HEM/HEF 16A Machined Crimp Contact for Crimping

CONTENT

1. INTRODUCTION

This specification covers the requirements for the application of pin and socket contacts of HEM/HEF 16A machined crimp contact series. It is valid for proper manual, semiautomatic and fully automatic tools.

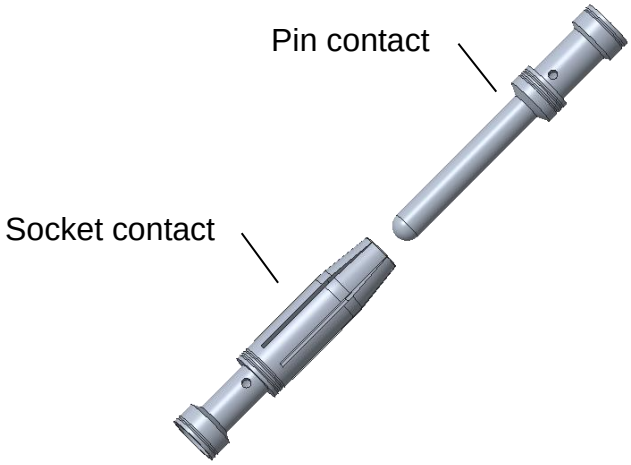


Figure 1

2. SUPPORT DOCUMENT

2.1 Drawings

Customer drawing for product part numbers are available from the service work. If there is a conflict between the information contained in the customer drawings and this specification or any other technical documentation supplied, contact TE connectivity Engineering.

2.2 Product Specification

Performance specification for HEM/HEF 16A machined crimp contact can be found in TE Connectivity related drawings and product specification 108-137612.

3. REQUIREMENTS

3.1 Prepare the crimp contact

Pin contact is applicable to the conductor cross-sectional area: 0.14 mm² ~4.0 mm²

HEE pin contact part number		Wire guage	
Part number	Description	mm²	AWG
T2030031002-000	HEM-0.3, L=28	0.14-0.37	26-22
T2030031005-000	HEM-0.5, L=28	0.5	20
T2030031008-000	HEM-0.75, L=28	0.75	18
T2030031010-000	HEM-1.0, L=28	1.0	18
T2030031015-000	HEM-1.5, L=28	1.5	16
T2030031025-000	HEM-2.5, L=28	2.5	14
T2030031030-000	HEM-3.0, L=28	3.0	12
T2030031040-000	HEM-4.0, L=28	4.0	12
T2030041002-000	HEM-0.3, L=25	0.14-0.37	26-22
T2030041005-000	HEM-0.5, L=25	0.5	20
T2030041008-000	HEM-0.75, L=25	0.75	18
T2030041010-000	HEM-1.0, L=25	1.0	18
T2030041015-000	HEM-1.5, L=25	1.5	16
T2030041025-000	HEM-2.5, L=25	2.5	14
T2030041030-000	HEM-3.0, L=25	3.0	12
T2030041040-000	HEM-4.0, L=25	4.0	12

Socket contact is applicable to the conductor cross-sectional area: 0.14 mm² ~4.0 mm²

HEF socket contact part number		Wire guage	
Part number	Description	mm²	AWG
T2030032002-000	HEF-0.3	0.14-0.37	26-22
T2030032005-000	HEF-0.5	0.5	20
T2030032008-000	HEF-0.75	0.75	18
T2030032010-000	HEF-1.0	1.0	18
T2030032015-000	HEF-1.5	1.5	16
T2030032025-000	HEF-2.5	2.5	14
T2030032030-000	HEF-3.0	3.0	12
T2030032040-000	HEF-4.0	4.0	12

3.2 Wire preparation

Using the appropriate cable stripping tool, strip the conductor as indicated in **Figure 2** and strip length according to **Table 1**, and proceed to clean and clear cuts of the insulating sleeve without damaging the strands.

