

IARPB[®] HORIZONTAL

Instruction Manual

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Rev.	ECN	Date	Prepared by	Checked by	Approved by

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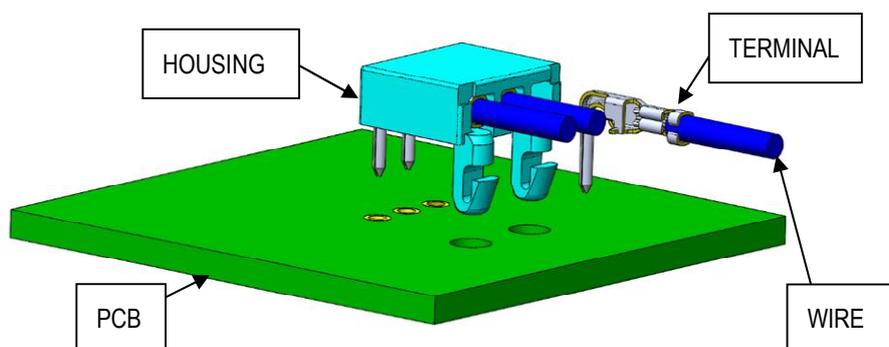
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1. Purpose

The Manual explains the handling of IARPB HORIZONTAL.

2. Applicable items

The Manual is applicable to the items listed below.



Name	Part number	Image
2P HOUSING	V0125-91002-01	
3P HOUSING	V0125-91003-01	
4P HOUSING	V0125-91004-01	
5P HOUSING	V0125-91005-01	
6P HOUSING	V0125-91006-01	

Name	Partnumber	Image
TERMINAL	V0039-71001-011	

3. Crimping procedure

3-1. Applicable wires

Table1. Applicable wires

Wire size	Insulation outer diameter
0.3mm ²	φ1.67mm MAX

3-2. Wire strip length

- ① Strip the insulation off at the dimension shown in Fig .1.
- ② Check to see that there is no damage to the conductors or insulation, cut off conductors, short conductors and deformed conductors as shown in Fig. 2.

Do not use wires with damaged conductors, cut off conductors, short conductor and deformed conductors.

Using faulty wires may cause crimping problems.

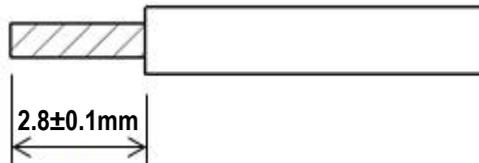


Fig 1. Wire strip

Condition	Image	Condition	Image
Good		Cut off conductors (defect)	
Damaged conductors (defect)		Deformed (conductors defect)	

Fig 2. Stripped wires (unacceptable examples)

3-3. Terminal part names

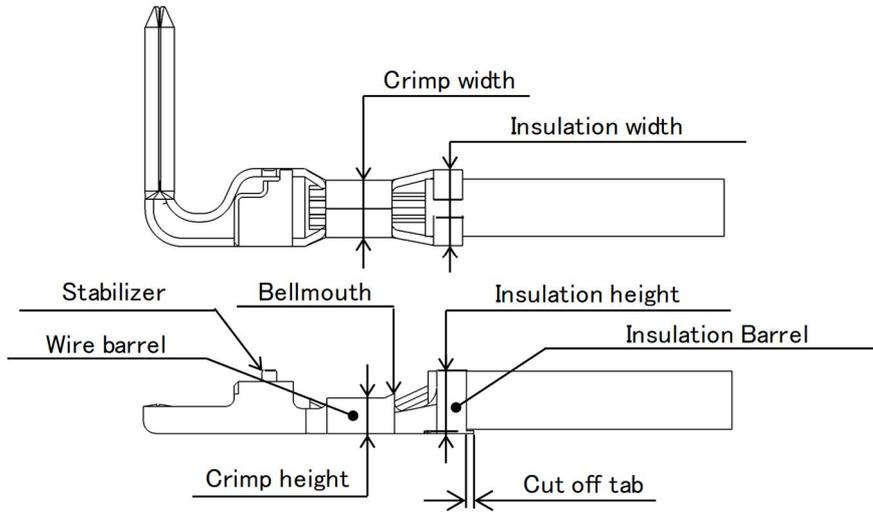


Fig 3. Terminal part names

3-4. Crimping requirements

(1) Crimp dimension

Terminals must satisfy the crimp dimension specified in Table 2.

Table 2. Crimp dimension

Wire size	Insulation outer diameter	Crimp height (※)	Crimp width	Insulation height	Insulation width
0.3mm ²	Φ 1.67mm MAX.	0.85±0.05 mm	1.40±0.05 mm	1.55±0.05 mm	1.85±0.05 mm

※Crimp dimensions may be different depending on conductor construction of the wire.

Please contact our Sales Department shown in 10 (sheet17) about wire used, then we will verify it and notify you the appropriate crimp dimensions.

Use the micrometer shown in Fig.4 for measurement.



Fig 4. Micrometer

(1)-1. Measuring method for crimp height and wide of wire barrel is described below.

Measure with a micrometer between the top and the bottom of the wire barrel or both sides of the wire barrel. (See Fig. 5.)

Fix the terminals firmly so that they do not rattle.

Do not pinch the bell mouth as it cannot measure the crimp height accurately.

