Japan Aviation Electronics Industry, Ltd. Connector Division	Number	T 7 0 3 2 6 3 - E	Page 1／9
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TITLE:
Crimp Data for Series FI-C3-A1 / FI-XC3-1 / FI-AC3-1 / FI-RC3-1A / FI-RC3-1B contacts

ISSUED: 2ND PRODUCTION Engineering Dept.

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CAUTION

- Check that operation manual T703000-01E (applicator) is provided in addition to this manual. If not, contact us.
- Be sure to read T703000-01E before operation since all safety precautions are described in it.
- Properly keep this operation manual and T703000-01E near the applicator so that anyone can refer to them at anytime.
- Be sure to use the machine by following the instructions given in this operation manual and T703000-01E. Otherwise, we will not be responsible for any accidents that may result.
- Don't to repair or adjust, without the procedure specified with this operation manual, it cause is to brake the tool or product the rejected items. If you feel the tool abnormally or brake the tool, please inquire our shop or tool service, and repair it.

1.Applicator

Part description of the applicator used : 350-FI-2B

(Applicable Press No.CP210-1B・CP215-4B)

2. Part description of applicable contact and wire

Applicable wire is stranded 7 annealed copper. conductors. Using not specified wire, please ask us whether the wire is usable or not.

Contact part description	Applicable wire	Insulation diameter
FI-C3-A1-15000	AWG#28 thru AWG#32	ϕ 0.45 thru ϕ 0.9mm
FI-XC3-1-15000	AWG#30 thru AWG#36	ϕ 0.45 thru ϕ 0.75mm
FI-AC3-1-15000	AWG#30 thru AWG#36	Less than ϕ 0.5mm
FI-RC3-1A-15000 FI-RC3-1B-15000	AWG#30 thru AWG#32	ϕ 0.44 thru ϕ 0.6mm

Note :The crimper,anvil and crimp condition differ in each contact.
For details,plaese refer to paragraph 4.

3.Allpicable wire , insulation diameter , and insulation stripped length

3-1.Applicable wire

Vinyl insulated wire

3-2. Insulation stripped length

Insulation stripped length: 1.3 thru 1.7mm

Note :Please make sure that the insulation stripped length is within the above dimension. At the time , inspect if wire is not damaged , cut , or disheveled. If so , remove or remedy it.

4.Crimp data by contact type

4-1.FI-C3-A1

4-1-1.Applicable crimper,anvil

	Insulation anvil	Wire anvil	Insulation crimper	Wire crimper
Part discription	725-03161-030	725-03200-031	725-03200-032	725-03200-033
Inscribed NO.	161-30	200-31	200-32	200-33

4-1-2.Applicable wire,crimp height,crimp tensile strength,Disk set mark

Disk Set Mark	Wire Size (AWG)	Crimp Height Range (mm)	Min.Crimp Tensile Strength (N)
C	AWG#28	0.45 thur 0.50	13.1N
D	AWG#30	0.43 thur 0.48	9.8N
E	AWG#32	0.40 thur 0.45	5.8N

4-1-3Crimp height adjustment disc set mark, Insulation cam set mark and Insulation diameter

Insulation Cam set Mark / Disc set Mark		1～3	4	5	6	7	8
C	Insulation Dia.	－	φ0.90～0.8	φ0.7	φ0.6	φ0.5	－
	Insulation Support Height	－	1.05	0.95	0.85	0.75	－
D	Insulation Dia.	－	φ0.9～0.75	φ0.65	φ0.55	φ0.45	－
	Insulation Support Height	－	1.05	0.95	0.85	0.75	－
E	Insulation Dia.	－	φ0.9～0.75	φ0.65	φ0.55	φ0.45	－
	Insulation Support Height	－	1.00	0.90	0.80	0.70	－

Note: The figures shown in above table are not specified values, but for reference purposes only.

