

Ring and Spade Terminals
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 Standard Ring and Spade Terminals, Flanged Spade Terminals, and Insulation Piercing Ring and Spade Terminals. These requirements are applicable to hand or automatic machine crimping tools.

When corresponding with Tyco Electronics 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.

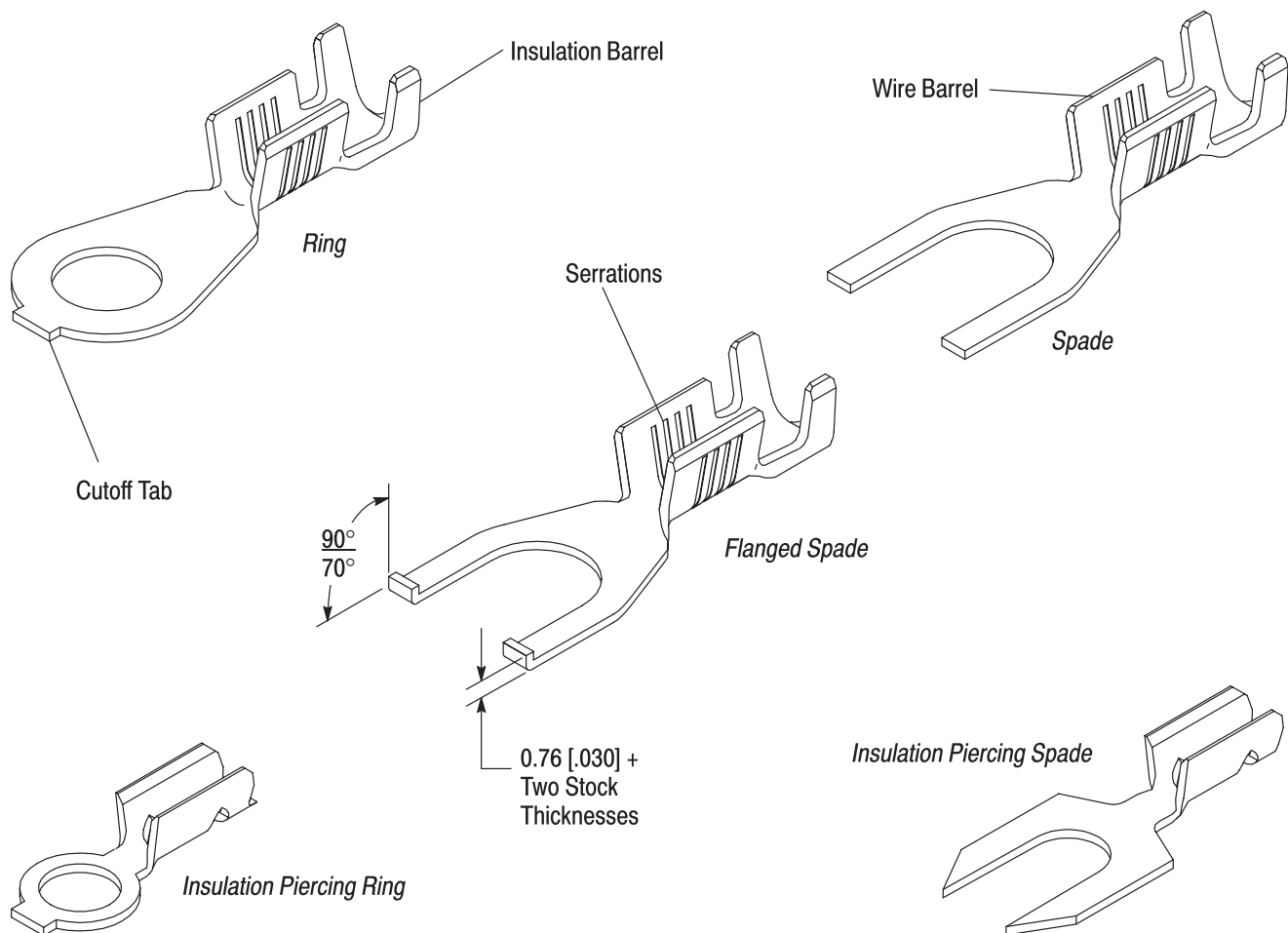


Figure 1

2. REFERENCE MATERIAL
2.1. Revision Summary

- Updated document to corporate requirements
- Added new NOTE to Section 5, TOOLING

2.2. Customer Assistance

Reference Product Part Numbers 41409 (Insulation Piercing), 60771 (Standard), 60775 (Flanged Spade) and Product Code 1170 are representative of Ring and Spade Terminals. 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 Tyco Electronics Representative or, after purchase, by calling the Product Information Center at the number at the bottom of page 1.