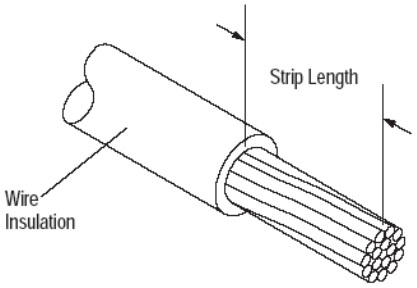


Figure 2

Table 1

Nominal conductor cross section		Conductor stripped length (mm)
mm²	AWG	
0.14-0.37	26-22	$7.5^{+}/_{-0.5}$
0.5	20	$7.5^{+}/_{-0.5}$
0.75	18	$7.5^{+}/_{-0.5}$
1.0	18	$7.5^{+}/_{-0.5}$
1.5	16	$7.5^{+}/_{-0.5}$
2.5	14	$7.5^{+}/_{-0.5}$
3.0	12	$7.5^{+}/_{-0.5}$
4.0	12	$7.5^{+}/_{-0.5}$

3.3 Crimping the contact

Step **1:** Insert the stripped strands into the wire barrel of pin contact or socket contact. The hole located in **Figure 5** at the end of the barrel is for checking and be sure of the correct insertion of the conducting strands.

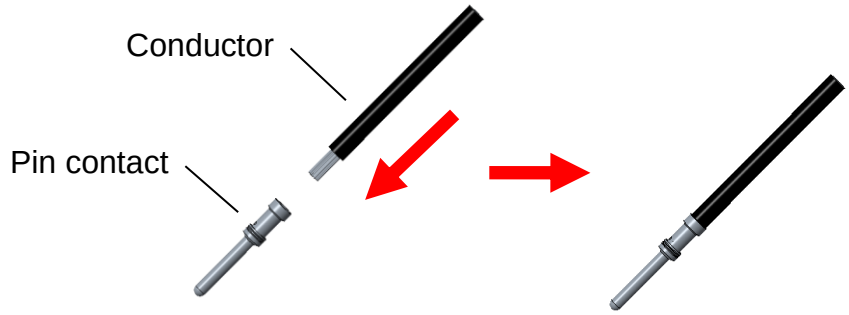


Figure 3

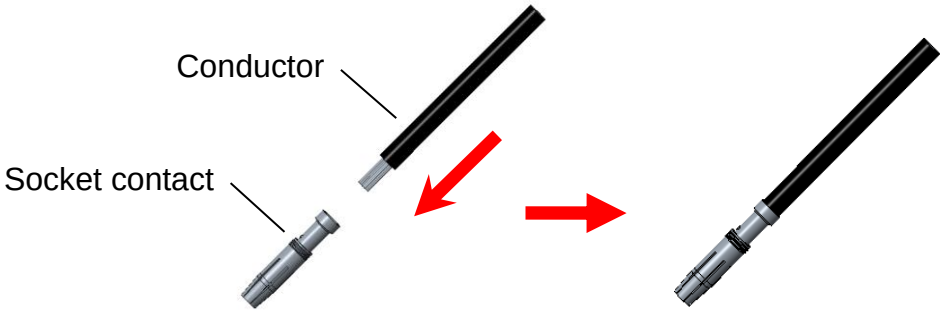