4-2.FI-XC3-1,FI-AC-3-1,FI-RC3-1A&FI-RC3-1B

4-2-1. Applicable crimper,anvil

	Insulation anvil	Wire anvil	Insulation crimper	Wire crimper
Part discription	725-03249-030	725-03249-031	725-03249-032	725-03249-033
Inscribed NO.	249-30	249-31	249-32	249-33

4-2-2.Applicable wire,crimp height,crimp tensile strength,Disk set mark

Disk Set Mark	Wire Size (AWG)	Crimp Height Range (mm)	Min.Crimp Tensile Strength (N)
C	AWG#30	0.40 thur 0.45	9.8N
D	AWG#32	0.375 thur 0.425	5.8N
E	AWG#36	0.35 thur 0.40	1.9N

4-2-3.Crimp height adjustment disc set mark, Insulation cam set mark and Insulation diameter

FI-XC3-1

Insulation Cam set Mark / Disc set Mark		1	2	3	4	5	6	7	8
C	Insulation Dia.	—	φ0.75	φ0.7	φ0.6	φ0.5	—	—	—
	Insulation Support Height	—	1.0	0.9	0.8	0.7	—	—	—
D	Insulation Dia.	—	—	φ0.65	φ0.55	φ0.45	—	—	—
	Insulation Support Height	—	—	0.85	0.75	0.65	—	—	—
E	Insulation Dia.	—	—	—	φ0.55	φ0.45	—	—	—
	Insulation Support Height	—	—	—	0.7	0.6	—	—	—

FI-AC3-1

Insulation Cam set Mark / Disc set Mark		1	2	3	4	5	6	7	8
C	Insulation Dia.	—	—	—	—	—	φ0.5	—	—
	Insulation Support Height	—	—	—	—	—	0.5	—	—
D	Insulation Dia.	—	—	—	—	—	φ0.45	—	—
	Insulation Support Height	—	—	—	—	—	0.5	—	—
E	Insulation Dia.	—	—	—	—	—	φ0.45	—	—
	Insulation Support Height	—	—	—	—	—	0.5	—	—

FI-RC3-1A & FI-RC3-1B

Insulation Cam set Mark	1～2	3	4	5～7
Insulation diameter.		ϕ 0.6	ϕ 0.5	
Insulation Support Height		0.85	0.75	

Note1: Be sure to make the insulation hight under 0.53mm on FI-AC3.
(Over 0.53mm is not acceptable due to the insulation diameter of housing. It is 0.54mm.)
Note2: The figures shown in above table are not specified values, but for reference purposes only.

5.Notes in operation

5-1

FI series contacts are so small in size, it may happen that a crimper strikes against an anvil and they become damaged when making crimping with a contact and wire being not installed.
To maintain the quality, be sure to make crimping with a contact and wire being installed.

5-2

It is not easy to locate a wire with a wire stopper because the applicable wires this contact are very thin.
It is recommended that a wire is put on the contact barrel in advance before making crimping.

5-3

This tool can use for FI-C3-A1, FI-XC3, FI-AC3, FI-RC3-1A and FI-RC3-1B by changing the crimper,anvil
When this tool is delivered, the specified crimper,anvil has built in already.
To purchase another crimper,anvil. please make sure the proper part number according to the assembly procedure of contact or following chart..

Crimper, anvil / Contact	Insulation anvil	Wire anvil	Insulation crimper	Wire crimper
FI-C3-A1	725-03161-030	725-03200-031	725-03200-032	725-03200-033
FI-XC3･AC3-1 ･RC3-1A･RC3-1B	725-03249-030	725-03249-031	725-03249-032	725-03249-033

6.Check of the crimped contact

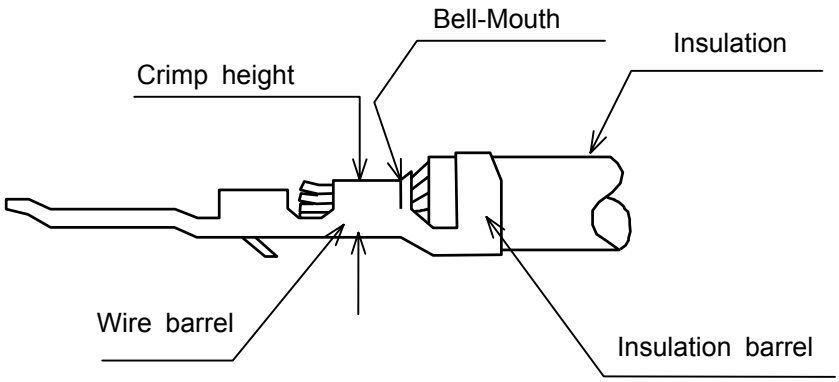
This paragraph provides criteria of discrimination of " Proper " crimped contact after crimping operation.