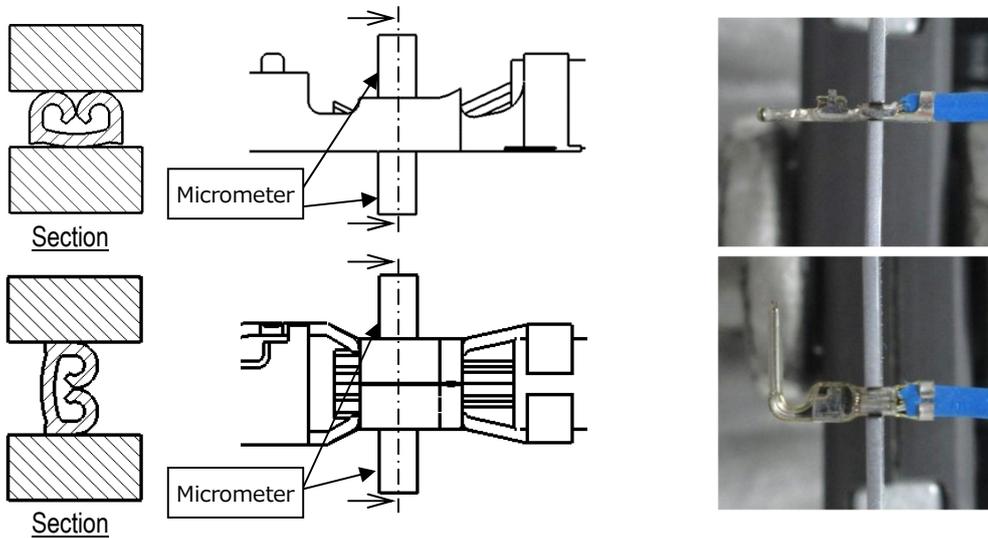


Fig 5. Crimp height and width measurement

(1)-2. Measuring method for crimp height and wide of Insulation barrel is described below.

Measure with a micrometer between the top and the bottom of the insulation barrel or both sides of the insulation barrel. (See Fig. 6.)

Fix the terminals firmly so that they do not rattle.

There is possibility of damage on the conductor because the insulation barrel bite into the wires by over-crimping. Cut off the insulation barrel only, and strip off the covering, then check that there is no damage on the conductor. (see Fig.7)

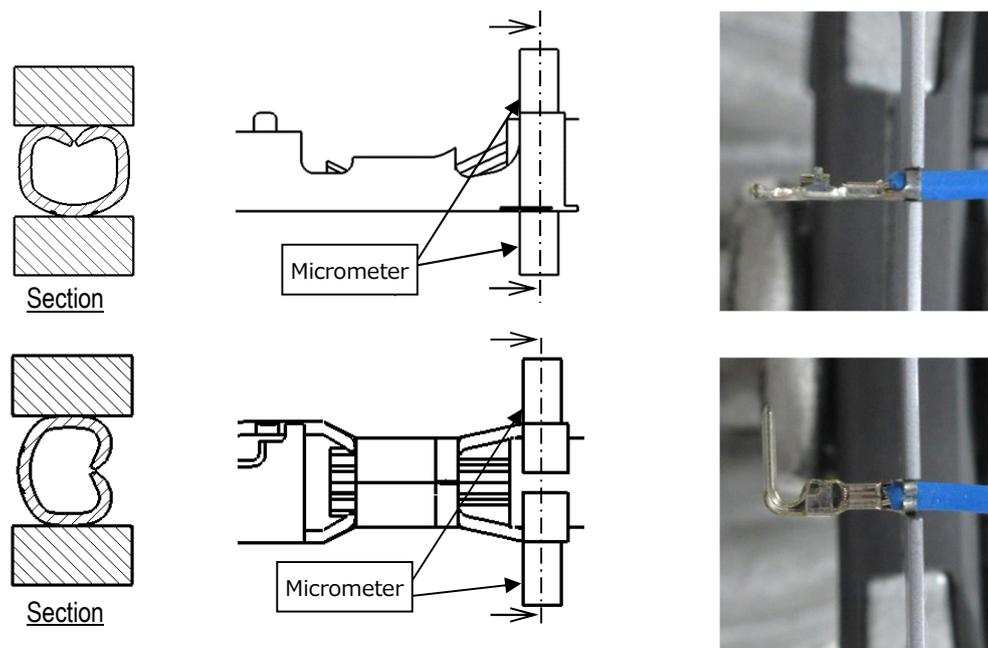


Fig 6. Insulation height and width measurement

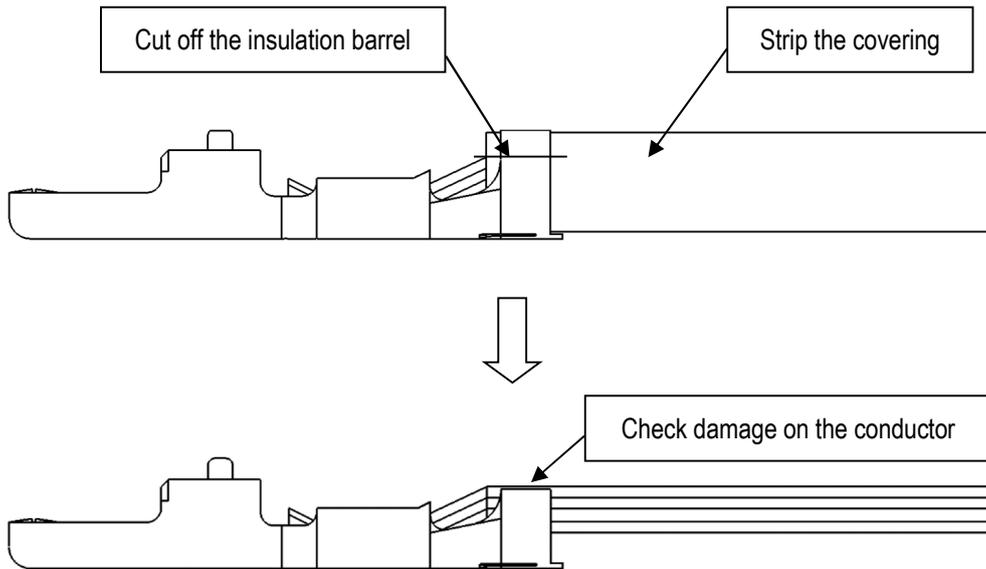


Fig.7 How to check damage (by over-crimping insulation barrel)

(2) Bottom burrs

Burrs produced during crimping process must not extend beyond the bottom surface. (see Fig.8)

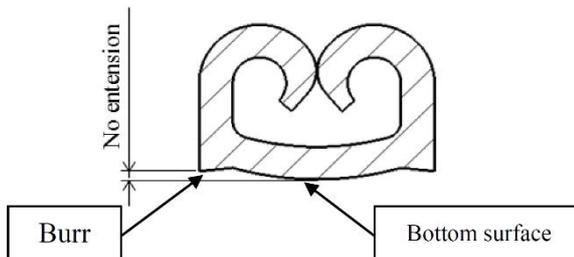


Fig 8. Bottom burrs

(3) Bellmouth, excess conductors and cut-off tab

Bellmouth, excess conductors and cut-off tab must satisfy the dimensions shown in Fig. 9.