2.3. Drawings

Customer Drawings for product part numbers are available from 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



Because of the large amount of dies, hand tools, applicators, and power units used to terminate this product line, it is not feasible to list all the related tooling documents in this section. Related tooling documents are available through the service network and are also shipped with the specific application tooling.

Reference generic documents available which pertain to the application of this product are:

<u>Document Number</u>	<u>Document Title</u>
408-3295	Preparing Reel of Contacts for Application Tooling
408-7424	Checking Terminal Crimp Height or Gaging Die Closure
408-8053	Conversion Guide for Miniature Quick-Change Applicators
408-8059	General Preventative Maintenance for Applicators
408-9816	Handling of Reeled Products

3. REQUIREMENTS

3.1. Storage

A. Ultraviolet Light

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

B. Reeled Terminals

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

C. Shelf Life

The terminals should remain in the shipping containers until ready for use to prevent deformation to the terminals. The terminals 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 terminals near any chemicals listed below, as they may cause stress corrosion cracking in the terminals.

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



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

3.2. Materials

A variety of materials are available in this product line. Contact the Product Information Center at the number at the bottom of page 1 for specific metals and platings available for your production needs.

3.3. Wire Size and Preparation

The terminals will accept a wide range of stranded wire sizes. Contact the Product Information Center at the number at the bottom of page 1 for specific wire size ranges available for your production needs.

A. Standard and Flanged Spade Wire Preparation

Insulation shall be stripped as indicated in Figure 2 and is based on wire barrel length which may be found on the product customer drawing.

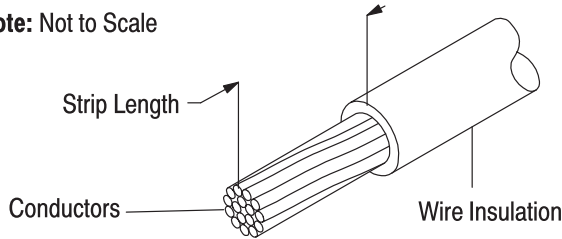


DO NOT nick, scrape, or cut the wire conductors during the stripping operation. Filaments of insulation material remaining after stripping should be avoided and shall never extend among the bare conductors.

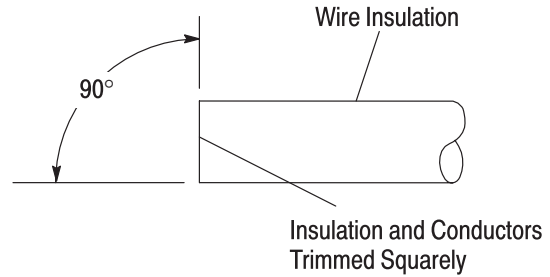
B. Insulation Piercing Wire Preparation

Wire shall be trimmed cleanly and squarely. Due to the insulation piercing technique employed in crimping the terminal, it is not necessary to strip the insulation from the wire. See Figure 2.

Note: Not to Scale



Standard Ring and Spade or Flanged Spade Terminals



Insulation Piercing Ring and Spade Terminals

TERMINAL STYLE	WIRE BARREL LENGTH	WIRE STRIP LENGTH
STANDARD RING AND SPADE TERMINALS OR FLANGED SPADE TERMINALS	2.36-2.74 [.093-.108]	3.18 [.125]
	2.77-3.58 [.109-.141]	3.96 [.156]
	3.61-4.42 [.142-.174]	4.78 [.188]
	4.44-5.26 [.175-.207]	5.56 [.219]
	5.28-6.10 [.208-.240]	6.35 [.250]
	6.12-6.93 [.241-.273]	7.14 [.281]
INSULATION PIERCING TERMINALS	---	---

Figure 2

3.4. Crimped Terminal Requirements

The terminal shall be located in desired tooling and crimped according to the instructions packaged with that tooling. See Section 5, TOOLING, of this document for details on tooling options.



The applied crimp dimension (within the functional range of the product) is dependent on the termination tooling being used. Refer to the documentation (applicator logs and instruction sheets) supplied with the termination tooling for the applied crimp height.



