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## 1.0 OBJECTIVE

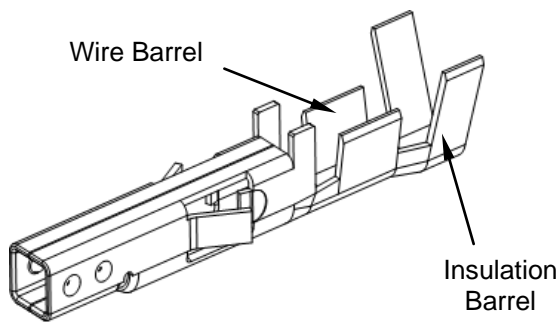
This specification provides information and requirements regarding customer application of Minitek Pwr4.2 crimp to wire connectors. This specification is intended to provide general guidance for application process development. It is recognized that no single application process will work under all customer scenarios and that customers will develop their own application processes to meet their needs. However, if these application processes differ greatly from the one recommended, Amphenol FCI cannot guarantee results.

## 2.0 SCOPE

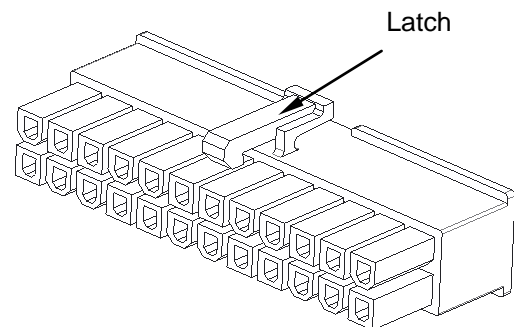
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## 3.0 GENERAL

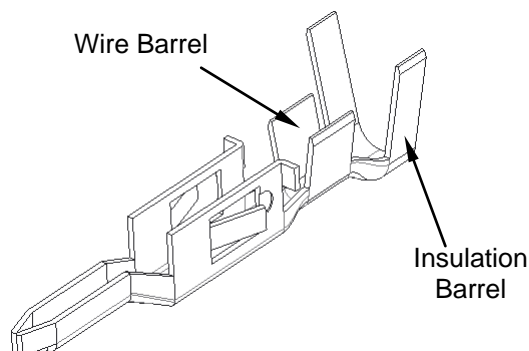
This document is meant to be an application guide. If there is a conflict between the product drawings and specifications, the drawings take precedence.