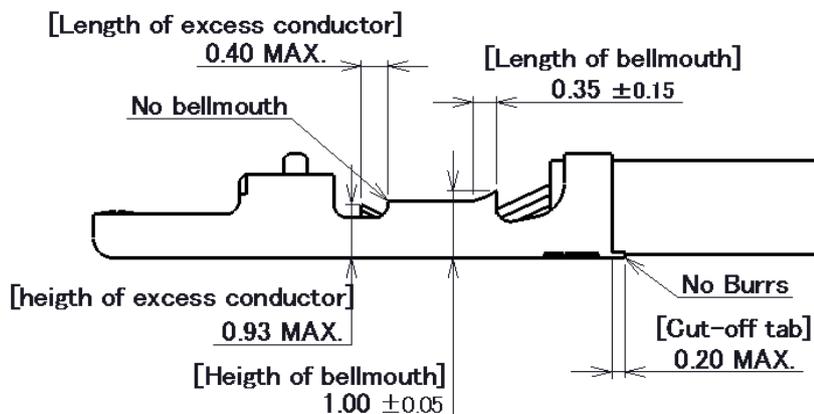


Fig 9. Bellmouth, excess conductors and cut-off tab

(4) Unaligned wire barrel ends

Unaligned wire barrel ends is 0.1mm MAX.. (see Fig.10)

※If wire barrel ends are not aligned, resulting in different dimension of excess conductors(Fig. 9 0.40MAX.) or bellmouth between the sides (Fig. 9 0.35±0.15), dimensions must be measured on larger side and be satisfied. (In the case shown in Fig.11, measure excess conductors, bellmouth.)

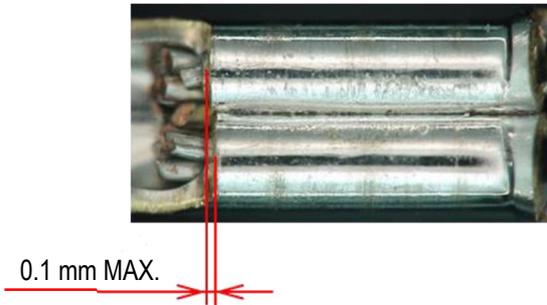


Fig 10. Unaligned wire barrel ends

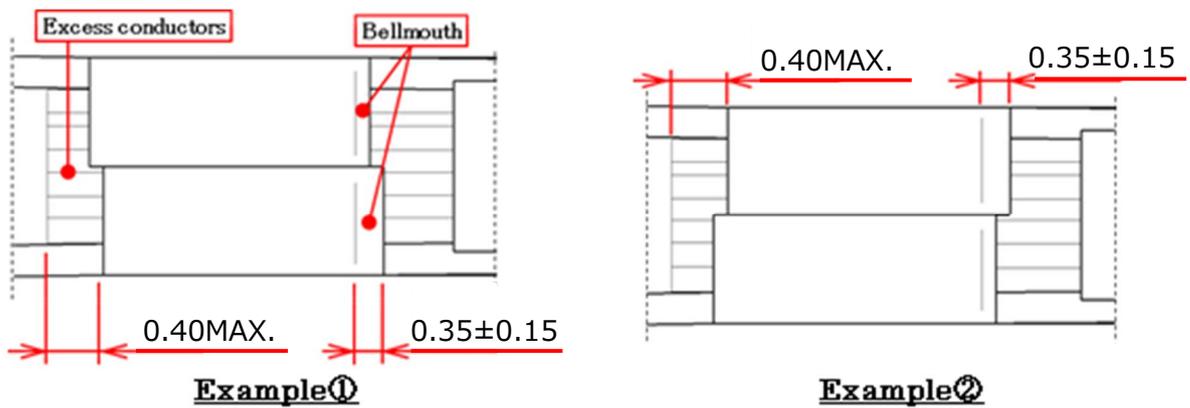


Fig 11. Examples of unaligned wire barrel ends

(5)Rolling

Rolling is 4° MAX. from the wire barrel (baseline).(see Fig.12)

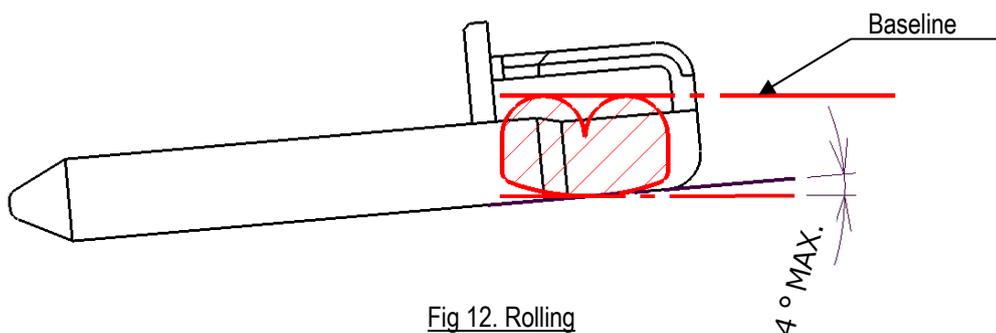


Fig 12. Rolling

(6) Terminal twist

Terminal twist is 3° MAX. from the wire barrel (baseline). (see Fig. 13)

