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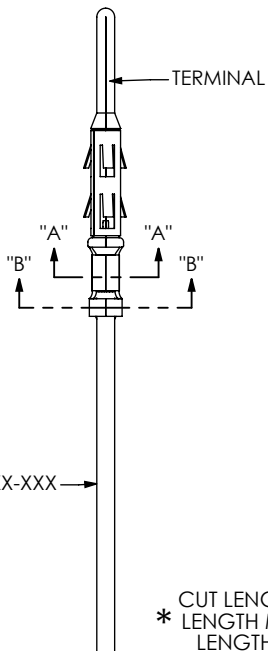
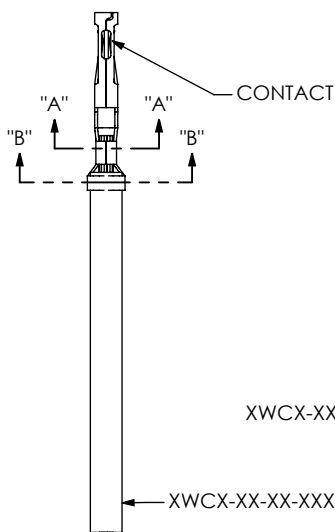


FIG 1

CUT LENGTH IS ASSEMBLY \* LENGTH MINUS OVERALL LENGTH SUBTRACTOR

**FOR CRIMP INSPECTION CALLOUTS**  
 CONTACT/TERMINAL - LEAD STYLE - CRIMP - AWG - CABLE TYPE  
 SEE TABLE 1  
 FOR EXAMPLE, IF INSPECTING A CRIMP OF C-179-02-X WITH 26AWG DWC, THE CALLOUT FOR INSPECTION WOULD BE "C-179-02-CRIMP-26-DWC"

SERIES	"F"	"G"	"H"
MMSSX / MMSDX	0.250	0.500	N/A
MMTSX / MMTDX	0.464	N/A	0.714
MPSS	0.300	0.600	N/A
PMSSX / PMSDX	0.427	0.854	N/A
S2SDX	0.224	0.448	N/A
SFSSX / SFSDX	0.249	0.498	N/A
T2SDX	0.375	0.750	0.600
TFSSX / TFSDX	0.400	0.800	0.675
PESS	0.623	1.246	N/A
S1SX	0.110	0.220	N/A
SMSX	0.250	0.500	N/A
MPCC	SIGNAL WIRE	0.238	0.476
	POWER WIRE	0.312	0.624

CUT CABLE	DEPTH/DIMENSION
BWC-01-04-01	0.55[14MM]
BWC-01-16-01	1.34[34MM]
BWC-02-10-01	0.71[18MM]
BWC-02-32-01	1.18[30MM]
BWC-05-14-01	0.31[18MM]
UCA-01-01	0.47[12MM]
UCA-02-01	0.55[14MM]
UCA-03-01	0.63[16MM]
ECA-01-01	0.79[19MM]
ECA-02-02	0.79[19MM]
SCTP-05-02	0.83[21MM]
SCTP-08-02	1.10[28MM]
LSPC-26100-05-P5-H	1.10[28MM]
LSPC-26100-08-H	1.26[32MM]
LSPC-26100-12-H	1.57[40MM]
STCP-08-01	0.91[23MM]
SCTP-12-01	1.06[27MM]
SCTP-16-01	1.18[30MM]
SCTP-24-01	1.42[36MM]
LSPC-30100-05-P5-H	0.79[20MM]
LSPC-26100-09	1.18[30MM]
LSPC-26100-08-P5-H	1.18[30MM]
LSPC-26100-08	1.10[28MM]
LSPC-26100-12	1.26[32MM]