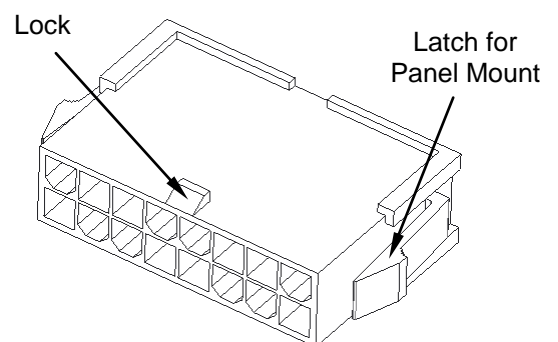
**Receptacle Terminal 10127817 Series**



**Receptacle HSG 10127815 Series**

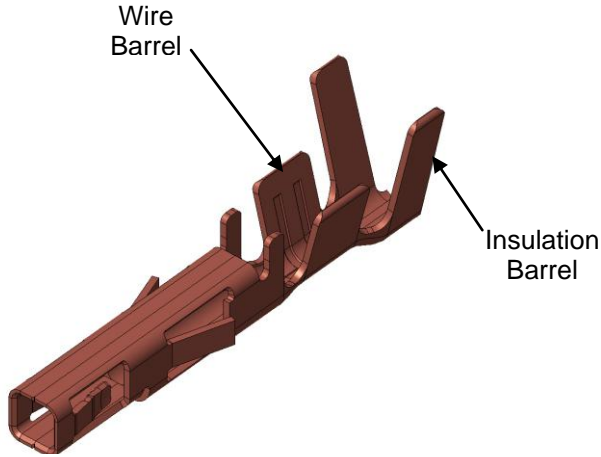


**Plug Terminal 10127818 Series**

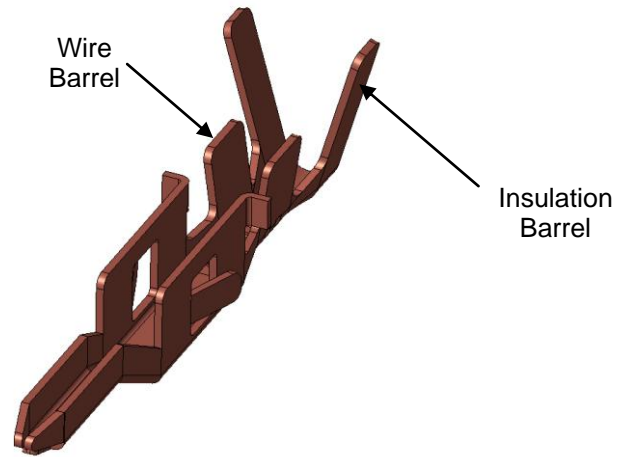


**Panel Mount, Plug HSG  
10127816 series**

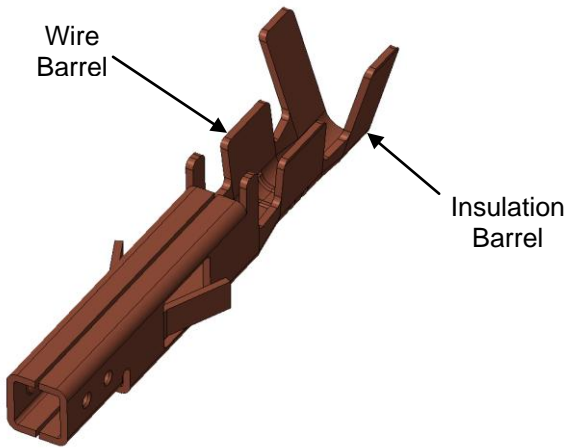
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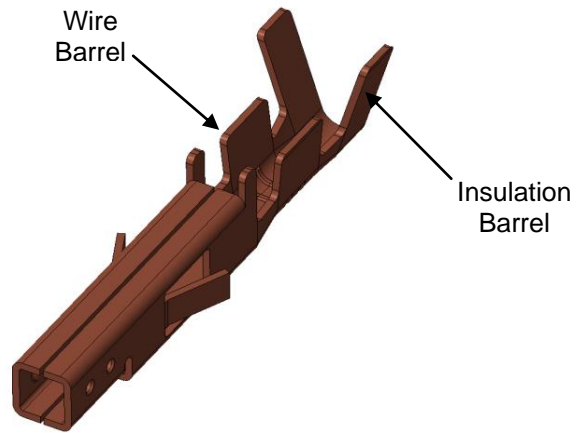
**Receptacle Terminal 10134170 Series**