For detail information about this ,please refer to manual JAHL.

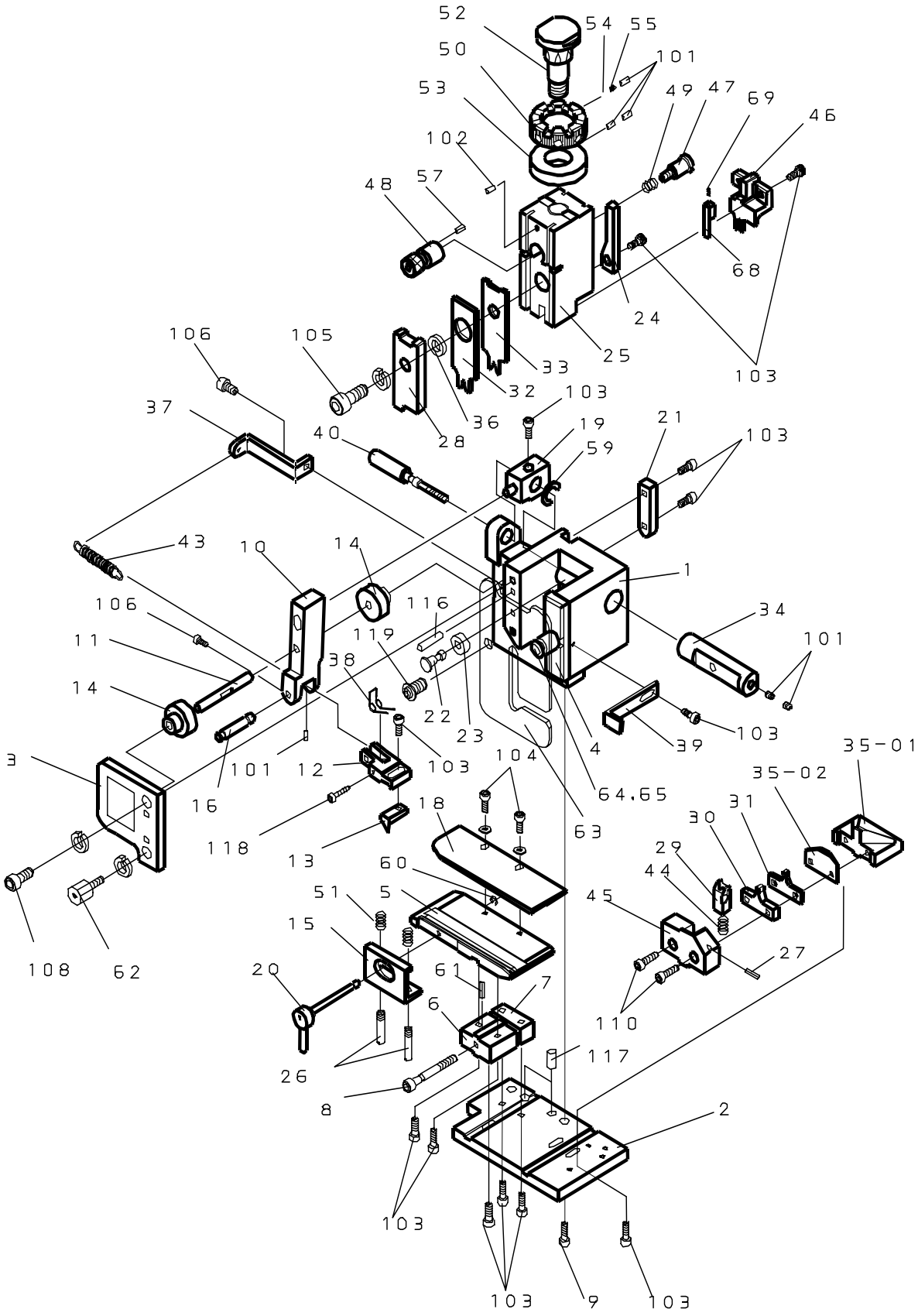
Proper Crimped Contact:

" Proper crimped contact " is crimped as shown below.