Contact / Terminal	"A" -MA +/-	"A" -HT +/-	"B" +/-	"C" +/-	"D" +/-
C169	.0010	.0020	0.003	*	*
C179	.0010	.0020	0.003	*	*
CC20 and C198	.0010	.0020	0.003	*	*
T1R31	.0010	.0020	0.003	*	*
CC62	.0010	.0020	0.003	*	*
CT62	.0010	.0020	0.003	*	*
T1M44	.0010	.0020	0.003	*	0.001
C203	.0010	.0020	0.003	*	*
C246	.0010	.0020	0.003	*	*
C281	.0010	.0020	0.003	*	*
T-1M74	.0010	.0020	0.003	*	*
T-1M82	.0010	.0020	0.003	*	*
C-310	.0020	.0020	0.003	*	*
C-309	.0010	.0020	0.003	*	*
C-383	.0010	.0020	0.003	*	*

\*block tolerance

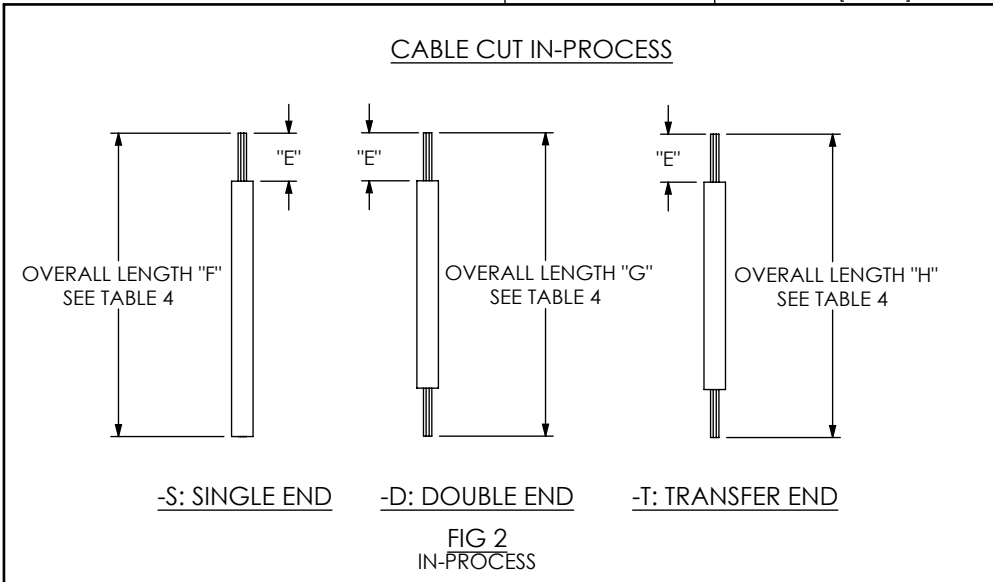


FIG 2 IN-PROCESS

- NOTES:
1. REPRESENTS A CRITICAL DIMENSION.
  2. ALL CRIMP AND STRIP DIMENSIONS SHOWN SHALL SUPERCEDE ANY EQUIVALENT SPECIFICATIONS THAT ARE SUPPLIED BY TOOLING MANUFACTURER.
  3. FOR LENGTHS LESS THAN 12 IN, TOLERANCE SHALL BE +/- .125. FOR OTHER LENGTHS, TOLERANCE SHALL BE +/- 2%.
  4. MAXIMUM BURR ALLOWANCE: .003 [.08]

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE: DECIMALS ANGLES .XX: ±.01 [.3] 2° .XXX: ±.005 [.13] .XXXX: ±.0020 [.051]	PROPRIETARY NOTE THIS DOCUMENT CONTAINS INFORMATION CONFIDENTIAL AND PROPRIETARY TO SAMTEC, INC. AND SHALL NOT BE REPRODUCED OR TRANSFERRED TO OTHER DOCUMENTS OR DISCLOSED TO OTHERS OR USED FOR ANY PURPOSE OTHER THAN THAT WHICH IT WAS OBTAINED WITHOUT THE EXPRESSED WRITTEN CONSENT OF SAMTEC, INC.	 520 PARK EAST BLVD., NEW ALBANY, IN 47150 PHONE: 812-944-6733 FAX: 812-948-5047 e-Mail: info@SAMTEC.com code: 55322
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TABLE 1: CRIMP AND STRIP DIMENSIONS