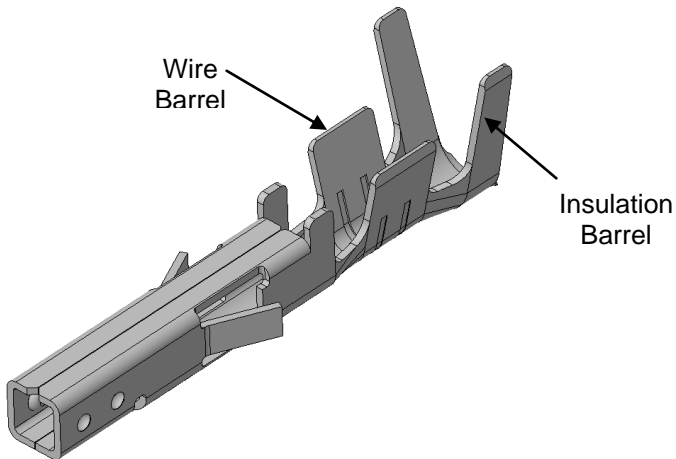
**Plug Terminal 10136290 Series**



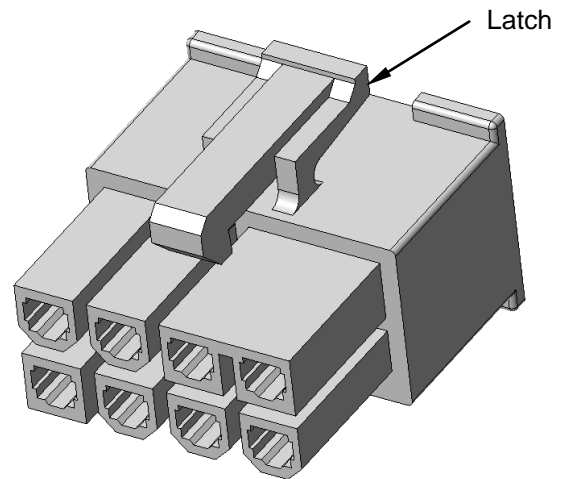
**Receptacle Terminal 10136289 Series**



**Receptacle Terminal 10130517 Series**

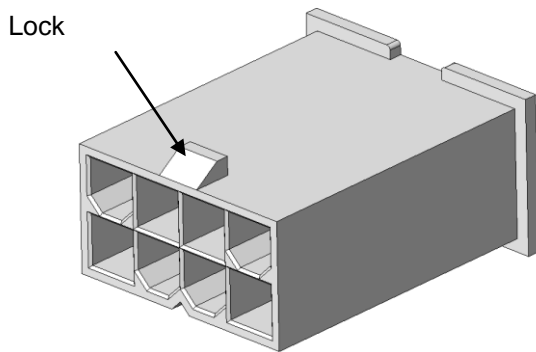


**Receptacle Terminal 1047578 Series**

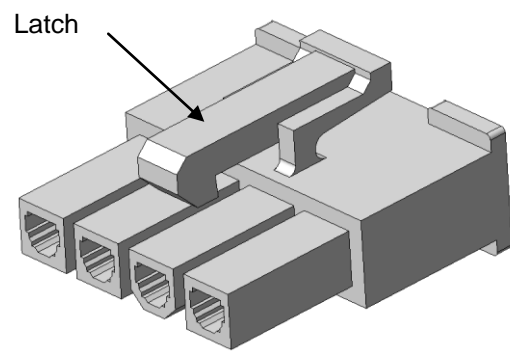


**Receptacle HSG 10147577 Series**

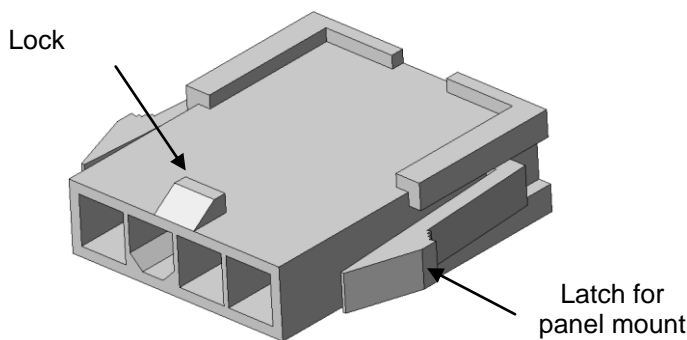
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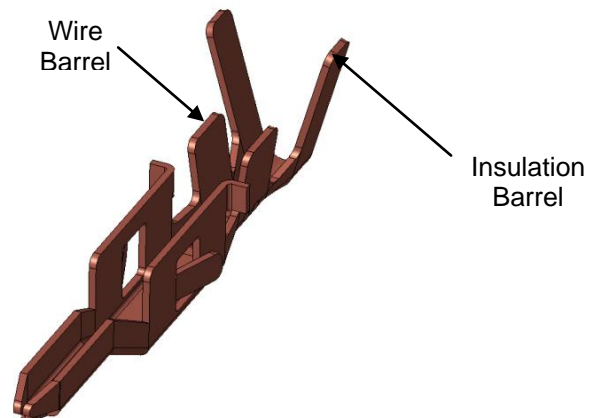
**Plug Housing 10144559 Series**



**Receptacle Housing 10136644 Series**



**Panel Mount Plug Housing 10136645 Series**



**Plug Terminal 10156852 Series**

#### 4.0 DRAWINGS AND APPLICABLE DOCUMENTS

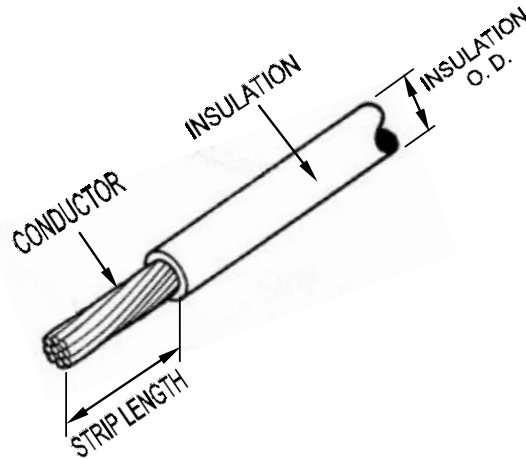
- 4.1 Amphenol FCI Product Specification: GS-12-1181, GS-12-1377, GS-12-1333, GS-12-1232, GS-12-1533 and GS-12-1626.
- 4.2 Amphenol FCI Application Specification: GS-20-0650 for TPA Receptacle and Plug Housing.
- 4.3 Amphenol FCI Product Drawing: Latest version of: 10127815 (Receptacle housing), 10127816 (Plug housing), 10153466 (TPA Receptacle housing), 10153592 (TPA Plug housing), 10153467 (TPA Receptacle housing), 10144559 (Plug housing), 10136644 (Receptacle housing), 10136645 (Plug housing), 10127817 (Receptacle crimp terminal), 10134170 (Receptacle crimp terminal), 10130517 (Receptacle HCC crimp terminal), 10136289 (Receptacle HCC crimp terminal), 10127818 (Plug crimp terminal), 10136290 (Plug HCC crimp terminal), 10147577 (PCIe Receptacle Housing), 10147578 (PCIe Receptacle crimp terminal) and 10156852 (Plug crimp terminal).