Figure 4

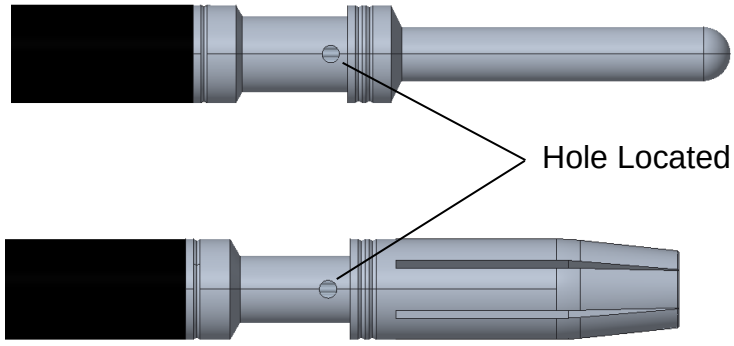


Figure 5

Sep **2**: Crimp contacts
Crimp tool: T3100000022-000 RPC-M23-T-B

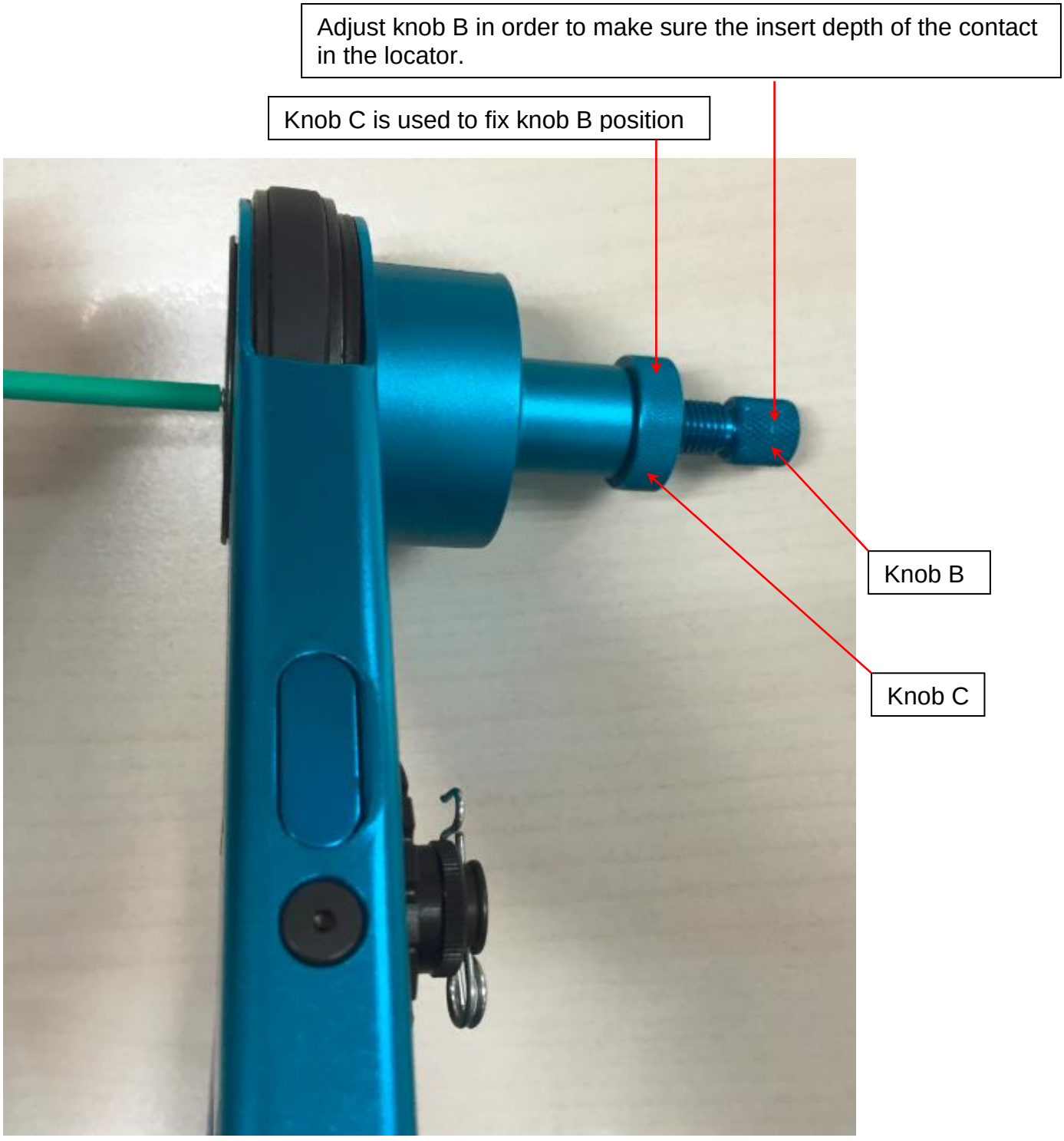
The indicated by the arrow of wire gauge for the tools currently available pressure gauge

knob A:
Adjusting method is to raise the knob, and then turn the knob and adjust the the right AWG number to the SEL. NO. arrow.
[the tool has 8 crimp position and the corresponding wire AWG number as below]
Refer 114-137329

Put the contact into crimping tool, then crimp the contact.
When crimping the contact, need to make sure the crimp tool fully press, then open the crimp tool and crimp the other contact.

