

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 ± 0.13 [$\pm .005$] 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 the application of Series 187 MK II and MK III, Series 250 MK II and MK III, and RAST 5 Positive Lock Receptacle Connectors. The 187 Series receptacle contacts are designed to accept a wire size range of 24 to 14 AWG while the 250 Series accepts 22 to 10 AWG.

Single and multiple circuit housings are available for your production requirements. The contacts are designed to be mated with tabs containing holes for greater locking force. These receptacle contacts are terminated by automatic or semi-automatic machines.

When corresponding with Tyco Electronics Personnel, use the terminology provided on this specification to help facilitate your inquiry for information. Basic terms and features of components are provided in Figure 1.

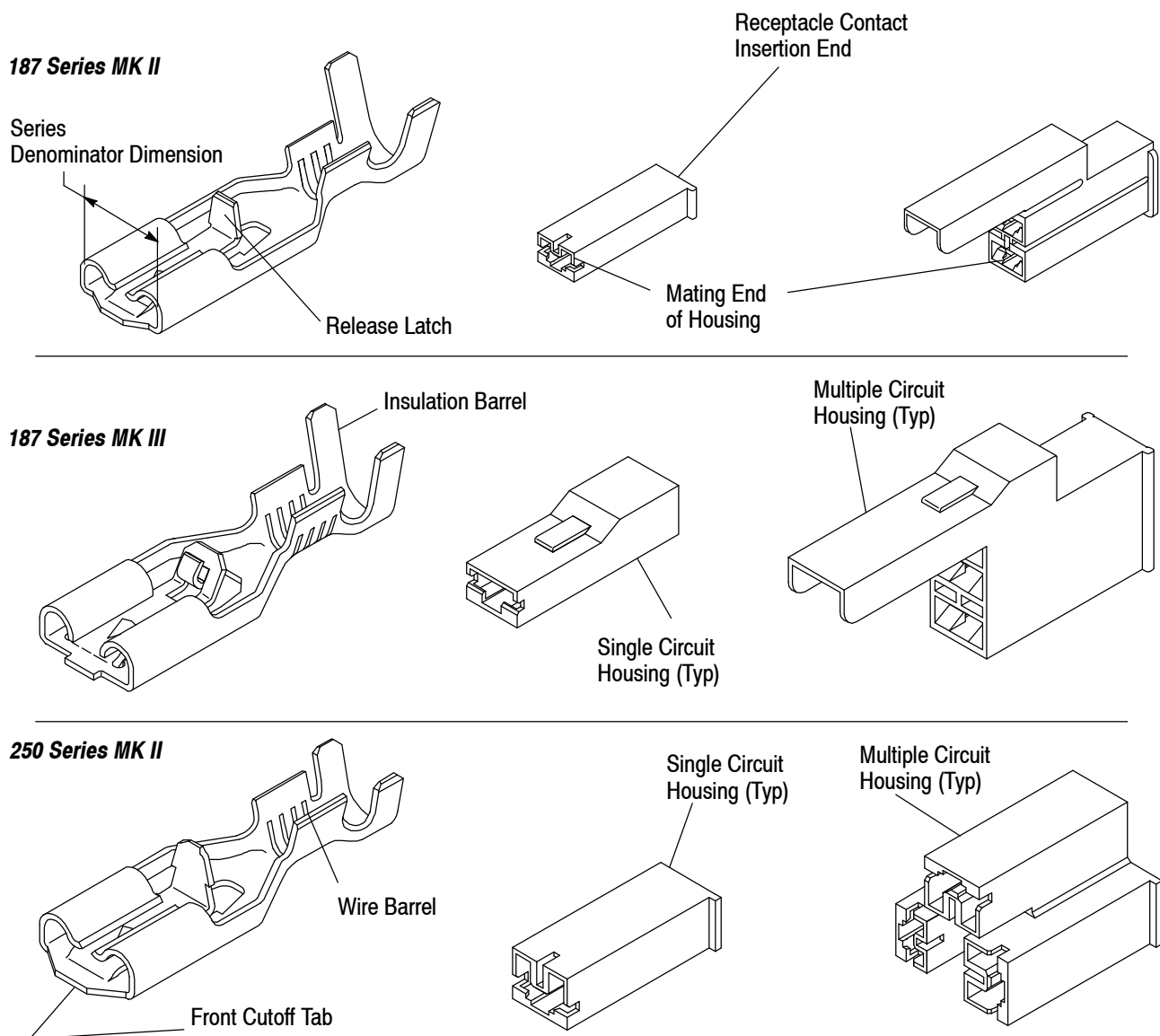
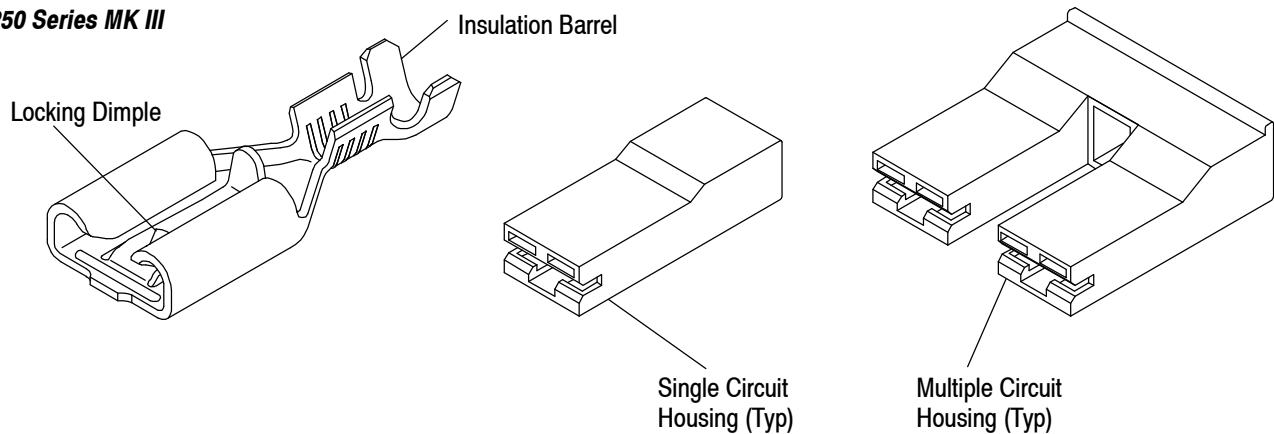
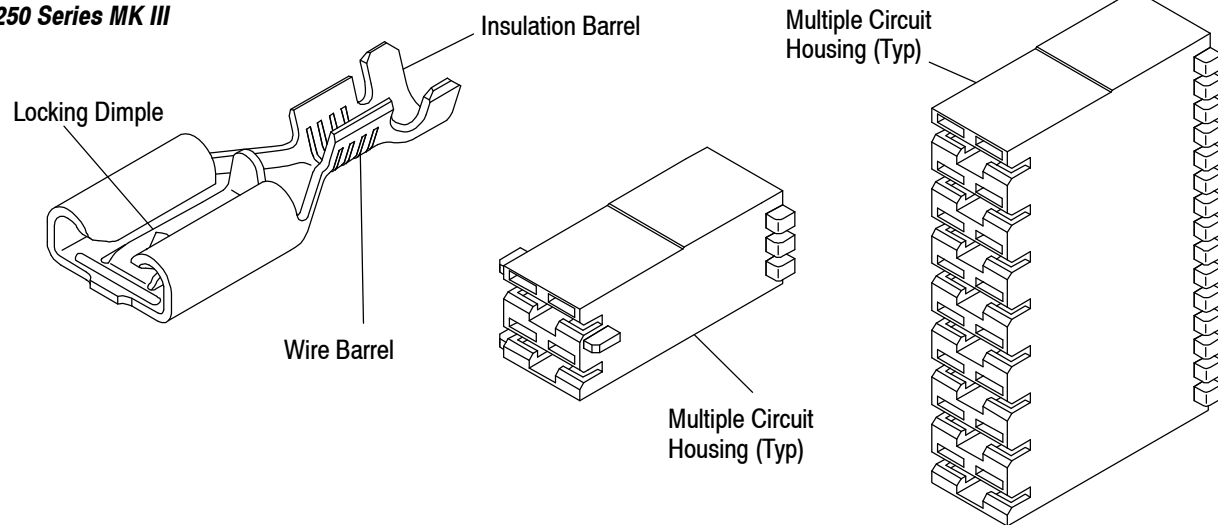