CONTACT	TERMINAL	AWG	CABLE	"A"		"B"		"C"		"D"		"E" (Strip Length)	
				IN	mm	IN	mm	IN	mm	IN	mm	IN	mm
C-169-02-XX-X		-24	DWC-24-10-300	0.0370	0.940	0.0580	1.473	0.075	1.91	0.077	1.96	0.128	3.25
		-22	DWC-22-10-300	0.0390	0.991	0.0580	1.473	0.075	1.91	0.073	1.85	0.128	3.25
		-20	DWC-20-10-300	0.0410	1.041	0.0580	1.473	0.075	1.91	0.075	1.91	0.128	3.25
C-169-03-XX-X		-20	DWC-20-10-600	0.0470	1.194	0.0740	1.880	0.120	3.05	0.125	3.18	0.115	2.92
		-18	DWC-18-10-600	0.0520	1.321	0.0740	1.880	0.125	3.18	0.135	3.43	0.115	2.92
		-16	DWCT-16-10-600	0.0620	1.575	0.0740	1.880	0.135	3.43	0.135	3.43	0.128	3.25
C-169-04-XX-X		-24	DWCT-24-02	0.0370	0.940	0.0580	1.473	0.054	1.37	0.064	1.63	0.128	3.25
C-179-02-X		-30	DWC-30-10-300	0.0250	0.635	0.0430	1.092	0.052	1.32	0.057	1.45	0.133	3.38
		-28	DWC-28-10-300	0.0260	0.660	0.0430	1.092	0.050	1.27	0.057	1.45	0.133	3.38
		-26	DWC-26-10-300	0.0270	0.686	0.0430	1.092	0.055	1.40	0.057	1.45	0.133	3.38
C-179-03-X		-24	DWCT-24-01	0.0280	0.711	0.0570	1.448	0.054	1.37	0.070	1.78	0.133	3.38
		-22	DWC-22-10-300	0.0340	0.864	0.0570	1.448	0.081	2.06	0.075	1.91	0.128	3.25
		-20	DWC-20-10-300	0.0360	0.914	0.0570	1.448	0.083	2.11	0.075	1.91	0.128	3.25
C-179-04-X		-24	DWCT-20-01	0.0360	0.914	0.0570	1.448	0.081	2.06	0.076	1.93	0.128	3.25
		-24	BWC-02-XX-01	0.0310	0.787	0.0570	1.448	0.075	1.91	0.075	1.91	0.128	3.25
		-30	DWCT-30-01	0.0250	0.635	0.0430	1.092	0.047	1.19	0.056	1.42	0.128	3.25
C-198-2024-01-X	T-1R31-2024-01-XX	-28	DWCT-28-01	0.0260	0.660	0.0430	1.092	0.048	1.22	0.056	1.42	0.128	3.25
		-24	DWC-24-10-300	0.0280	0.711	0.0580	1.473	0.072	1.83	0.063	1.60	0.098	2.49
		-24	BWC-02-XX-01	0.0280	0.711	0.0580	1.473	0.067	1.70	0.063	1.60	0.098	2.49
C-198-2428-01-X	T-1R31-2428-01-XX	-22	DWC-22-10-300	0.0310	0.787	0.0580	1.473	0.072	1.83	0.066	1.68	0.098	2.49
		-20	DWC-20-10-300	0.0360	0.914	0.0580	1.473	0.082	2.08	0.066	1.68	0.098	2.49
		-28	DWC-28-10-300	0.0320	0.813	0.0480	1.219	0.055	1.40	0.054	1.37	0.098	2.49
C203-2830-XX		-26	DWC-26-10-300	0.0320	0.813	0.0480	1.219	0.060	1.52	0.062	1.57	0.098	2.49
