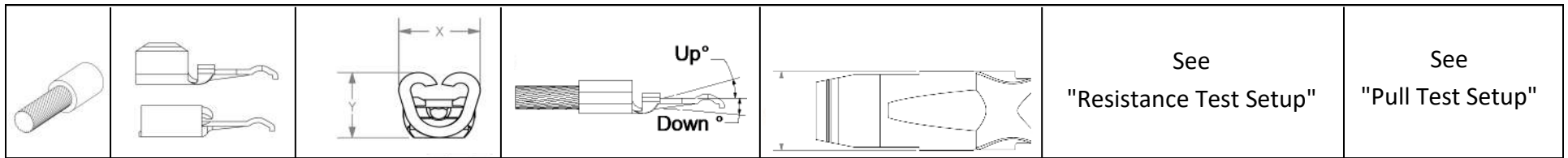








Crimp Specification for Powerpole® 15-45 Series Contacts



All Criteria Must Be Achieved for Proper Crimp Fit & Function

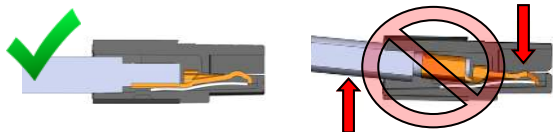
Wire Size	Contact Series	Maximum Crimp Barrel Dimensions				Maximum Blade Angle Distortion (Degrees)	Reel Cutoff Width MAX / MIN				Tin Plated Contacts Milli-ohm Resistance (MAX)	Silver Plated Contacts Milli-ohm Resistance (MAX)	Wire Pull Out Force (MIN) lb_f	Wire Pull Out Force (MIN) N
		X		Y			MAX		MIN					
		In	mm	In	mm		In	mm	In	mm				
10 AWG	26XXX Series	0.178	4.52	0.162	4.11	+5 up / '-2 down	0.155	3.93	0.142	3.61	0.11	0.09	70	312
	20XXX Series													
	1830 Series													
12 AWG	26XXX Series	0.178	4.52	0.162	4.11	+5 up / '-2 down	0.155	3.93	0.142	3.61	0.12	0.100	70	312
	20XXX Series					+2 up / '-2 down								
	1830 Series					+5 up / '-2 down								
	1331					N/A								
14 AWG	26XXX Series	0.178	4.52	0.162	4.11	+5 up / '-2 down	0.155	3.93	0.142	3.61	0.13	0.110	50	223
	20XXX Series					+2 up / '-2 down								
	1830 Series					+5 up / '-2 down								
	1331					N/A								
16 AWG	26XXX Series	0.178	4.52	0.162	4.11	+5 up / '-2 down	0.155	3.93	0.142	3.61	0.14	0.12	30	134
	20XXX Series													
	1331/1332													
18 AWG	26XXX Series	0.178	4.52	0.162	4.11	+5 up / '-2 down	0.155	3.93	0.142	3.61	0.16	0.13	20	89
	20XXX Series													
	1332													
20 AWG	26XXX Series	0.178	4.52	0.162	4.11	+5 up / '-2 down	0.155	3.93	0.142	3.61	0.18	0.14	13	58
	20XXX Series													
	1332													

Measure Blade Angle

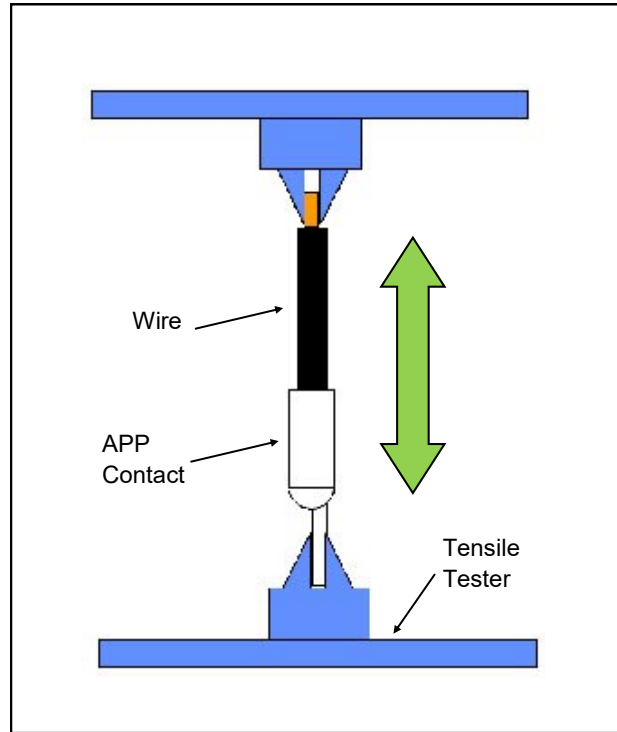
	Finger Proof	Standard
UP Blade Angle Distortion	 MIN= 0.062 in. (1.58 mm)	 MIN= 0.090 in. (2.29 mm)
DOWN Blade Angle Distortion	 MAX= 0.080 in. (2.03 mm)	 MAX= 0.108 in. (2.74 mm)