Figure 1 (cont'd)

250 Series MK III**RAST 5
250 Series MK III***Figure 1 (end)***2. REFERENCE MATERIAL****2.1. Revision Summary**

- Update application specification to corporate requirements
- Added new information to tables in Figures 2, 8, and 11; and changed callout in Figure 3

2.2. Customer Assistance

Reference Part Number 520977 and Product Code 1128 are representative of Series 187 and 250 Positive Lock Receptacle Connectors. These numbers are used in the Tyco Electronics network of customer service to access tooling and product application information. This service is provided by your local Tyco Electronics Representative or, after purchase, by calling the Tooling Assistance Center or the Product Information number at the bottom of page 1.

2.3. Drawings

Customer Drawings for specific products are available from the responsible Tyco Electronics Engineering Department via the service network. The information contained in the Customer Drawing takes priority if there is a conflict with this specification or any other technical documentation supplied by Tyco Electronics.

2.4. Instructional Material

The following list includes available instruction sheets (408- and 411-series) that provide assembly procedures for product, operation, maintenance and repair of tooling, and customer manuals (409-series) that provides setup, operation, and maintenance of machines.

Document Number	Document Title
408-3295	Preparing Reel of Contacts for Application Tooling
408-7424	Checking Terminal Crimp Height Gaging Die Closure
408-8039	Heavy Duty Miniature Quick-Change Applicators (End-Feed Type)
408-8053	Conversion Guide for Miniature Quick Change Applicators
408-9640	Crimp Quality Monitor Applicators for Side-Feed and End-Feed Applications
408-9816	Handling of Reeled Products
409-5128	Basic AMP-O-ELECTRIC* Model "K" Terminating Machines, and Accessories
409-5842	AMP-O-ELECTRIC Model "G" Terminating Machine 354500-1
409-5878	AMPOMATOR* CLS IV+ Lead-Making Machine 356500-[]
411-5106	Extraction Tool 724659-1, -2, and -5

3. REQUIREMENTS

3.1. Storage

A. Ultraviolet Light

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

B. Reel Storage

When using reeled contacts, store coil wound reels horizontally and traverse wound reels vertically.

C. Shelf Life

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

D. Chemical Exposure

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

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

NOTE



Where the above environmental conditions exist, phosphor-bronze contacts are recommended instead of brass if available.

3.2. Special Characteristics

Positive Lock Receptacles are designed with reduced mating forces and a flexible locking dimple. This unique locking feature acknowledges proper mating with an audible mechanical "snap" of the dimple into the hole in the mating tab. The locking feature enhances safety and reliability of the connection for isolated and hard-to-reach areas.

3.3. Wire Selection

The Series 187 and 250 Positive Lock Contacts will accept wire sizes and insulation diameters listed in Figure 2. Strip lengths, and crimp heights and widths are also listed in Figure 2.

CAUTION



DO NOT nick, cut, or scrape the wire conductor during the stripping operation.