		-30	DWCT-30-01	0.0180	0.457	0.0300	0.762	0.037	0.94	0.039	0.99	0.095	2.41
		-30	DWC-30-10-300	0.0160	0.406	0.0300	0.762	0.045	1.14	0.038	0.97	0.095	2.41
C-246-01-X		-28	DWC-28-10-300	0.0180	0.457	0.0300	0.762	0.045	1.14	0.038	0.97	0.095	2.41
		-28	DWCT-28-01	0.0200	0.508	0.0300	0.762	0.037	0.94	0.039	0.99	0.095	2.41
		-28	BWC-05-XX-01	0.0180	0.457	0.0300	0.762	0.045	1.14	0.038	0.97	0.095	2.41
C-281-2830-XX		-16	DWC-16-10-600	0.0680	1.727	0.1100	2.794	0.145	3.68	0.160	4.06	0.197	5.00
		-14	DWC-14-10-600	0.0750	1.905	0.1100	2.794	0.160	4.06	0.160	4.06	0.197	5.00
C-281-2426-XX		-30	DWC-30-XX-300	0.0170	0.432	0.0330	0.838	0.035	0.89	0.042	1.07	0.125	3.18
		-30	DWCT-30-01	0.0170	0.432	0.0330	0.838	0.035	0.89	0.042	1.07	0.125	3.18
		-28	DWC-28-XX-300	0.0180	0.457	0.0330	0.838	0.040	1.02	0.042	1.07	0.125	3.18
CC20X-2024-01-XX		-28	DWCT-28-01	0.0180	0.457	0.0330	0.838	0.040	1.02	0.042	1.07	0.125	3.18
		-26	DWC-26-XX-300	0.0230	0.584	0.0330	0.838	0.057	1.45	0.055	1.40	0.125	3.18
		-24	DWCT-24-01	0.0280	0.711	0.0330	0.838	0.055	1.40	0.055	1.40	0.125	3.18
CC62-1618-01-XX	CT62-1618-01-XX	-24	DWC-24-XX-300	0.0280	0.711	0.0330	0.838	0.066	1.68	0.055	1.40	0.125	3.18
		-22	DWC-22-10-300	0.0310	0.787	0.0580	1.473	0.073	1.85	0.066	1.68	0.058	1.47
CC62-2024-01-XX	CT62-2024-01-XX	-24	DWC-24-10-300	0.0280	0.711	0.0580	1.473	0.071	1.80	0.064	1.63	0.098	2.49
		-18	DWC-18-10-300	0.0550	1.397	0.0900	2.286	0.160	4.06	0.160	4.06	0.148	3.76
C-310-1012-X		-16	DWC-16-10-300	0.0560	1.422	0.0950	2.413	0.113	2.87	0.118	3.00	0.128	3.25
C-309-01-XX		-22	DWC-22-10-300/BWC-01-04-01/BWC-01-16-01	0.0380	0.965	0.0660	1.676	0.072	1.83	0.087	2.21	0.148	3.76
		-24	BWC-02-XX-01	0.0280	0.711	0.0580	1.473	0.055	1.40	0.063	1.60	0.128	3.25
C-310-1012-X		-10	DWC-10-10-600	0.1050	2.667	0.1360	3.454	0.193	4.90	0.225	5.72	0.200	5.08
		-12	DWC-12-10-600	0.1030	2.616	0.1360	3.454	0.188	4.78	0.225	5.72	0.200	5.08
C-309-01-XX		-28	DWC-28N-XX-300	0.0165	0.419	0.0277	0.704	0.0385	0.9779	0.0315	0.80	0.059	1.50
		-30	DWC-30-XX-300	0.0160	0.406	0.0277	0.704	0.0385	0.9779	0.0315	0.80	0.059	1.50