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

A. Wire Barrel Crimp

The crimp applied to the wire portion of the terminal is the most compressed area and is most critical in ensuring optimum electrical and mechanical performance of the crimped terminal. The terminal wire barrel crimp height must be within the dimension provided on the application tooling documentation.

B. Effective Crimp Length

For optimum crimp effectiveness, the crimp must be within the area shown in Figure 3 and must meet the crimp dimensions provided in the application tooling documentation. 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.

C. Bellmouths

Front and rear bellmouth shall be as shown and conform to the dimensions given in Figure 3.

D. Cutoff Tabs

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

NOTE: Ring Terminal Shown, Other Terminals Have Same Dimensions

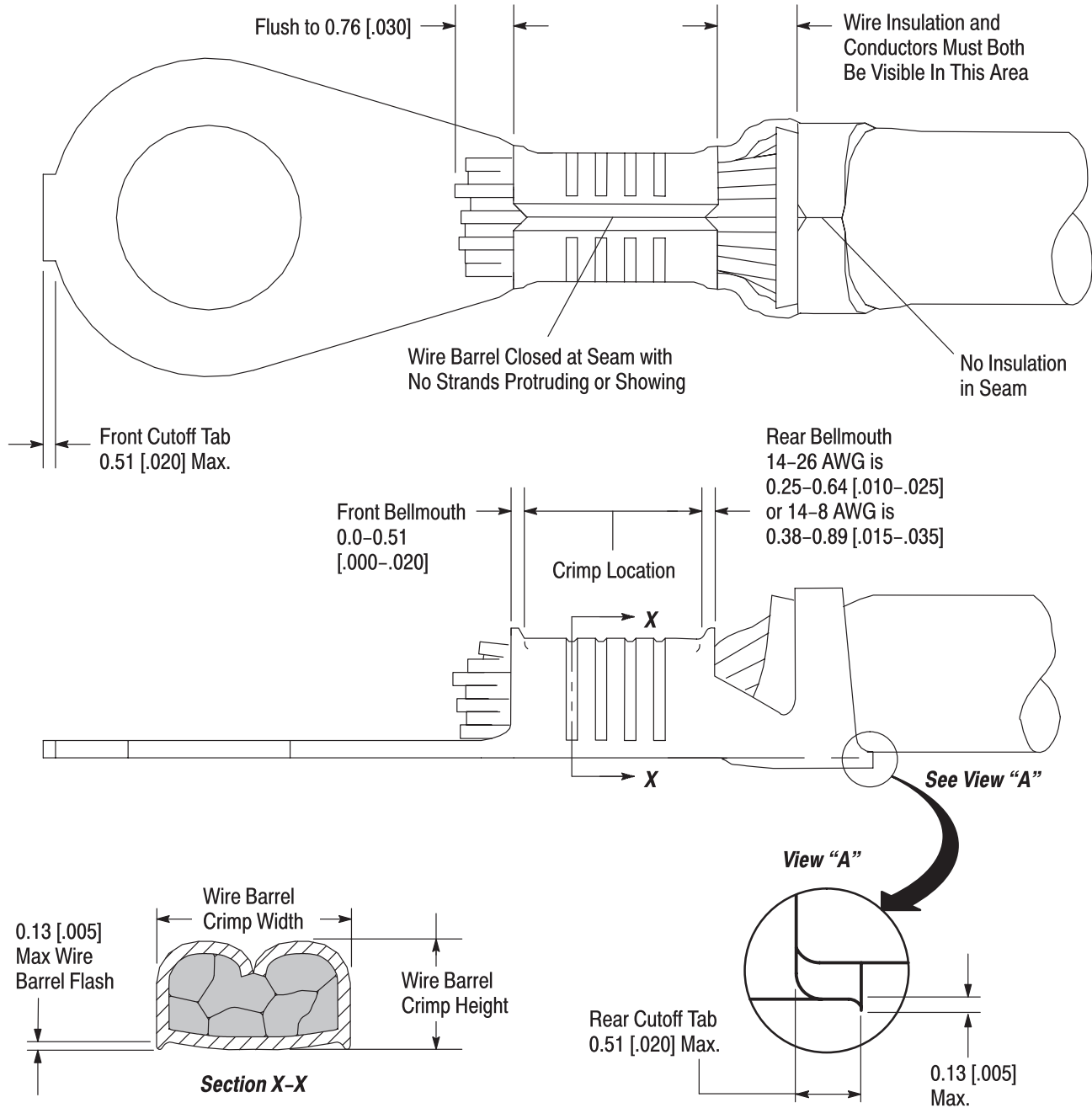


Figure 3

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, Section X–X.