Note: Measure with solid steel pin gauge after contact is inserted

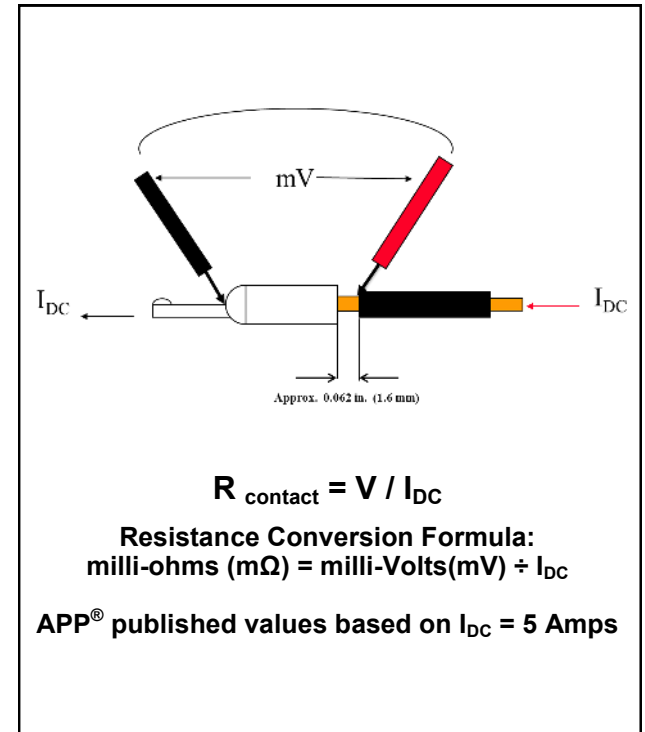
Only Measure Properly Trained Wires



Pull Test Setup



Resistance Test Setup



The included crimp performance and dimensional information are provided as a means to verify quality crimping of Anderson Power Products® contacts and is based on the use of tooling. The assembly of connector solutions with tooling assures that all crimp performance and fit specifications are met. Customers must regularly re-check electrical performance and dimensions of crimps to determine if crimp tools require maintenance due to wear over time.

The use of tooling not recommended by can affect performance and may void the product warranty as well as invalidate safety agency approvals or certifications.

Dimensions of crimps meeting all five performance and fit requirements may be recorded and used as quality acceptance criteria:

(1) "Milli-ohm Resistance"	Primary inspection criteria. Crimps which do not meet these minimum specifications are unacceptable.
(2) "Wire Pull Out Force"	
(3) "Maximum Crimp Barrel Dimensions"	Not to be interpreted as target crimp dimensions. They are the maximum dimensions that allow the contact to properly fit into the connector housing. Actual dimension of acceptable quality crimps will be less than the "Max Dimensions" in at least one if not both dimensions.
(4) "Maximum Blade Angle Distortion"	Required to ensure proper contact retention in the housing. Out of specification contacts can increase milli-ohm resistance of an assembled mated pair of connectors. Contacts with unacceptable blade angle distortion cause connector mating and unmating forces to deviate from specification.
(5) "Reel Cutoff Width" (for contacts purchased on a reel only)	A properly setup applicator trims off the carrier strip on reeled contacts without cutting into the contact mating surface area. Not exceeding maximum dimensions allow the contact to properly fit into the connector housing. Not violating the minimum dimensions protects the contacts from damage. Crimp cutoff must be symmetric.

Quality crimping of the contact alone does not assure the installed performance of the connector system. Stress

loads on the contacts from wires which have been bent or twisted near to the connector's wire exit may severely degrade connector performance. Wires should exit straight from the back of the connector and be secured before bending or twisting.

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