SC000035 SC000044	SC000146 SC000030	SC000013
Length	4.5 mm	7.0 mm	4.5 mm	4.5 mm	4.5 mm	4.5 mm

Contacts P/N	SC000337 SC000325	SC000338 SC000326	SC000036 SC000014	SC000040 SC000045	SC000041 SC000046	SC000039
Length	4.5 mm	4.5 mm	7.0 mm	7.0mm	9.5mm	9.5mm

Contacts P/N	SC000268 SC000267
Length	4.0mm

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Picture 1



Picture 2

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

Contacts P/N	SC000261 SC000259	SC000262 SC000260	SC000263 SC000264	SC000035 SC000044	SC000146 SC000030	SC000013
Pull force	18AWG≥32 lbf 22AWG≥12 lbf	14AWG≥70 lbf 18AWG≥32 lbf	22AWG≥12 lbf 28AWG≥3 lbf	18AWG≥32 lbf 22AWG≥12 lbf	24AWG≥8 lbf 28AWG≥3 lbf	18AWG≥32 lbf 22AWG≥12 lbf

Contacts P/N	SC000337 SC000325	SC000338 SC000326	SC000036 SC000014	SC000040 SC000045	SC000041 SC000046	SC000039
Pull force	18AWG≥32 lbf 22AWG≥12 lbf	18AWG≥32 lbf 22AWG≥12 lbf	14AWG≥70 lbf 18AWG≥32 lbf	14AWG≥70 lbf 18AWG≥32 lbf	8AWG≥220 lbf 12AWG≥110 lbf	8AWG≥220 lbf 12AWG≥110 lbf

Contacts P/N	SC000268 SC000267
Pull force	22AWG≥12 lbf 30AWG≥1.5 lbf

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Picture 3



Picture 4

Table 19-12 Pull Test Force Values

Conductor Size		Machined Connector Contact				Crimp Splices		Stamped Contacts and Terminal Lugs	
AWG	(mm ²)	Silver/Tin Plated Wire		Nickel Plated Wire		Pounds	(N)	Pounds	(N)
		Lbs	(N)	Lbs	(N)				
30	0.050	1.5	6.7	1.5	6.7	1.5	6.7	1.5*	6.7*
28	0.080	3	13.4	2	8.9	2	8.9	2*	8.9*
26	0.130	5	22.3	3	13.4	3	13.4	7	31.2
24	0.200	8	35.6	6	26.7	5	22.3	10	44.5
22	0.324	12	53.4	8	35.6	8	35.6	15	66.8
20	0.519	20	89.0	19	84.6	13	57.9	19	84.6
18	0.823	32	142	NE	NE	20	89.0	38	169.1
16	1.310	50	222.3	37	164.6	30	133.5	50	222.5
14	2.080	70	311.5	60	266.9	50	222.5	70	311.5
12	3.310	110	489.5	100	445.0	70	311.5	110	489.5
10	5.261	150	667.5	135	600.5	80	356.0	150	667.5
8	8.367	220	978.6	200	890.0	90	400.5	225	1001.3
6	13.300	300	1235.0	270	1201.0	100	445.0	300	1335.0
4	21.150	400	1780.0	360	1601.4	140	623.0	400	1780.0
3	26.670	NE	NE	NE	NE	160	712.0	NE	NE
2	33.620	550	2447.5	495	2201.9	180	801.0	550	2447.5
1	42.410	650	2892.5	585	2602.2	200	890.0	650	2892.5
1/0	53.490	700	3115.0	630	2757.9	250	1112.5	700	3115.0
2/0	67.430	750	3337.5	675	3002.5	300	1235.0	750	3337.5
3/0	85.010	NE	NE	NE	NE	350	1557.5	825	3671.3
4/0	107.200	875	3893.0	785	3491.9	450	2202.5	875	3893.8
250	127	NE	NE	NE	NE	500	2225.0	NE	NE
300	156	NE	NE	NE	NE	550	2447.5	NE	NE
350	177	NE	NE	NE	NE	600	2670.0	NE	NE
400	203	NE	NE	NE	NE	650	2892.5	NE	NE
500	253	NE	NE	NE	NE	800	3560.0	NE	NE
600	304	NE	NE	NE	NE	900	4005.0	NE	NE
700-2000	355 - 1016	NE	NE	NE	NE	1000	4450.0	NE	NE

* Value per UL 486A specification and established only for Class 1 assemblies