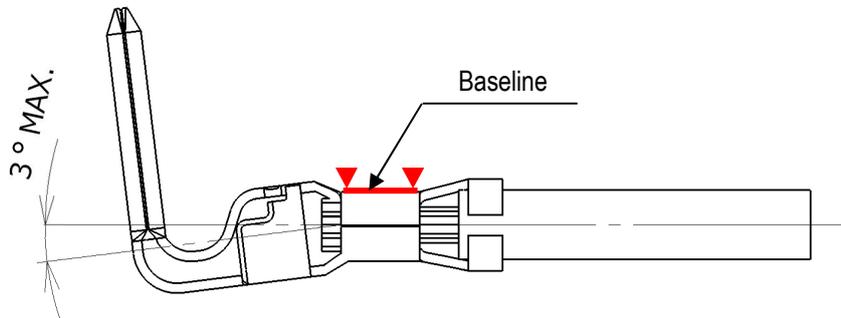


Fig 13. Terminal twist

(7) Bend up and Bend down

Bend up and Bend down from the wire barrel must satisfy the dimensions shown in Fig.14 and 15.

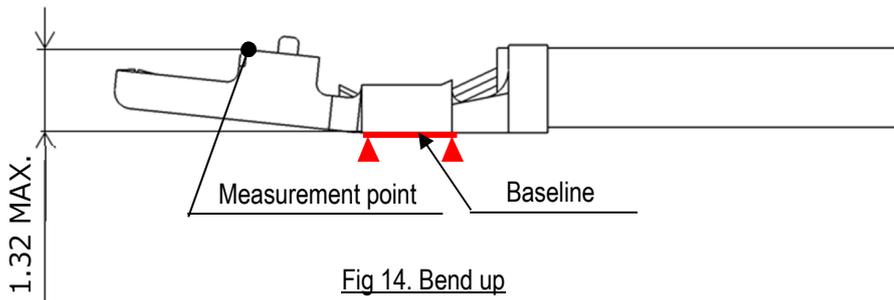


Fig 14. Bend up

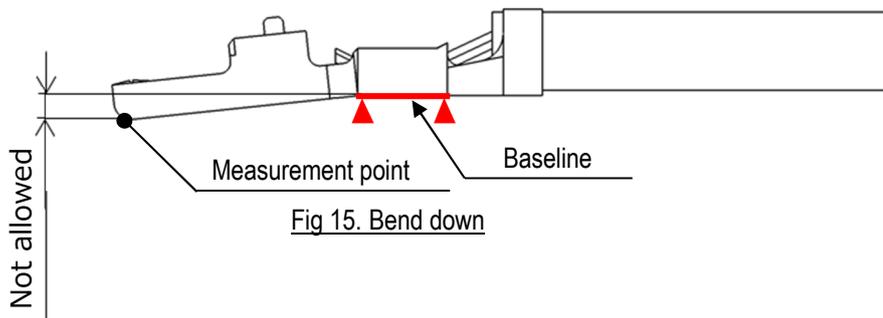


Fig 15. Bend down

3-5. Defective criteria

Terminals with the following conditions are deemed defective.

(1) No rear bellmouth

Rear bellmouth is not formed. (see Fig.16)

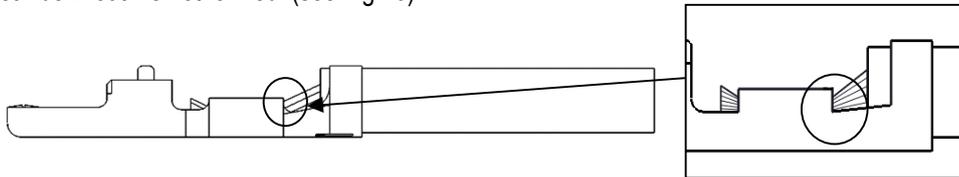


Fig 16. No rear bellmouth

(2) Insufficient conductors insertion

Conductors are insufficiently inserted into the wire barrel. (see Fig.17)

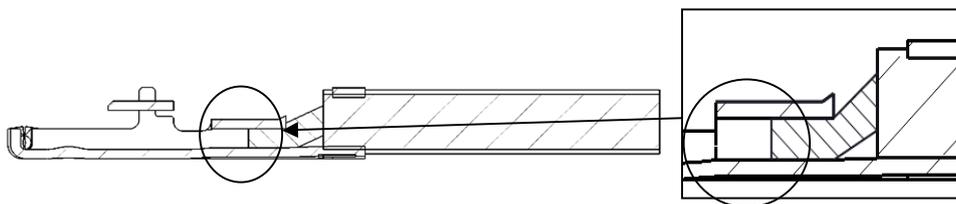


Fig 17. Insufficient conductors insertion

(3) Excessive conductors out

Excess conductors protrude from the wire barrel and do not satisfy the dimension in Fig.9 of sheet 7. (see Fig.18)

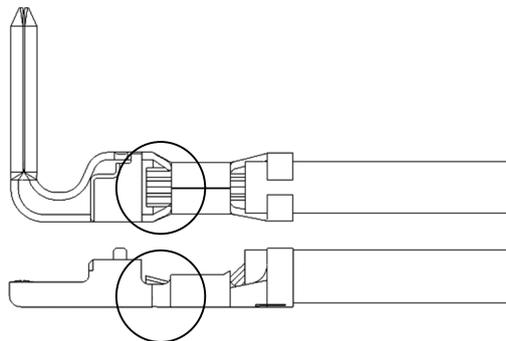


Fig 18. Excessive conductors out

(4) Incomplete conductors crimping

Conductors are not crimped inside the wire barrel, or within the terminal. (see Fig.19)

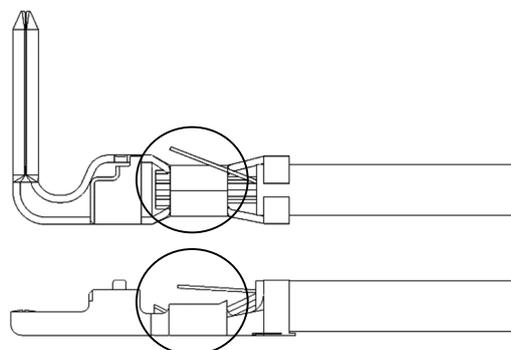


Fig 19. Incomplete conductors crimping

(5) Incomplete insulation crimping

Strip length is too short and insulation is crimped inside the wire barrel (see Fig. 20).