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DESCRIPTION:  
**CRIMP/STRIP SPECIFICATIONS**

DWG. NO.  
**CRIMP SPECIFICATIONS**

BY: D.SCHMELZ 10-11-2010 SHEET 2 OF 4

TABLE 1: CRIMP AND STRIP DIMENSIONS (CONTINUED)

TERMINAL	AWG	CABLE	"A"		"B"		"C"		"D"		"E" (STRIP LENGTH)	
			IN	mm	IN	mm	IN	mm	IN	mm	IN	mm
C-383-2428-X	-24	DWC-24-100-300	0.0310	0.787	0.0530	1.346	0.075	1.91	0.075	1.91	0.098	2.490
	-26	DWC-26-100-300	0.0270	0.686	0.0430	1.092	0.055	1.40	0.052	1.32	0.098	2.490
	-28	DWC-28-100-300	0.0260	0.660	0.0430	1.092	0.050	1.27	0.052	1.32	0.098	2.490
T-1M44-2830-XX	-30	DWC-30-10-300	0.0170	0.432	0.0300	0.762	0.0450	1.14	0.0380	0.97	0.095	2.41
	-30	DWCT-30-01	0.0170	0.432	0.0300	0.762	0.0390	0.99	0.0420	1.07	0.095	2.41
	-28	BWC-05-14-01	0.0200	0.508	0.0300	0.762	0.0450	1.14	0.0380	0.97	0.095	2.41
	-28	DWC-28-10-300	0.0190	0.483	0.0300	0.762	0.0450	1.14	0.0380	0.97	0.095	2.41
	-28	DWCT-28-01	0.0190	0.483	0.0300	0.762	0.0390	0.99	0.0440	1.12	0.095	2.41
T-1M74-01-X	-30	DWC-30-10-300	0.0200	0.508	0.0330	0.838	0.045	1.14	0.052	1.32	0.128	3.25
	-28	DWC-28-10-300	0.0210	0.533	0.0330	0.838	0.050	1.27	0.052	1.32	0.128	3.25
	-26	DWC-26-10-300	0.0230	0.584	0.0330	0.838	0.055	1.40	0.052	1.32	0.128	3.25
T1M74-02-X	-24	DWCT-24-01	0.0270	0.686	0.0430	1.092	0.054	1.37	0.070	1.78	0.128	3.25
	-24	DWC-24-10-300	0.0270	0.686	0.0430	1.092	0.075	1.91	0.075	1.91	0.128	3.25
	-22	DWC-22-10-300	0.0310	0.787	0.0430	1.092	0.081	2.06	0.075	1.91	0.128	3.25
	-20	DWC-20-10-300	0.0380	0.965	0.0430	1.092	0.083	2.11	0.075	1.91	0.128	3.25
	-20	DWCT-20-01	0.0380	0.965	0.0430	1.092	0.076	1.93	0.075	1.91	0.128	3.25
T1M74-03-X	-30	DWCT-30-01	0.0200	0.508	0.0330	0.838	0.026	0.66	0.052	1.32	0.128	3.25
	-28	DWCT-28-01	0.0210	0.533	0.0330	0.838	0.028	0.71	0.052	1.32	0.128	3.25
T-1M82-2830-XX	-30	DWC-30-XX-300	0.0170	0.432	0.0330	0.838	0.035	0.89	0.042	1.07	0.125	3.18
	-30	DWCT-30-011	0.0170	0.432	0.0330	0.838	0.035	0.89	0.042	1.07	0.125	3.18
	-28	DWCT-28-01	0.0180	0.457	0.0330	0.838	0.040	1.02	0.042	1.07	0.125	3.18
	-28	DWC-28-XX-300	0.0180	0.457	0.0330	0.838	0.040	1.02	0.042	1.07	0.125	3.18
T-1M82-2426-XX	-26	DWC-26-XX-300	0.0230	0.584	0.0330	0.838	0.057	1.45	0.055	1.40	0.125	3.18
	-24	DWCT-24-01	0.0280	0.711	0.0330	0.838	0.055	1.40	0.055	1.40	0.125	3.18
	-24	DWC-24-XX-300	0.0280	0.711	0.0330	0.838	0.066	1.68	0.055	1.40	0.125	3.18