(1) Crimp height is satisfied with crimp standard.(refer to para.4)
(2) Wire strands tip is extended from the wire barrel.
(3) Wire insulation does not intrude into the wire barrel.
(4) Wire strands do not protrude between the wire barrel and the insulation barrel.
(5) Wire insulation is wrapped in the insulation barrel.
(6) Bell-mouth(not crimped part)is formed.
(7) Crimped surface is not got too rough.



BLOWN-UP VIEW OF APPLICATOR



PARTS LIST OF APPLICATOR

INDEX NO.	DESCRIPTION	PARTS NO.	QTY
1	Applicator body	743-03005-001	1
2	Base plate	722-03013-002	1
3	Left slide guide	722-03005-003	1
4	Right slide guide	722-03004-004	1
5	Contact feed plate	722-03005-005	1
6	Adjusting plate	743-03004-006	1
7	Fixed plate	743-03004-007	1
8	Adjusting screw	701-03004-008	1
9	Applicator set screw	750-03004-009	2
10	Feed lever	742-03005-010	1
11	Feed lever shaft	708-03005-011	1
12	Feed finger holder	734-03004-012	1
13	Feed finger	732-03004-013	1
14	Pivot bush	710-03005-014	2
15	Contact pressure plate	723-03005-015	1
16	Pin for feed	704-03005-016	1
17			
18	Feed plate cover	722-03263-018	1
19	Pivot block	743-03004-019	1
20	Lift cam unit	700-03004-020	1
21	Key	723-03004-021	1
22	Roller pin	704-03004-022	1
23	Roller	711-03004-023	1
24	Feed actuating cam	741-03004-024	1
25	Crimper holder	743-03081-025	1
26	Screw for contact hold	701-03004-026	2
27	Spring pin for movable cutter		1
28	Front actuator unit	700-03092-028	1
29*	Front movable cutter	726-03263-029	1
30	Insulation anvil	Refer to para 4	1
31	Wire anvil	〃	1
32	Insulation crimper	〃	1
33	Wire crimper	〃	1
34	Feed actuating lever	742-03004-034	1
35-01	Anvil block	743-03247-035-01	1
35-02	Anvil spacer	720-03263-035-02	1
36	Insulation spacer	711-03092-036	1
37	Feed spring bracket	744-03005-037	1
38	Twisted spring	762-03004-038	1

INDEX NO.	DESCRIPTION	PARTS NO.	QYT
39	Wire stopper unit	700-03263-039	1
40	Feed adjusting shaft	708-03004-040	1
43	Feed spring	762-03004-043	1
44	Cutter spring	762-03004-044	1
45	Cutter block	743-03092-045	1
46	Positioner	724-03263-046	1
47	Set-screw for insulation cam	701-03004-047	1
48	Insulation cam unit	700-03004-048	1
49	Spring for insulation cam	762-03004-049	1
50	Crimp-height adjusting disk	715-03023-050	1
51	Contact pressure spring	762-03004-051	2
52	Crimp-height locating shaft	708-03004-052	1
53	Spacer	715-03132-053	1
54	Locating ball	765-03004-054	1
55	Spring for locating ball	762-03004-055	1
57	Locating pin for insulation cam		1
59	E-ring for feed adjusting shaft	754-03004-059	1
60	E-ring for cam shaft	754-03004-060	1
61	Pin for adjusting screw		1
62	Bolt for safety cover	701-03005-062	1
63	Safety cover	748-03005-063	1
64	Fastening screw for safety cover	701-03005-064	1
65	Collar	711-03005-065	1
68	Wire pressure	727-03247-068	1
69	Wire pressure spring	762-03247-069	1
101	Screw with hexagonal hole	M4×4	7
102	〃	〃	2
103	Bolt with hexagonal hole	M4×10	11
104	〃	〃	4
105	〃	M8×20	1
106	〃	M5×10	1
107	〃	M3×4	1
108	〃	M6×15	4
110	〃	M4×30 or 35	2
116	Knock pin	ϕ5×20	2
117	〃	ϕ6×15	2
118	Bolt with hexagonal hole	M3×15	1
119	Cross head screw assembling washer	M4×10	1