Strip length is too long and insulation does not fit completely inside the insulation barrel (see Fig.21).

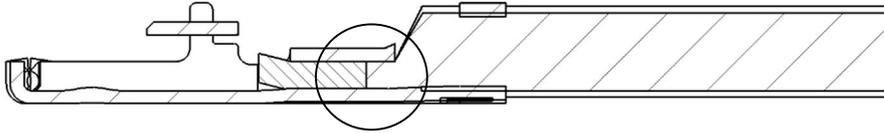


Fig 20. Strip too short

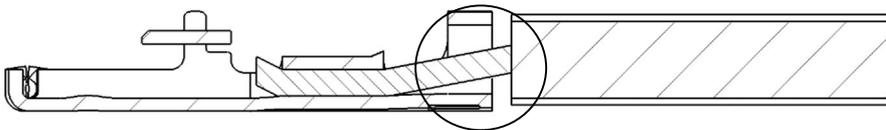
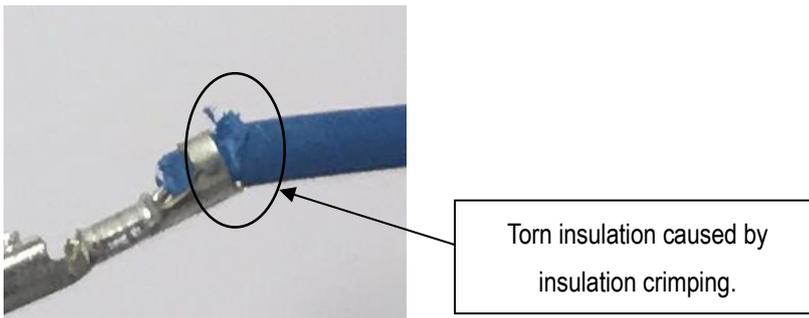


Fig 21. Strip too long

(6) Torn insulation

Insulation is torn by insulation barrel. (see Fig.22)



Torn insulation caused by
insulation crimping.

Fig 22. Torn insulation

4. Terminal insertion

- ① Ensure that the terminal is crimped correctly and there is no damage, deform or dirt present.
- ② Hold the wire to insert the terminal as shown in Fig.23.
- ③ Insert the terminal into the corresponding corehole of the housing, as deeply as possible, in the orientation as shown in Fig. 23.
- ④ Once the terminal is inserted, ensure that the terminal retention is fastened by pulling the wire lightly towards you.

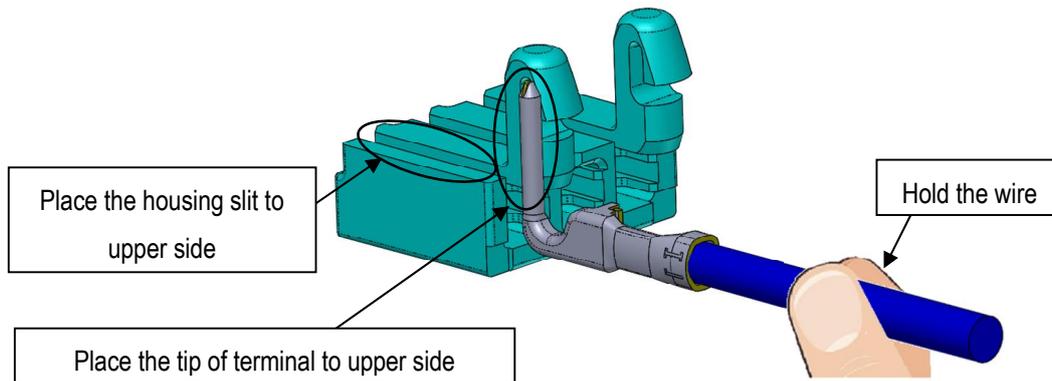


Fig 23. Terminal insertion direction

Notes:

- ① Terminals must be inserted in the orientation instructed. Forcibly inserting terminals in any other orientation may result in damage or deformation. Furthermore, if the terminals are inserted with incorrect orientation, terminal key prevents insertion into coreholes. (see Fig.24)
- ② Once the terminal is inserted, do not apply excessive pulling force to the wire.

