

PowerMod® Contact System Crimp Specification

The following crimp tools have been approved for PowerMod Contacts:

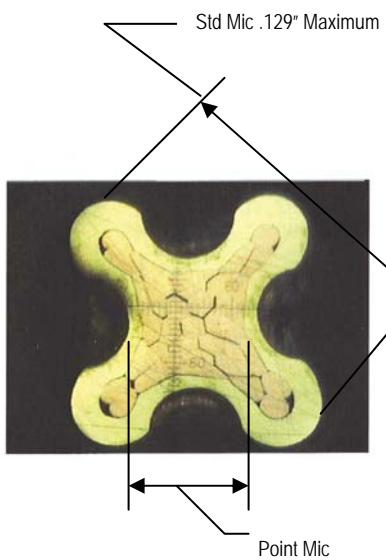
- PM1000G1 Hand Tool
- PM1001G1 Semi-automatic Pneumatic Tool
- TM0001 (Daniels AF8) Hand Tool with TL0002 (sockets) and TL0001 (pin) locators
- TP0001 (Daniels WA27F) Pneumatic Tool with TL0002 (sockets) and TL0001 (pin) locators

All the above tools make four indents.

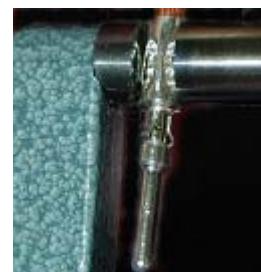
We recommend controlling the crimp process by:

1. Making samples
2. Measuring with point micrometer from both directions
3. Measuring with standard 1 inch micrometer
4. Performing a pullout test

If the pullout test is satisfactory per the customer Quality Specification, such as UL486A or UL1977, the point micrometer and standard micrometer checks can be performed frequently at the crimp operation and the destructive pullout test less frequently. The readings can be recorded on a SPC chart for better control.



Measure crimp dimension, two directions 90 deg apart



Measure the diagonal two directions 90 deg apart

DRAWN BY	
AMS	5/1/08

CHECKED BY	
DJD	5/5/08

ENGINEERING	
DAM	5/5/08

MFG	
CHB	5/5/08

QUALITY	
JJA	5/5/08

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HEADQUARTERS: Anderson Power Products®, 13 Pratts Junction Road, Sterling, MA 01564-2305 USA T: 978-422-3600 F: 978-422-3700 www.andersonpower.com