SERIES SIZE	WIRE SIZE, AWG	INSULATION DIAMETER	STRIP LENGTH	WIRE BARREL		INSULATION BARREL CRIMP WIDTH (REF)
				CRIMP HEIGHT ± 0.05 [.002]	CRIMP WIDTH (REF)	
187 MK II	24	1.52-2.79 [.060-.110]	4.45-3.68 [.175-.145]	0.89 [.035]	1.78 [.070]	3.56 [.140]
	22			0.97 [.038]		
	20			1.04 [.041]		
	20	2.29-3.30 [.090-.130]	4.45-3.68 [.175-.145]	1.14 [.045]	2.29 [.090]	4.57 [.180]
	18			1.27 [.050]		
	16			1.45 [.057]		
187 MK III	22	2.29-3.30 [.090-.130]	5.17-4.39 [.203-.173]	1.02 [.044]	2.03 [.080]	3.94 [.155]
	20			1.19 [.047]		
	18			1.32 [.052]		
	18	3.81-5.08 [.150-.200]	5.17-4.39 [.203-.173]	1.3 [.051]	3.05 [.120]	5.59 [.220]
	16			1.42 [.056]		
	14			1.6 [.063]		
	(2) 18	2@2.79 [.110] Max	6.22-5.46 [.245-.215]	1.52 [.060]		
250 MK II	22	1.52-2.79 [.060-.110]	5.17-4.39 [.203-.173]	1.3 [.051]	2.29 [.090]	3.56 [.140]
	20			1.35 [.053]		
	18			1.45 [.057]		
	18	2.29-3.94 [.090-.155]	5.17-4.39 [.203-.173]	1.47 [.058]	2.79 [.110]	4.57 [.180]
	16			1.65 [.065]		
	14			1.88 [.074]		
	12	3.81-5.08 [.150-.200]	6.22-5.46 [.245-.215]	2.21 [.087]	3.94 [.155]	5.59 [.220]
	10			2.64 [.104]		
250 MK III	22	1.52-2.79 [.060-.110]	5.17-4.39 [.203-.173]	1.22-.048]	2.29 [.090]	3.56 [.140]
	20			1.3 [.051]		
	18			1.4 [.055]		
	(2) 22			1.35 [.053]		
	18	2.29-3.94 [.090-.155]	5.17-4.39 [.203-.173]	1.47 [.058]	2.79 [.110]	4.57 [.180]
	16			1.63 [.064]		
	14			1.85 [.073]		
	16	3.05-4.32 [.120-.170]	5.17-4.39 [.203-.173]	1.5 [.059]	3.56 [.140]	6.1 [.240]
	(2) 18	2@3.05 [.120] Max	6.22-5.46 [.245-.215]	1.6 [.063]		
	(1) 16 and (1) 18			1.7 [.067]		
	(2) 16			1.78 [.070]		

Figure 2 (cont'd)

SERIES SIZE	WIRE SIZE, AWG	INSULATION DIAMETER	STRIP LENGTH	WIRE BARREL		INSULATION BARREL CRIMP WIDTH (REF)
				CRIMP HEIGHT ± 0.05 [.002]	CRIMP WIDTH (REF)	
RAST 5 250 MK III	22	1.52-2.79 [.060-.110]	5.17-4.39 [.203-.173]	1.07 [.042]	2.03 [.080]	3.30 [.130]
	20			1.12 [.044]		
	18			1.24 [.049]		
	18	2.29-3.94 [.090-.155]	5.17-4.39 [.203-.173]	1.24 [.049]	2.79 [.110]	4.57 [.180]
	16			1.37 [.054]		
	14			1.57 [.052]		
	16	3.05-4.32 [.120-.170]	5.17-4.39 [.203-.173]	1.32 [.052]	3.56 [.140]	6.1 [.240]
	(2) 18	2@3.05 [.120] Max	6.22-5.46 [.245-215]	1.42 [.056]		
	(1) 16 and (1) 18			1.52 [.060]		
	(2) 16			1.62 [.064]		

Figure 2 (end)

3.4. Crimped Contact Requirements

Locate the contact to be crimped in the appropriate tooling according to the instructions packaged with that tooling. Detailed instructions covering the placement of contacts in the tooling and the use of such tooling is packaged with each tool.

Terminate the contact according to the directions shipped with the appropriate tooling. See Section 5, TOOLING.



Wire insulation shall NOT be cut or broken during the crimping operation, nor shall the insulation be crimped into the contact wire barrel. Reasonable care should be taken by tooling operators to provide undamaged wire terminations.

A typical receptacle contact as it should appear after crimping is shown in Figure 3.

A. Crimp Height

The crimp applied to the wire portion of the contact is the most compressed area and is most critical in ensuring optimum electrical and mechanical performance of the crimped contact. The crimp height must be within the dimensions provided in Figure 2.

B. Crimp Length

For optimum crimp effectiveness, the crimp must be within the area shown and must meet the crimp dimensions provided in Figure 2. Effective crimp length shall be defined as that portion of the wire barrel, excluding bellmouth(s), fully formed by the crimping tool. Instructions for adjusting, repairing, and inspecting tools are packaged with the tools. See Figure 11.

C. Bellmouths

Front and rear bellmouths shall be evident and conform to the dimensions given in Figure 3.

D. Cutoff Tab

The cutoff tab shall be cut to the dimensions shown in Figure 3.

E. Burrs

The cutoff burr shall not exceed the dimensions shown in Figure 3.

F. Wire Barrel Flash

The wire barrel flash shall not exceed the dimensions shown in Figure 3 in Section X-X.

G. Wire Location

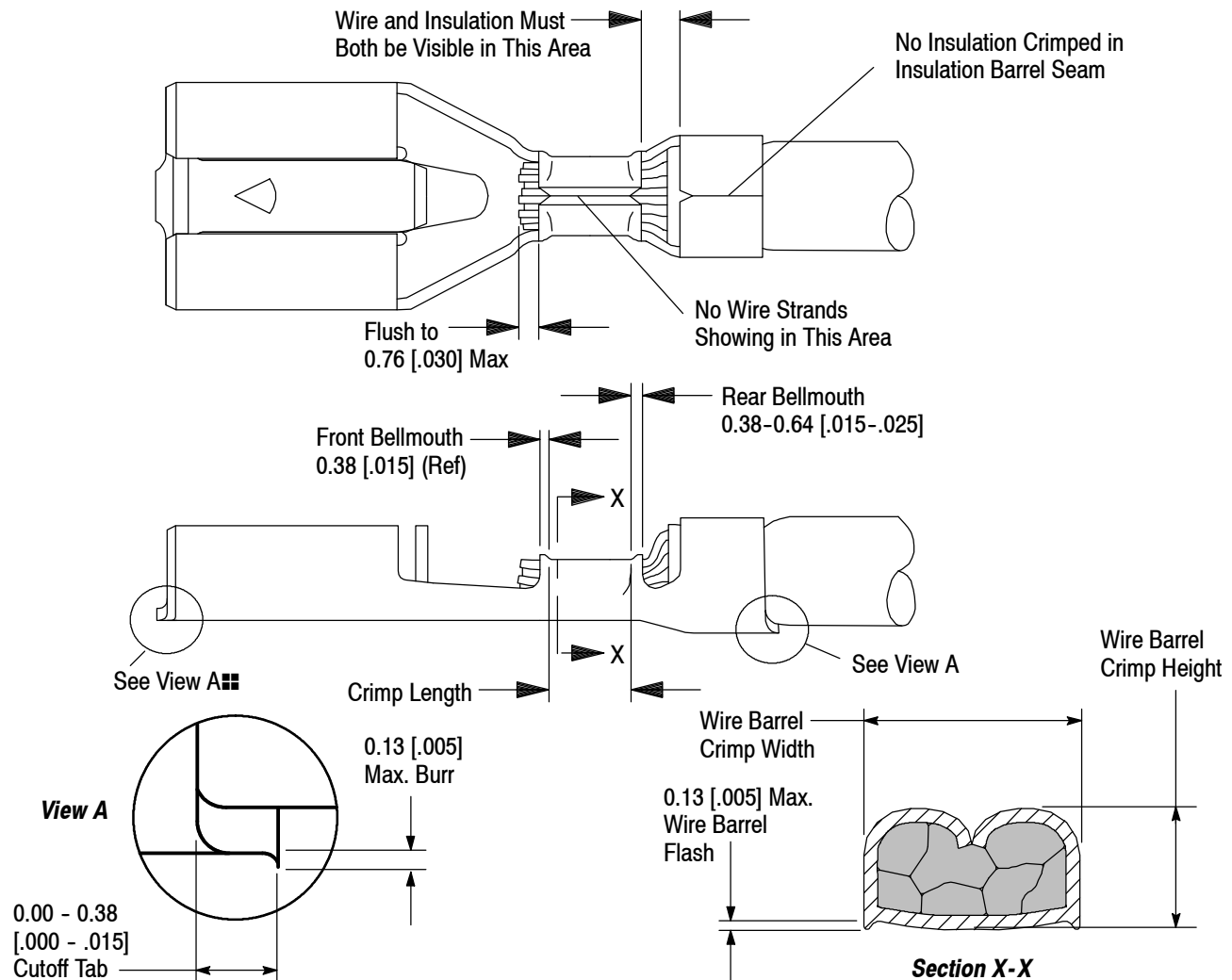
After crimping, the wire conductor and insulation must be visible in the transition area between the wire and insulation barrels.