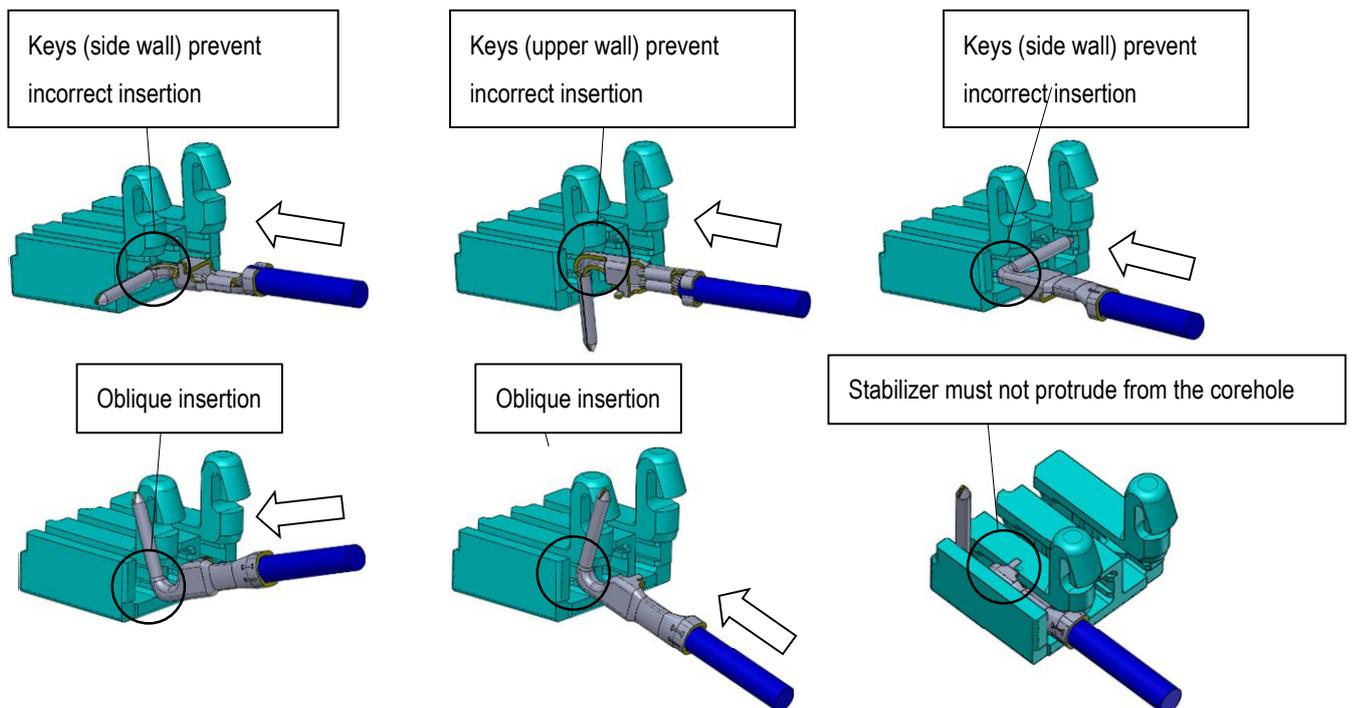


Fig24. Incorrect terminal insertion

5. Solderability

5-1. Recommended conditions for soldering

Recommended soldering conditions are shown in Table3,4.

Table3. Recommended flow soldering conditions

Temperature	Immersion time	Composition	Flux
255~275°C	5~10s	Sn-3.0Ag-0.5Cu	Flux activity: Rosin L1 type (J-STD-004)

Table4. Recommended hand soldering conditions

Soldering iron temperature	Soldering time	Solder Structure
340~360°C	4~6s	Sn-3.0Ag-0.5Cu

- Recommend that ensure the PCB and the bottom surface of the housing are touching each other in applying the load of 2N to 5N. (see Fig.25)
- Solderability is affected by PCB dimensions, placement of installed parts, etc.
- If the solderability is insufficient, it should examine appropriate conditions.
- Do not allow solder to come in contact with the housing bosses during flow.
- Do not touch the housing with the soldering iron when hand soldering.
- If the soldering time exceeds in Table 3 and 4 or the mounting time, heat may be transferred from the terminals and the housing may melt.

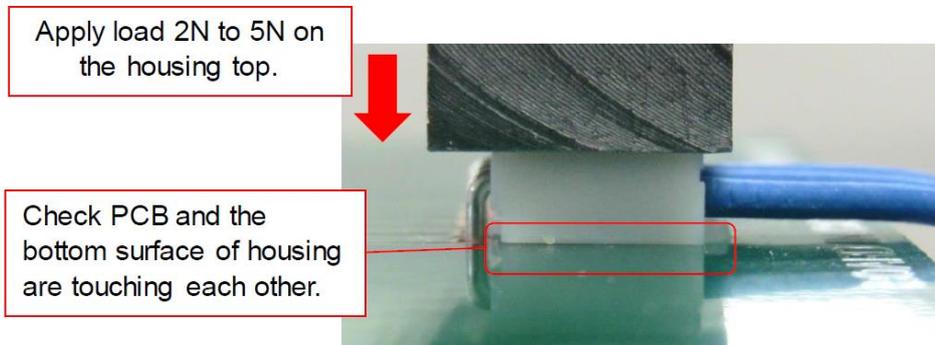


Fig.25 Pressing load

6. How to release terminals

- ① Hold the wire and push in the terminal lightly. Place the terminal releasing jig into the releasing apertures of the housing (see Figs. 26 and 27).
- ② Push the releasing jig fully into the lance shown in Fig.29, then push further and lever up the lance as shown in Fig.30.
Keep the jig in the place and pull the terminal out by holding the wire.
- ③ If there is any difficulty in pulling out the terminal, do not pull it forcefully. Check that the jig is in the correct place, that it is pushed fully in, etc. and repeat the procedures ① and ②.

Retainer releasing JIG: Part No. 91683-0001 (Old : AP0026-01-001)