G. Insulation Barrel Crimp

The insulation barrel shall grip the insulation firmly without fully cutting into it. Care must be taken to prevent cutting, nicking, or scraping of the insulation. Insulation crimp shall comply to width dimensions provided in the application tooling documentation.

H. Wire Location

The wire conductor and insulation must be visible in the transition area between the wire and insulation barrels as shown in Figure 3.

I. Conductor Extension

The conductor may extend beyond the wire barrel to the maximum shown. No strands may extrude over the height of the conductor crimp. See Figure 3.

J. Wire Barrel Seam

The wire barrel seam must be closed with no evidence of loose wire strands visible in the seam. See Figure 3.

K. Twist and Roll

Twist or roll of the crimped terminal shall not exceed the limits specified in Figure 4.

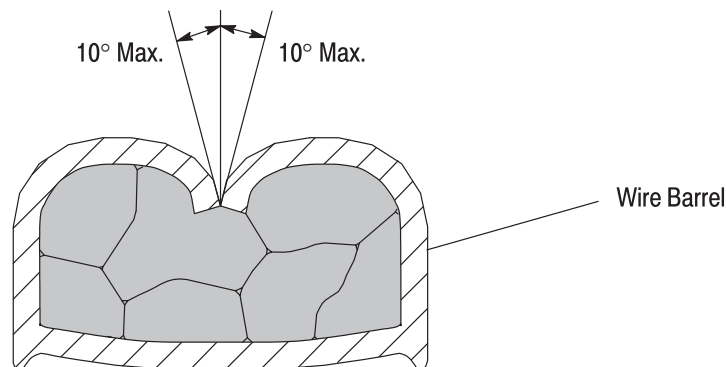


Figure 4

L. Straightness

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

1. The up and down bend of the crimped terminal, including cutoff tab and burr, shall not be bent above or below the datum line more than the amount shown.
2. The side-to-side bend of the terminal may not exceed the limits provided.

CAUTION

Damaged terminals may not be used. If a damaged terminal is evident, it must be removed from the wire and replaced with a new one.

NOTE

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

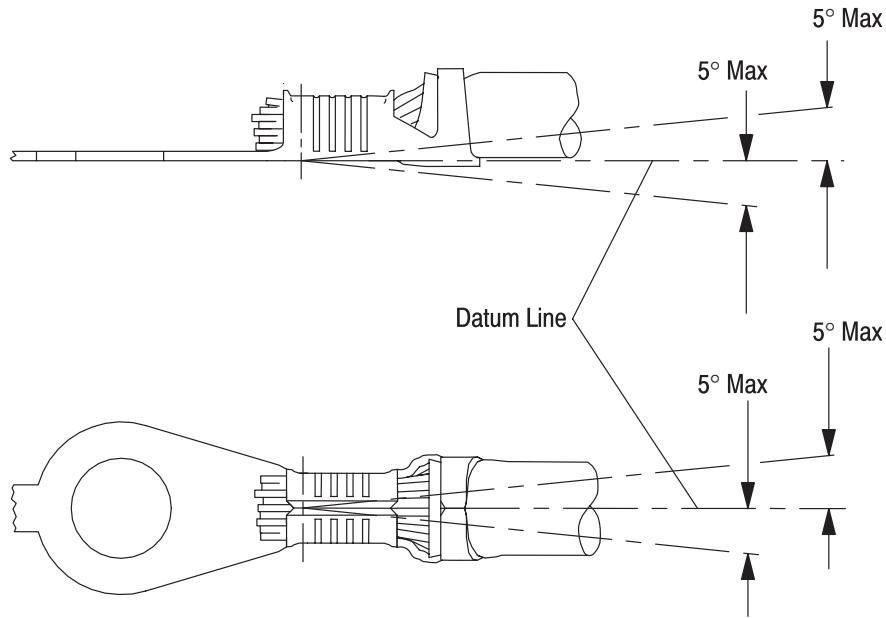


Figure 5

4. QUALIFICATION

Contact Tyco Electronics Product Engineering for agency approval information.

5. TOOLING

NOTE


Because of the large amount of product variations and application tooling available, it is not feasible to list all the tooling on this document. Contact Tyco Electronics using the phone numbers listed at the bottom of page 1 for specific dies, hand tools, applicators, and power units to fit your production needs and requirements.

NOTE


Lubrication is required when terminating any steel or stainless steel terminals.