H. Conductor Location

The conductor may extend beyond the wire barrel to the maximum shown in Figure 3.

I. Wire Barrel Seam

The wire barrel seam must be closed with no evidence of loose wire strands visible in the seam.



■ Also see Customer Drawings for front cutoff configuration.

Figure 3

J. Twist and Roll

There shall be no twist, roll, deformation or other damage to the mating portion of the crimped contact that will prevent proper mating. See Figure 4.

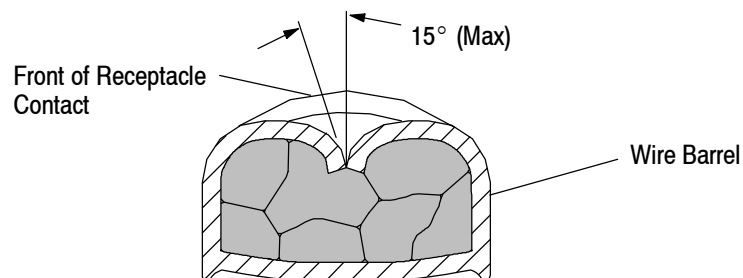


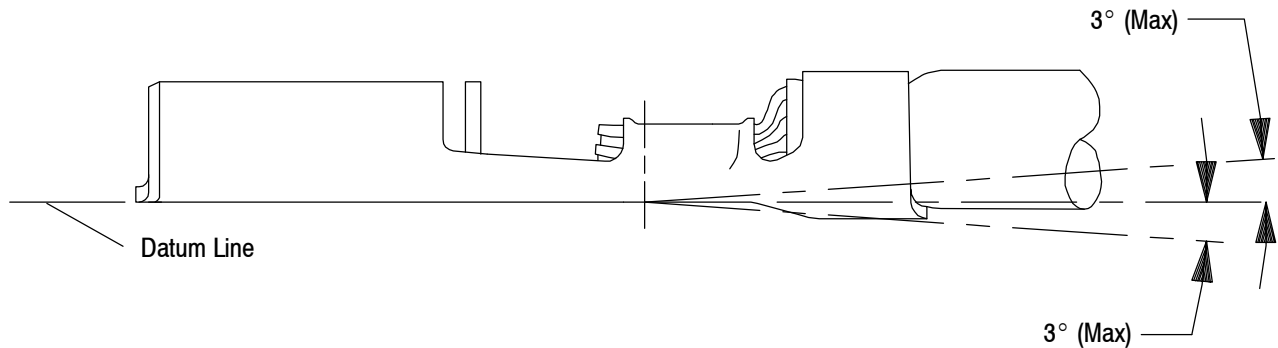
Figure 4

K. Straightness

The force applied during crimping may cause some bending between the crimped wire barrel and the mating portion of the contact. Such deformation is acceptable within the limits provided in Figures 5 and 6.

1. Up and Down

The crimped contact, including cutoff tab and burr, shall not be bent above or below the datum line more than the amount shown in Figure 5.



NOTE: Angles are drawn for clarification only and are not to scale.

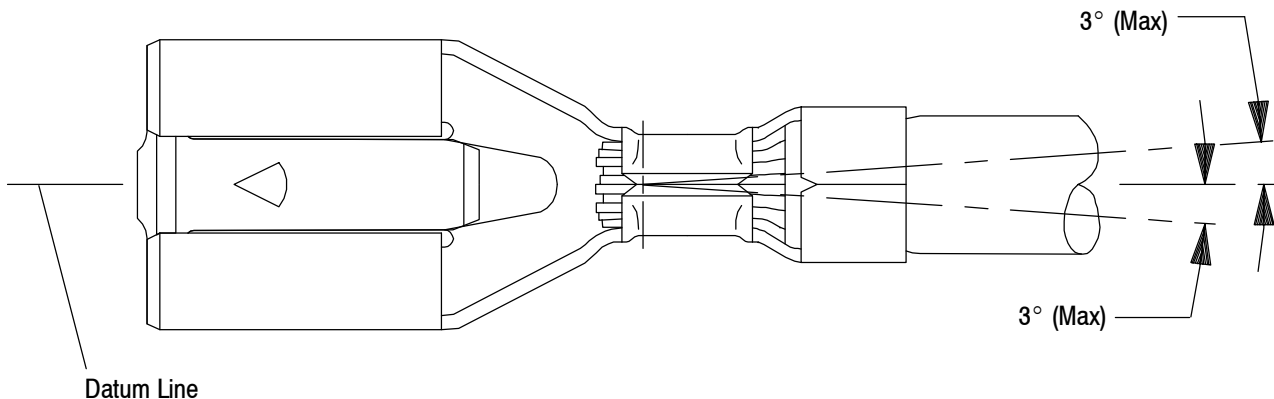
Figure 5

2. Side to Side

The side-to-side bending of the contact may not exceed the limits provided in Figure 6.