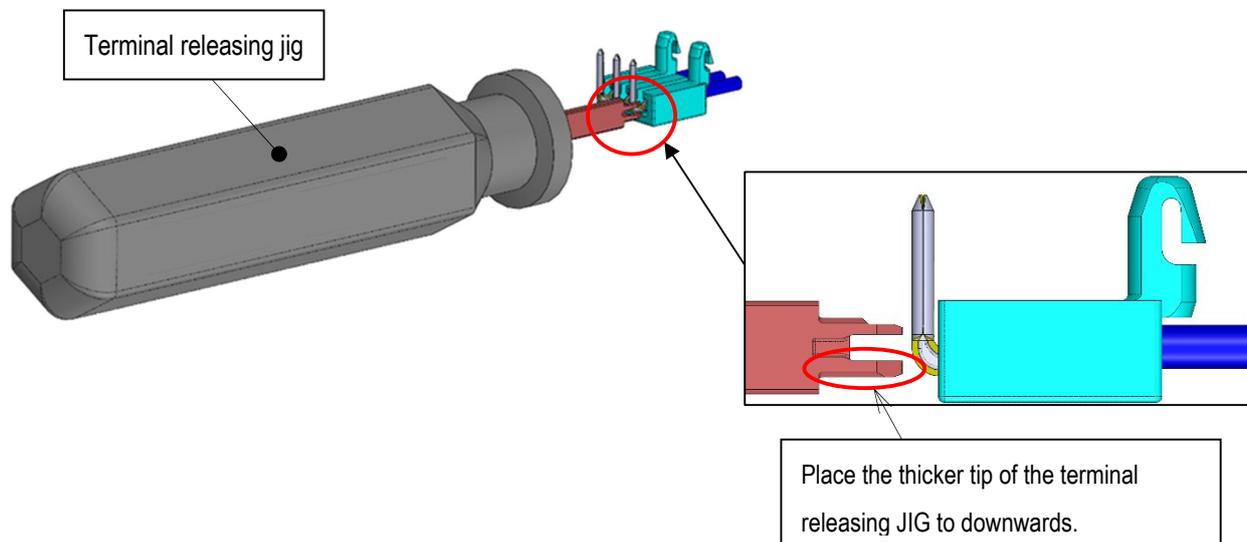


Fig26 Housing and Direction of release

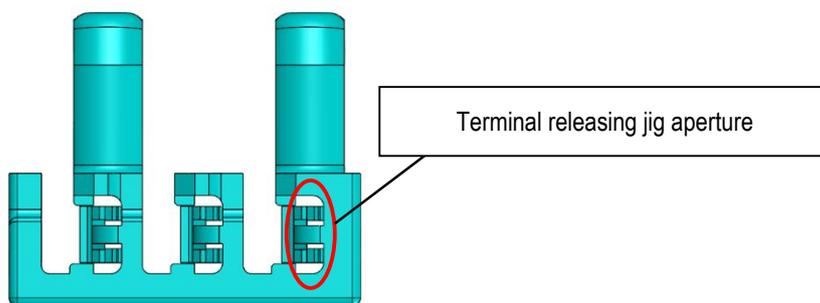


Fig27 Terminal releasing jig aperture

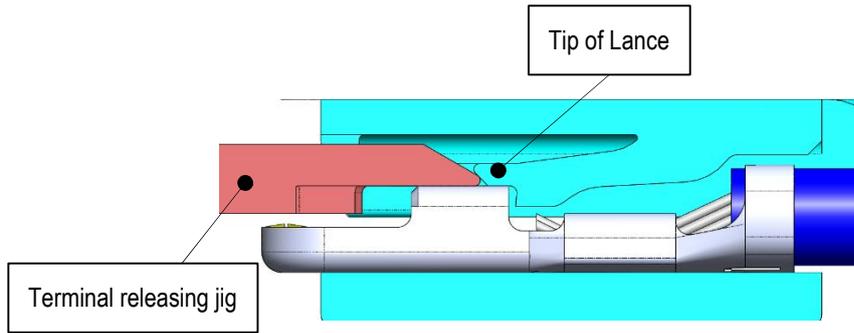


Fig28. Correct orientation of the releasing jig and the housing lance

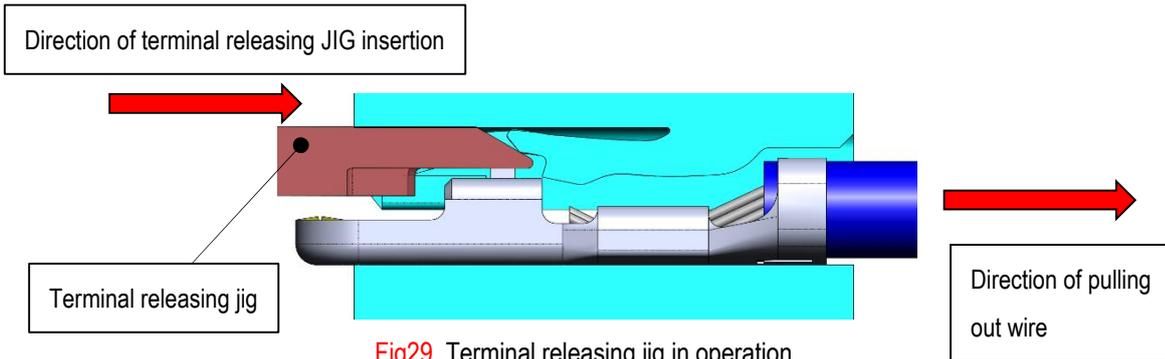


Fig29. Terminal releasing jig in operation

Notes

- ① Do not pry with the releasing jig or terminals during operation. Check for any deformation or damage on the terminals and the housing after releasing the terminals. (see Fig.30)
- ② Do not pull out the terminal or rotate the terminal releasing jig without the lance fully lever up. It may cause damage or deformation of lance and terminal releasing jig. (See Fig.31)
- ③ If there is any damage or deformation on the terminal or the housing, do not use the damaged item. Replace the item with a new one.
- ④ If the terminal releasing jig is used in incorrect orientation, the terminal releasing jig can not reach to and lever up the lance. Furthermore, if the wire is pulled out this situation, the lance may be damaged and deformed.

If there is any difficult in pulling out the wire, do not insert the jig forcefully. Check that the jig is in the correct place and repeat the procedures ① to ③. (See Fig.32)

- ⑤ Care must be taken not to damage edge of the jig (e.g. from dropping, etc.)