This section provides information on tools for various application requirements.

- **Crimping Die Assemblies**

Crimping Die Assemblies for crimping the terminals are available for the full wire size range. They are designed for easy installation and removal in hand crimping tool frame assemblies or applicators.

- **Hand Tools**

Hand crimping tools are designed for prototype, low-volume applications, and repair.

- **Applicators**

Applicators are designed for the full wire size range of terminals, 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 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


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

6. VISUAL AID

Figure 6 shows a typical application of Ring and Spade Terminals. 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.

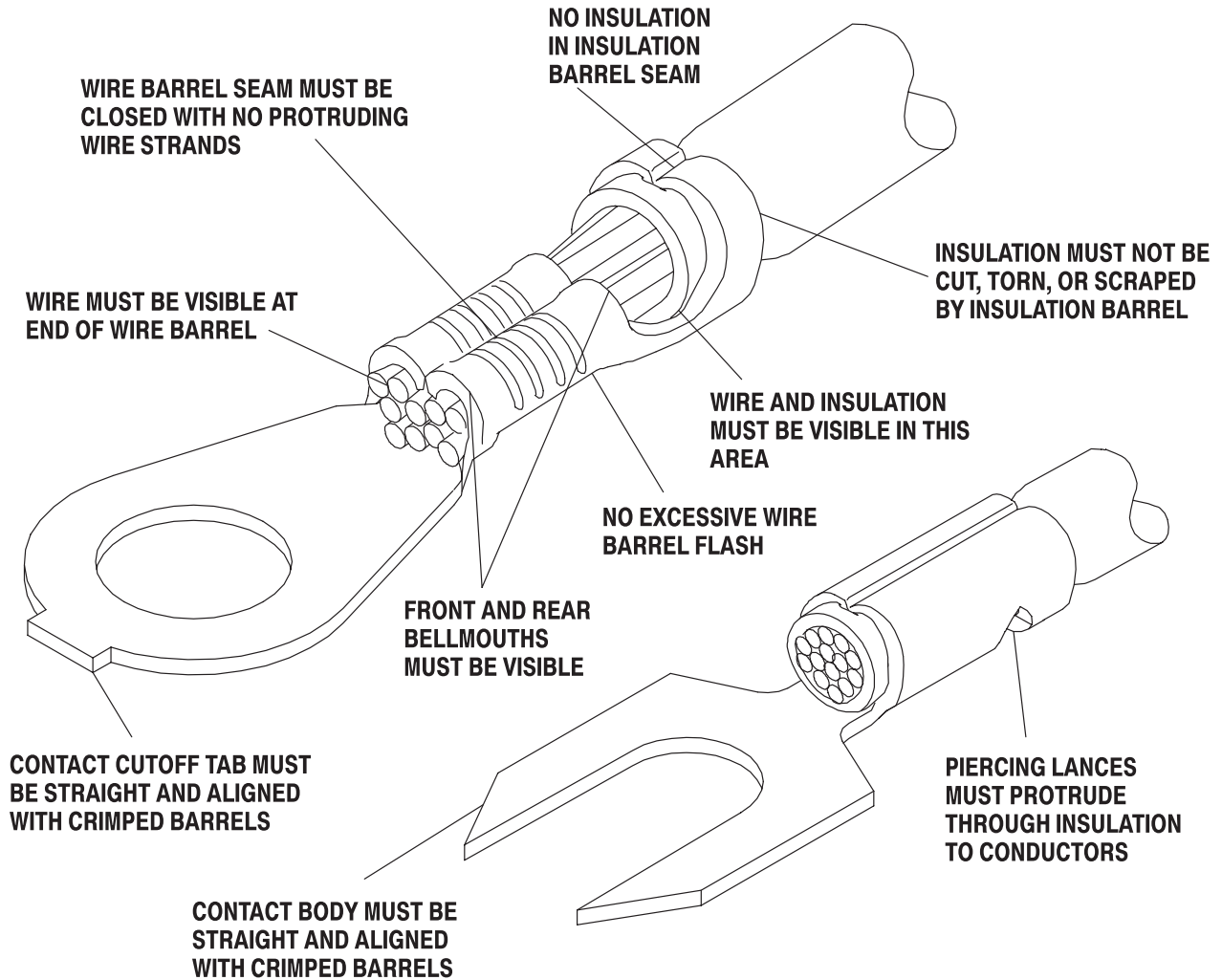


FIGURE 6. VISUAL AID