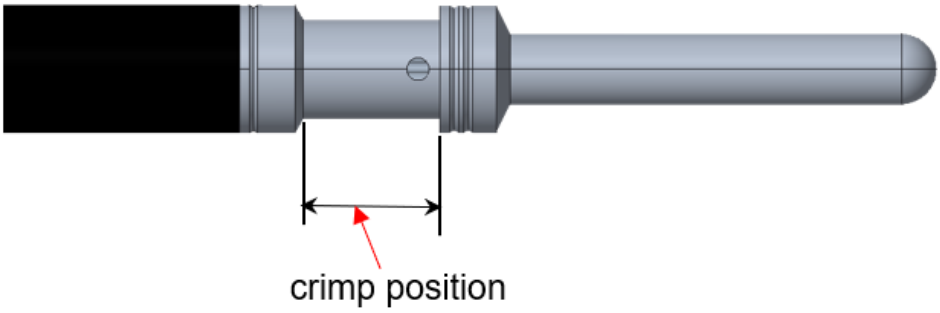
NOTE

a. contact should be put the right position for crimping.



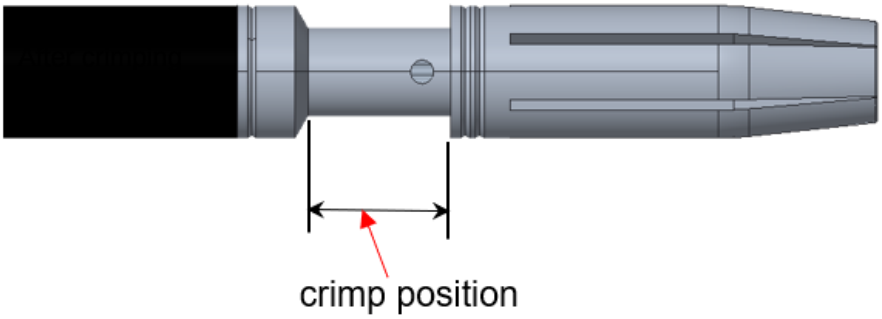
b. The right crimp area per the below crimp position：

HEM contact：conductor cross-section 0.14 mm² ~4.0 mm²



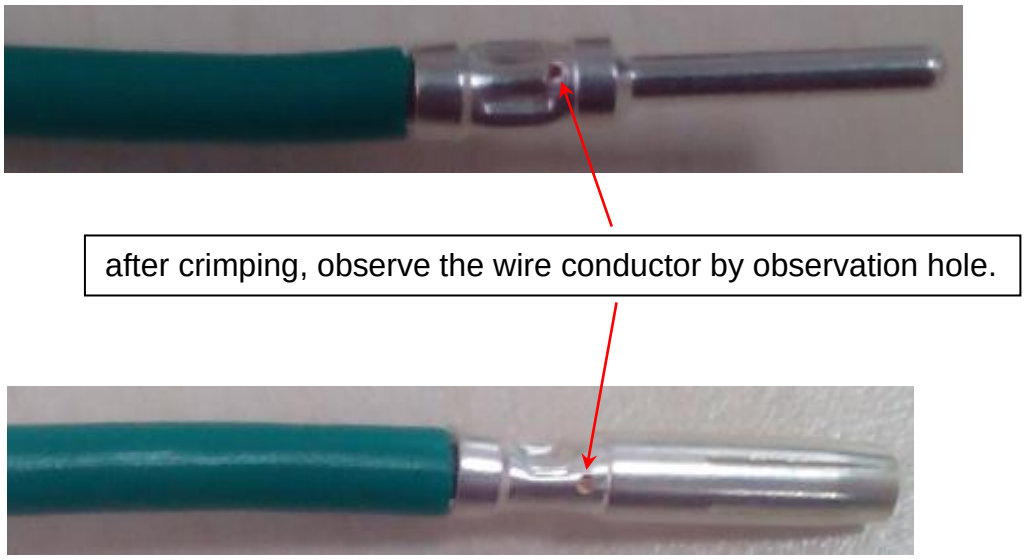
After crimping

HEF contact：conductor cross-section 0.14 mm² ~4.0 mm²



After crimping

c. After crimping, observe the wire conductor by observation hole.



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