NOTE

Periodic inspections must be made to ensure crimped contact formation is consistent as shown.

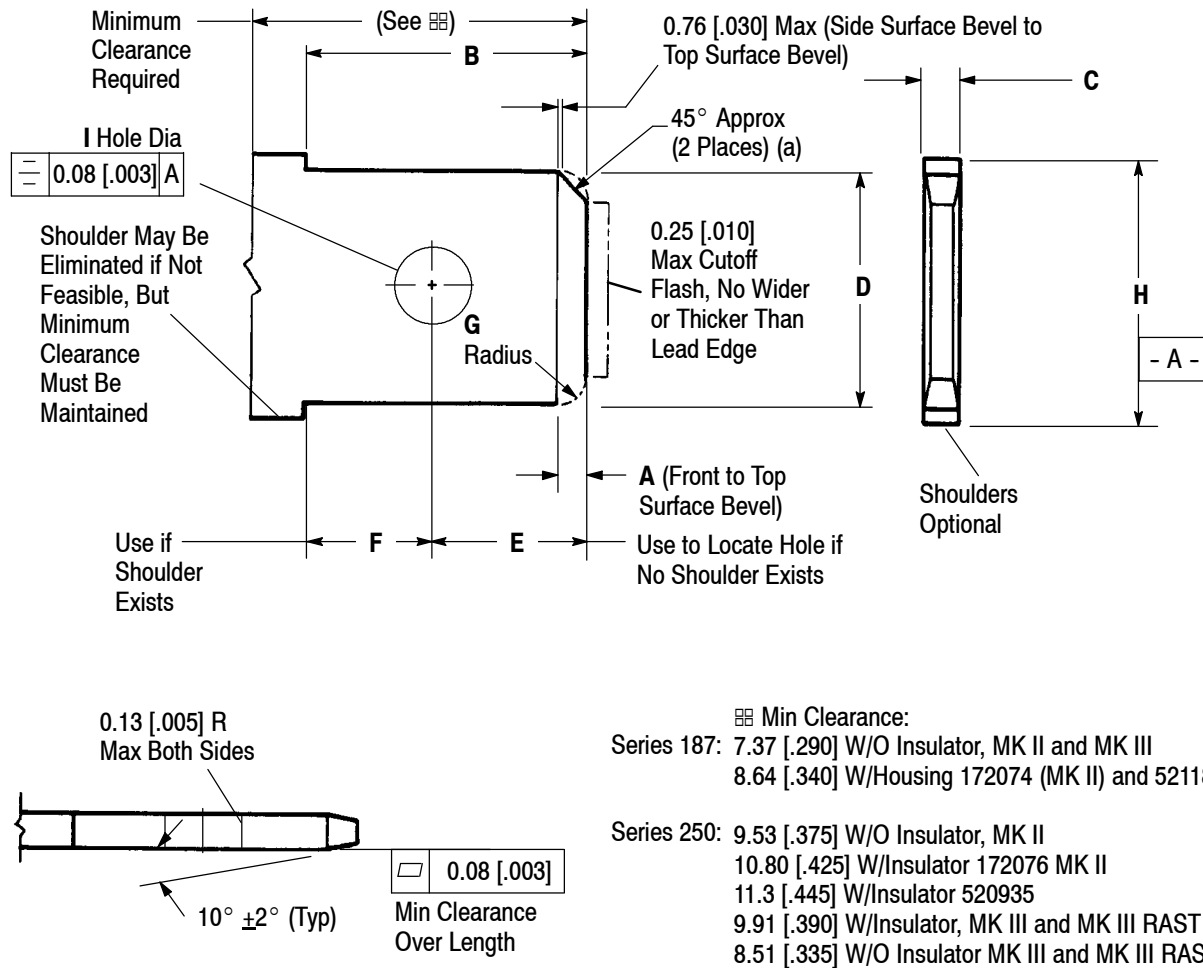


NOTE: Angles are drawn for clarification only and are not to scale.

Figure 6

3.5. Mating Tab Dimensions

Figure 7 shows features and dimensional requirements for tab terminals intended for mating with Series 187 and 250 Positive Lock Receptacle Contacts. The mating portion of the tab and clearance for applicable housings shall be manufactured to the dimensions shown in Figure 7.



TAB SIZE	A ± 0.13 [.005]	B ± 0.13 [.005]	C ± 0.03 [.001]	D ± 0.08 [.003]	E ± 0.20 [.008]	F ± 0.08 [.003]	G ± 0.51 [.020]	H (MIN)	I DIA
6.35 x 0.81 [.250 x .032]	1.02 [.040]	7.92 [.312]	0.81 [.032]	6.35 [.250]	4.52 [.178]	3.40 [.134]	1.27 [.050]	8.26 [.325]	1.65-2.03 [.065-.080]
4.75 x 0.51 [.187 x .020]	1.02 [.040]	6.35 [.250]	0.51 [.020]	4.75 [.187]	3.18 [.125]	3.18 [.125]	1.14 [.045]	5.41 [.213]	1.27-1.52 [.050-.060]
4.75 x 0.81 [.187 x .032]	1.02 [.040]	6.35 [.250]	0.81 [.032]	4.75 [.187]	3.18 [.125]	3.18 [.125]	1.14 [.045]	5.41 [.213]	1.27-1.52 [.050-.060]

NOTE(a) Bevel need not be a straight line if within confines as shown, or a radius of $G \pm 0.51$ [.020] may be substituted.

NOTE Dimensional measurements shall not include plating, burrs, or flatness tolerance.

Figure 7

3.6. Mating and Testing

NOTE



Testing may be done using a gage as described in *Residential Controls--Quick-Connect Terminals*, ANSI/NEMA No. DC2--1982.

The forces required to mate and unmate a test mating tab and receptacle shall be as specified in Figure 8. Measure the force using a testing device capable of holding the reading. It must also provide accurate alignment with slow and steady mating and unmating of the test tab and receptacle.