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DESCRIPTION:  
 CRIMP/STRIP SPECIFICATIONS

DWG. NO.  
**CRIMP SPECIFICATIONS**

BY: D.SCHMELZ 10-11-2010 SHEET 3 OF 4

TABLE 2

CONTACT	AWG WIRE	HAND TOOLING	AUTO TOOLING			EXTRACTION AND REPAIR TOOLING		
			CAT 3000 & AMP G	AMP T and AUTO	AMP K	CONTACT EXTRACTION TOOL	CONTACT REPAIR TOOL	INSERTION TOOL
C310	10~12	N/A	CAT-MA-310-1012-FR-01	CAT-MA-310-1012-FS-01	CAT-MA-310-1012-TR-01	N/A		CAT-IN-PESS
CC69 and C169	16~20	CAT-HT-169-1620-11	CAT-MA-169-1620-FR-01	CAT-MA-169-1620-FS-01	CAT-MA-169-1620-TR-01	CAT-EX-169-01	CAT-RE-169-01	
	20~24	CAT-HT-169-2024-11	CAT-MA-169-2024-FR-01	CAT-MA-169-2024-FS-01	CAT-MA-169-2024-TR-01	N/A	CAT-RE-169-01	
	24~26	N/A	CAT-MA-169-2426-FR-03	N/A	CAT-MA-169-2426-TR-03	CAT-EX-169-01	CAT-RE-169-01	
CC79 and C179	20~24	CAT-HT-179-2024-11	CAT-MA-179-2024-FR-01	CAT-MA-179-2024-FS-01	CAT-MA-179-2024-TR-01	CAT-EX-179-01	CAT-RE-179-01	
	26~30	CAT-HT-179-2630-11	CAT-MA-179-2630-FR-01	CAT-MA-179-2630-FS-01	CAT-MA-179-2630-TR-01	N/A	CAT-RE-179-01	
	28~30	N/A	CAT-MA-179-2830-FR-03	N/A	CAT-MA-179-2830-TR-03	CAT-EX-179-01	CAT-EX-179-01	
CC20 and C198	20~24	N/A	CAT-MA-020-2024-FR-01	CAT-MA-020-2024-FS-01	CAT-MA-020-2024-TR-01	N/A	N/A	
	24~28	N/A	CAT-MA-020-2428-FR-01	CAT-MA-020-2428-FS-01	CAT-MA-020-2428-TR-01	N/A	N/A	
CT20 and T1R31	20~24	N/A	CAT-MA-020-2024-FR-01	CAT-MA-020-2024-FS-01	CAT-MA-020-2024-TR-01	N/A	N/A	
	24~28	N/A	CAT-MA-020-2428-FR-01	CAT-MA-020-2428-FS-01	CAT-MA-020-2428-TR-01	N/A	N/A	
CC62 and C194	14~18	N/A	CAT-MA-194-1418-FR-01	CAT-MA-194-1418-FS-01	CAT-MA-194-1418-TR-01	CAT-EX-062-01	N/A	
	20~24	N/A	CAT-MA-194-2024-FR-01	CAT-MA-194-2024-FS-01	CAT-MA-194-2024-TR-01	CAT-EX-062-01	N/A	
	20~24	N/A	CAT-MA-194-2024-FR-02	CAT-MA-194-2024-FS-02	CAT-MA-194-2024-TR-02	CAT-EX-062-01	N/A	
	26~30	N/A	CAT-MA-194-2630-FR-01	CAT-MA-194-2630-FS-01	CAT-MA-194-2630-TR-01	CAT-EX-062-01	N/A	
	26~30	N/A	CAT-MA-194-2630-FR-02	CAT-MA-194-2630-FS-02	CAT-MA-194-2630-TR-02	CAT-EX-062-01	N/A	
CT62 and T1R29	14~18	N/A	CAT-MA-194-1418-FR-01	CAT-MA-194-1418-FS-01	CAT-MA-194-1418-TR-01	CAT-EX-062-01	N/A	