Fig30. Damage caused by releasing jig

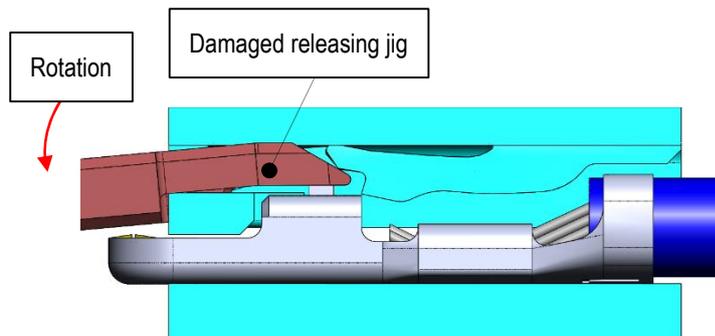


Fig31. Lance and Damaged releasing jig

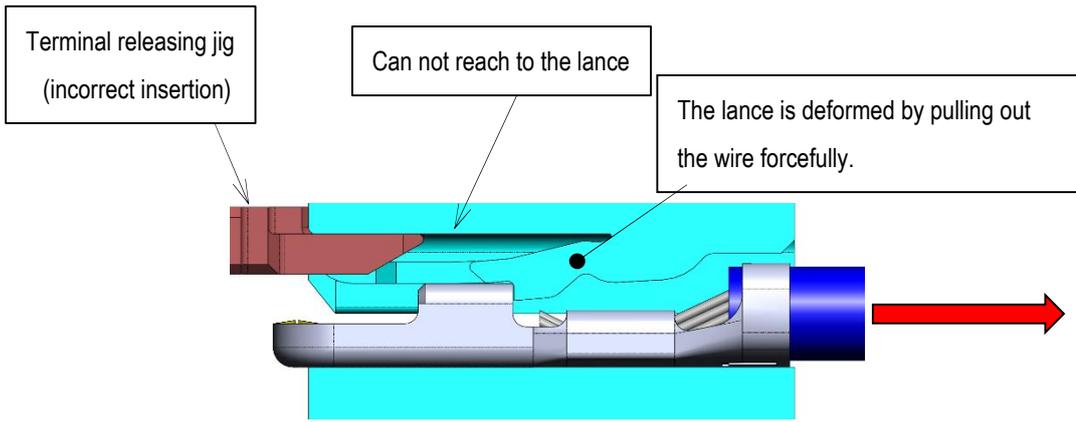


Fig 32. Incorrect insertion of the releasing jig

7. Handling of Product

7-1. Conductivity test

- ① When carrying out conductivity test of the connector, place the probe on the tip (DIP side) of the terminal from the arrow mark directions. (Load: 0.5N MAX.)
If load exceeds 0.5N, terminal may be damaged or deformed. (see Fig. 33)
- ② If there is any damage or deformation, do not use the damaged item.
Replace the item with a new one.

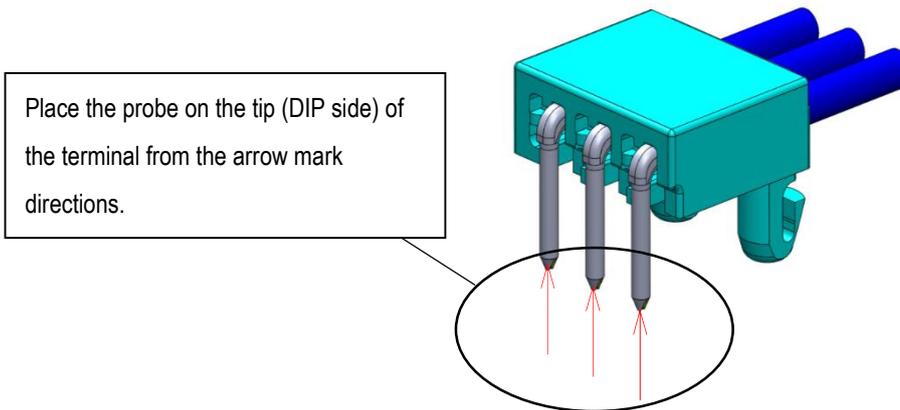


Fig 33. Conductivity test for terminals (contacts)

7-2. Arrangement of Wires

- ① When arranging the wires horizontally, to avoid excessive stress to the sidewalls and terminals, please keep the wires straight (at least 15mm) from connector as shown in Fig.34.
- ② Once straight portion is secured, arrange the wires with adequately large R.

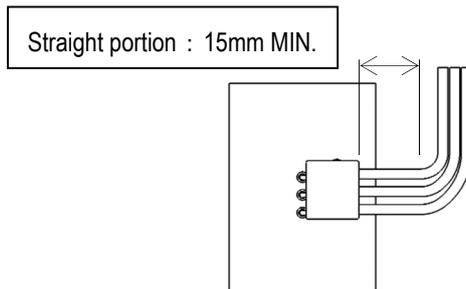


Fig 34. Arrangement of wires

8. Storage of housings and terminals

- ① Store housings and terminals in a warehouse which is controlled temperature and humidity.
(Recommend : Temperature 27°C MAX., Humidity 65% MAX.)
- ② Store housings in a cardboard box. Avoid storing in a way that may cause damage to the boxes, e.g. placing boxes on top of other boxes or storing in a precarious way to cause the boxes to fall. Housing may be deformed if the boxes have been damaged.
- ③ Store terminals in a cardboard box. Avoid storing in a way that may cause damage to the boxes, e.g. placing boxes on top of other boxes or storing in a precarious way to cause the boxes to fall. Reel(s) or terminal(s) may be deformed if the boxes have been damaged.
It is recommended that the connector is soldered to PCB in 90 days after delivery.

9. Other notes

- ① Handle products with care. Do not place excessive force/impact to connectors main bodies or wires.
- ② Store products in a dry place without any dust or dirt.
Avoid storage for an extended period or any way that may cause damage or deformation to connectors.
- ③ While transporting of products should ensure that no excessive force must be applied to the connectors and wires, and that no rain water, dust and dirt, etc. are present.
- ④ Handle products with care. If there is any damage, deformation, discoloration, etc. to wires, housings, and any other parts, do not use the damaged item. Replace the item with a new one.
- ⑤ Do not touch the soldering part of the connector with fingers or with any object.
- ⑥ Do not apply excessive current. Doing so may cause fire and melting damage.
- ⑦ Do not disassemble products.
- ⑧ Do not insert any terminals into housing other than those specified.
- ⑨ Follow this Manual for using the products. Do not use in any way other than instructed.

10. Inquiries

Sales Dept. Yokohama office I-PEX Inc.

TEL:+81-45-472-7111 FAX:+81-45-472-7130