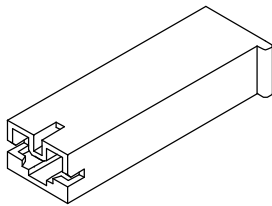
TAB SERIES	FORCE (NEWTONS [LBS])			
	FIRST MATING (MAXIMUM)	FIRST UNMATING (MINIMUM)		SIXTH UNMATING (MINIMUM)
		LOCKED	UNLOCKED	LOCKED
250	35.6 [8]	66.7 [15]	8.9 [2]	66.7 [15]
187 MK II	31.1 [7]	53.4 [12]	8.9 [2]	53.4 [12]
187 MK III	35.6 [8]	53.4 [12]	8.9 [2]	53.4 [12]
RAST 5 MK III (Per Circuit)	31.1 [7]	66.7 [15]	8.9 [2]	66.7 [15]

Figure 8

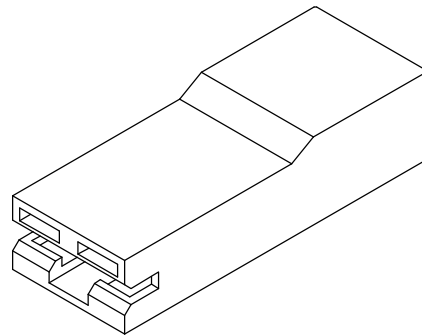
3.7. Housings

Series 187 and 250 Positive Lock Housings are available in single or multiple circuitry. These housings provide insulation and protection for the mating tabs and receptacles. See Figure 9.

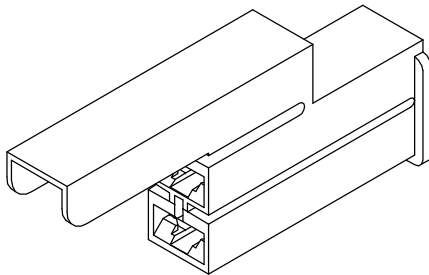
Single Circuit Series 187 Housing (Typ)



Single Circuit Series 250 Housing (Typ)



Multiple Circuit Series 187 Housing (Typ)



Multiple Circuit Series 250 Housing (Typ)

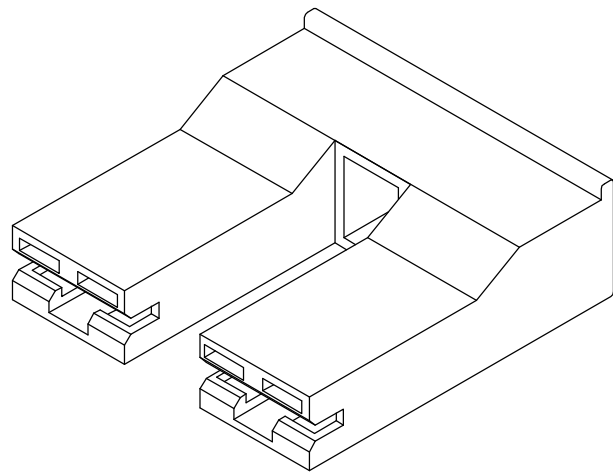


Figure 9

3.8. Assembly/Disassembly Procedures

A. Assembling Connector

The receptacle contact is inserted into the back of the connector until it bottoms. The contact is held in place by a contact retention latch designed inside the housing to prevent the contact from backing out. See Figure 10C. The contact is designed with a flexible locking dimple which acknowledges proper mating with an audible mechanical “snap” of the dimple into the hole in the mating tab. See Figure 10A.

B. Disassembling Connector

To release the lock, the release latch must be depressed. This is accomplished either with a thumb (Figure 10B), or a cam surface (Figure 10C and D), inside the housing. Unless the release latch is depressed either manually or with the optional designated area of the housing, the receptacle cannot be removed without damage force being applied.