	20~24	N/A	CAT-MA-194-2024-FR-01	CAT-MA-194-2024-FS-01	CAT-MA-194-2024-TR-01	CAT-EX-062-01	N/A	
	20~24	N/A	CAT-MA-194-2024-FR-02	CAT-MA-194-2024-FS-02	CAT-MA-194-2024-TR-02	CAT-EX-062-01	N/A	
	26~30	N/A	CAT-MA-194-2630-FR-01	CAT-MA-194-2630-FS-01	CAT-MA-194-2630-TR-01	CAT-EX-062-01	N/A	
	26~30	N/A	CAT-MA-194-2630-FR-02	CAT-MA-194-2630-FS-02	CAT-MA-194-2630-TR-02	CAT-EX-062-01	N/A	
CT03 and T1M44	28~32	CAT-HT-203-2832-11	CAT-MA-144-2832-FR-01	CAT-MA-144-2832-FS-01	CAT-MA-144-2832-TR-01	CAT-EX-169-01	CAT-RE-169-01	
CC03 and C203	28~32	CAT-HT-203-2832-11	CAT-MA-203-2832-FR-01	CAT-MA-203-2832-FS-01	CAT-MA-203-2832-TR-01	CAT-EX-169-01	CAT-RE-169-01	
CC46 and C246	14~16	CAT-HT-246-1416-11	CAT-MA-246-1416-FR-01	CAT-MA-246-1416-FS-01	CAT-MA-246-1416-TR-01	CAT-EX-MPSS-01	N/A	
C281	24~30	CAT-HT-281-2430-11	CAT-MA-281-2430-FR-01	CAT-MA-281-2430-FS-01	CAT-MA-281-2430-TR-01	CAT-EX-169-01N/A	CAT-RE-169-01	
T1M74	20~24	CAT-HT-174-2024-11	CAT-MA-174-2024-FR-01	CAT-MA-174-2024-FS-01	CAT-MA-174-2024-TR-01	CAT-EX-74-01	N/A	
	26~30	N/A	CAT-MA-174-2630-FR-01	CAT-MA-174-2630-FS-01	CAT-MA-174-2630-TR-01		N/A	
	28~30	N/A	CAT-MA-174-2830-FR-03	CAT-MA-174-2830-FS-03	CAT-MA-174-2830-TR-03		N/A	
T-1M82	24~30	CAT-HT-182-2430-11	CAT-MA-182-2430-FR-01	CAT-MA-182-2430-FS-01	CAT-MA-182-2430-TR-01	CAT-EX-169-01	CAT-EX-169-01	
	28~30	CAT-HT-182-2430-11	CAT-MA-182-2830-FR-01	CAT-MA-182-2830-FS-01	CAT-MA-182-2830-TR-01			
C309	28~32	N/A	CAT-MA-309-2832-FR-01	CAT-MA-309-2832-FS-01	CAT-MA-309-2832-TR-01	N/A	N/A	
C383	24~28	N/A	CAT-MA-383-2428-FR-01	CAT-MA-383-2428-FS-01	CAT-MA-383-2428-TR-01	N/A	N/A	

CAT: CRIMP APPLICATION TOOLING  
 -MA: MACHINE APPLICATOR  
 -HT: HAND TOOL  
 -XXX: CONTACT  
 -XXXX: GAUGE RANGE  
 -XX: -TR (PRE FEED 30MM STROKE)  
       -FR (PRE FEED 40MM STROKE \*)  
       -FS (POST FEED 40MM STROKE)  
 -XX: INSULATION THICKNESS  
       -01 (FOR 300V)  
       -02 (FOR 600V)  
       -03 (FOR TEFLON)

\* SAMTEC PRODUCTION TOOLING STANDARD

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DESCRIPTION: CRIMP/STRIP SPECIFICATIONS

DWG. NO. CRIMP SPECIFICATIONS

BY: D.SCHMELZ 10-11-2010 SHEET 4 OF 4