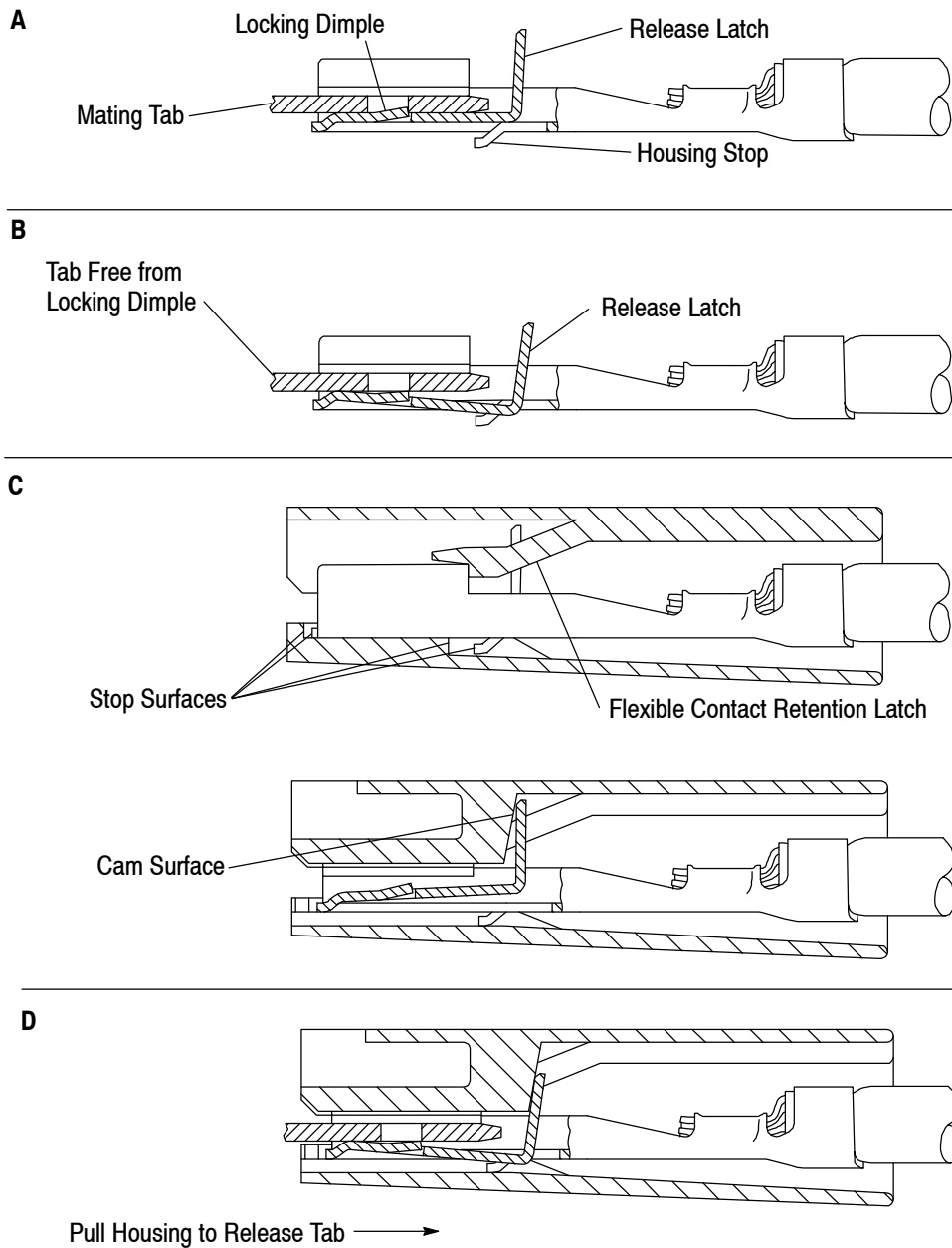


Figure 10

3.9. Repair/Replacement

Damaged crimped contacts or housings must be removed, discarded, and replaced with new components. Remove any damaged contacts with Extraction Tool 724659-[] with the information provided in Instruction Sheet 411-5106.



If a damaged contact is apparent before the contacts are inserted into the housing, cut the wire in back of the contact and reterminate the wire end. If contacts or housing are damaged after insertion, the wire must be cut directly in back of the housing and reterminated with new contacts and housing. See Section 5, TOOLING.

4. QUALIFICATIONS

Series 187, 250, and RAST 5 Positive Lock Receptacle Connectors are Recognized in the Component Program by Underwriters Laboratories Inc. (UL) in File E66717 and E28476; and Certified by CSA International in Report LR7189A. They are also applicable to all performance requirements as listed in UL Specification 310.

5. TOOLING

Figure 11 provides tool part numbers and instructional material related to wire size.

NOTE



Tyco Electronics Tool Engineers have designed machines for a variety of application requirements. For assistance in setting up prototype and production line equipment, contact Tyco Electronics Tool Engineering through your local Tyco Electronics Representative or call the Tooling Assistance Center number at the bottom of page 1.

• Applicators

Applicators are designed for the full wire size range of strip-fed, precision formed contacts, and provide for high volume, heavy duty production requirements. The applicators can be used in bench or floor model power units.

NOTE



Each applicator is shipped with a metal identification tag attached. DO NOT remove this tag or disregard the information on it. Also, a packet of associated paperwork is included in each applicator shipment. This information should be read before using the applicator; then it should be stored in a clean, dry area near the applicator for future reference. Some changes may have to be made to the applicators to run in all related power units. Contact the Tooling Assistance Center number located at the bottom of page 1 for specific changes.

• Power Units

A power unit is an automatic or semi-automatic device used to assist in the application of a product. Power unit includes the power source used to supply the force or power to an applicator.

NOTE



The Model "K" AMP-O-LECTRIC Terminating Machine PN 565435-5 has been superseded by the Model "G" Terminating Machine PN 354500-1 (409-5842) for new applications. For existing applications, the Model "K" is still recommended because of the large number of installed machines.

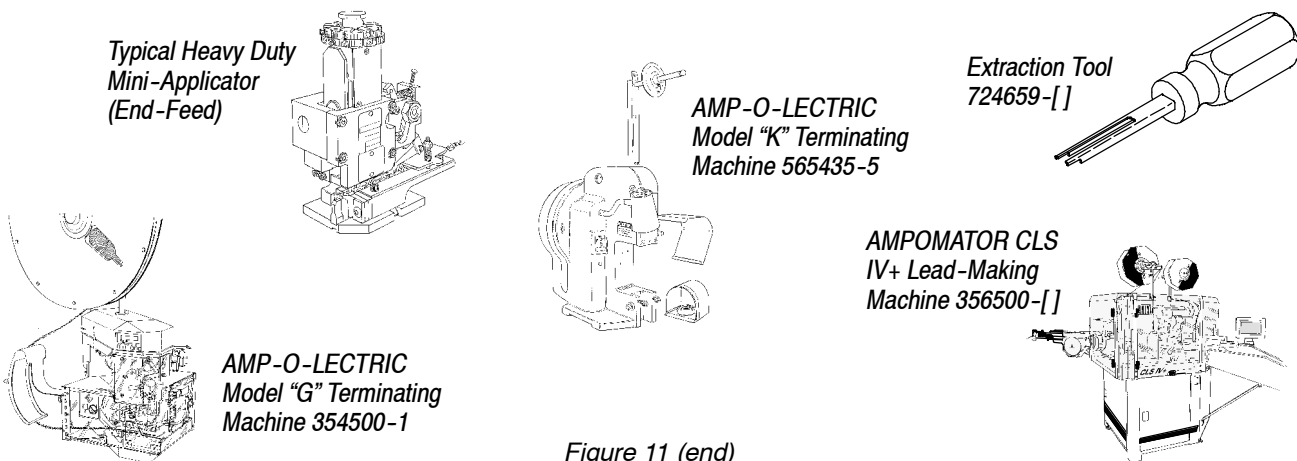
• Extraction Tools

Extraction Tools are designed to release the plastic locking lance inside the connector housing without damaging the housing or contacts.

SERIES SIZE	WIRE SIZE, AWG	INSULATION DIAMETER	APPLICATOR (408-8039)	POWER UNIT (DOCUMENT)
187 MK II	24-20	1.52-2.79 [.060-.110]	567110-2	354500-1 (409-5842) 565435-5 (409-5128)
	20-16	1.52-2.79 [.060-.110]	567366-2	
		2.29-3.30 [.090-.130]	567109-1	356500-[] (409-5878)
			567109-2	354500-1 (409-5842) 565435-5 (409-5128)
			567748-2, -3	354500-1 (409-5842)
			680141-1	356500-1 (409-5878)
			680141-2	354500-1 (409-5842) 565435-5 (409-5128)
187 MK III	22-18	2.29-3.30 [.090-.130]	680645-1	356500-[] (409-5878)
			680645-2	354500-1 (409-5842) 565435-5 (409-5128)
	18-14, (2) 18	3.81-5.08 [.150-.200] or 2@ 2.79 [.110] Max	680652-1	356500-[] (409-5878)
			680652-2	354500-1 (409-5842) 565435-5 (409-5128)

Figure 11 (cont'd)

SERIES SIZE	WIRE SIZE, AWG	INSULATION DIAMETER	APPLICATOR (408-8039)	POWER UNIT (DOCUMENT)
250 MK II	22-18	1.52-2.54 [.060-.100]	567064-1	356500-1 (409-5878)
			567064-2	354500-1 (409-5842) 565435-5 (409-5128)
	18-14	2.29-3.94 [.090-.155]	567049-1	356500-1 (409-5878)
			567049-2	354500-1 (409-5842) 565435-5 (409-5128)
			567528-1	356500-[] (409-5878)
			567528-2	354500-1 (409-5842)
	12-10	3.81-5.08 [.150-.200]	567132-1	356500-[] (409-5878)
			567132-2	354500-1 (409-5842) 565435-5 (409-5128)
250 MK III	22-18	1.52-2.54 [.060-.100]	680411-1	356500-1 (409-5878)
			680411-2	354500-1 (409-5842) 565435-5 (409-5128)
			680411-3	354500-[] (409-5842)
	18-14	2.29-3.94 [.090-.155]	680161-1	356500-[] (409-5878)
			680161-2	354500-1 (409-5842) 565435-5 (409-5128)
			680161-3	354500-[] (409-5842)
	(1) 16, (2) 18, (1) 16 and (1) 18, (2) 16	3.05-4.32 [.120-.170] or 2@ 3.05 [.120] Max	680646-1	356500-[] (409-5878)
			680646-2	354500-1 (409-5842) 565435-5 (409-5128)
RAST 5 250 MK III	22-18	1.52-2.79 [.060-.110]	1852165-1	356500-[] (409-5878)
			1852165-2	354500-1 (409-5842) 565435-5 (409-5128)
	18-14	2.29-3.94 [.090-.155]	680653-1	356500-[] (409-5878)
			680653-2	354500-1 (409-5842) 565435-5 (409-5128)
	(1) 16, (2) 18, (1) 16 and (1) 18, (2) 16	3.05-4.32 [.120-.170] or 2@ 3.05 [.120] Max	680654-1	356500-[] (409-5878)
			680654-2	354500-1 (409-5842) 565435-5 (409-5128)



6. VISUAL AID

Figure 12 shows a typical application of Series 187, 250, and RAST 5 Positive Lock Connector. This illustration should be used by production personnel to ensure a correctly applied product. Applications which DO NOT appear correct should be inspected using the information in the preceding pages of this specification and in the instructional material shipped with the product or tooling.

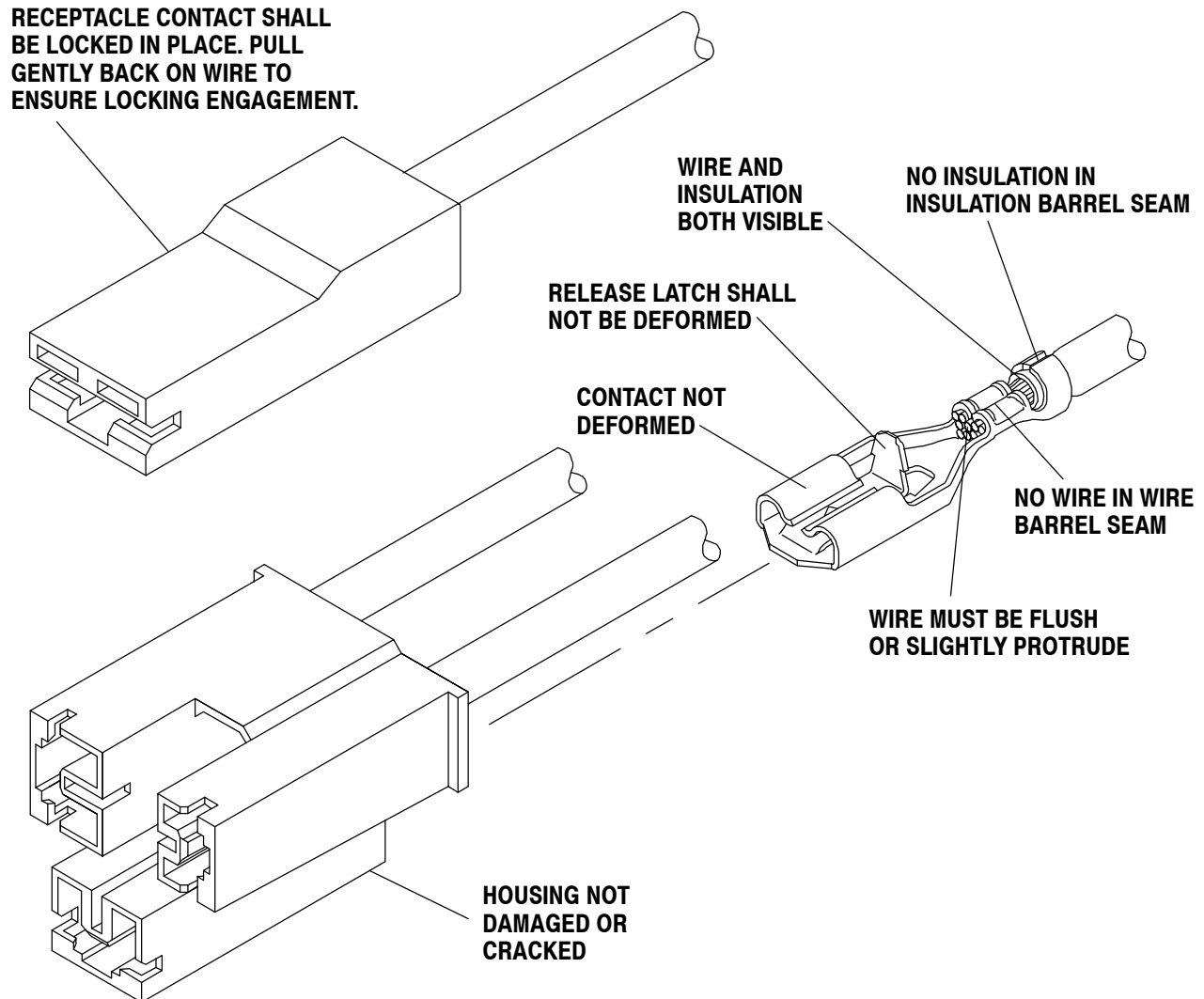


FIGURE 12. VISUAL AID