Product drawings and **Amphenol FCI's GS-XX-XXX** Product Specification are available at [www.amphenol-icc.com](http://www.amphenol-icc.com). In the event of a conflict between this application specification and the drawing, the drawing will take precedence. Customers are advised to refer to the latest revision level of Amphenol FCI product drawings for appropriate details.

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## 5.0 APPLICATION REQUIREMENTS

The wires in Table 1 are the wiring information for use with crimp terminals 10127817, 10127818, 10136289, 10136290, 10130517, 10134170 and 10156852.



**Table 1**

Crimp Terminal Part Number	Applicable Wire Gauge (AWG)	Insulation Outside Diameter (mm)	Strip Length (mm)
10127817-XX2XLF 10127818-XX2XLF	AWG 28 ~ 24	1.8 Max.	3 ~ 3.5
10127817-XX1XLF 10127818-XX1XLF	AWG 22 ~ 16	3.1 Max.	3 ~ 3.5
10134170-YX10LF	AWG 16	3.1 Max.	3 ~ 3.5
10134170-YX20LF	AWG 18 ~ 24	3.1 Max.	3 ~ 3.5
10134170-YX30LF	AWG 22 ~ 28	1.8 Max.	3 ~ 3.5
10130517-1X1XLF 10136289-1X1XLF	AWG 16 ~ 20	3.1 Max.	3 ~ 3.5
10136290-1X1XLF	AWG 16 ~ 20	3.1 Max.	3 ~ 3.5
10147578-XX1XLF	AWG 16 ~ 18	3.1Max	3 ~ 3.5
10156852-YX10LF	AWG 16 ~ 18	3.1Max	3 ~ 3.5
10156852-YX20LF	AWG 20~ 24	2.55Max	3 ~ 3.5
10156852-YX30LF	AWG 26~ 28	2.0Max	3 ~ 3.5

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## 6.0 APPLICATION TOOLING

There are some commercial crimping tools available for crimping terminals. Select the models listed in Table 2:

**Table 2: Crimping Tooling List**

Tool Description	Tool P/ N and Model No.	Applicable Terminal
Ratchet hand crimping tool	10129483-001LF	10127817-XXXLF 10127818-XXXLF

Semi-Auto crimping machine	Fully-Auto Pneumatic Crimping Applicator	Fully-Auto Mechanical Crimping Applicator	Applicable Terminal P/N
<b>Press P/N</b>			
10157923-001			
<b>Applicator P/N</b>	<b>Applicator P/N</b>	<b>Applicator P/N</b>	
10157894-001	10158621-001	10158622-001	10127818-XX2XLF
10157894-002	10158621-002	10158622-002	10134170-YX30LF
10157894-003	10158621-003	10158622-003	10127817-XX2XLF
10157894-004	10158621-004	10158622-004	10134170-YX20LF
10157894-005	10158621-005	10158622-005	10127817-XX1XLF 10130517-1X1XLF 10136289-1X1XLF
10157894-006	10158621-006	10158622-006	10134170-YX10LF
10157894-007	10158621-007	10158622-007	10127818-XX1XLF 10136290-1X1XLF
10157894-008	10158621-008	10158622-008	10156852-YX10LF
10157894-009	10158621-009	10158622-009	10156852-YX20LF
10157894-010	10158621-010	10158622-010	10156852-YX30LF
10157894-011	10158621-011	10158622-011	10147578-XX1XLF

(\*) Fully-Auto Pneumatic and mechanical applicators are suitable in Semi-auto Crimping machines.

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**Hand crimping tool**

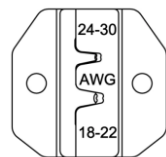
Hand Crimping Tool P/N	Applicable Terminal P/N
10159388-001	10134170-YX10LF 10136852-YX10LF* 10147578-XX1XLF*
10159388-002	10127817-XX1XLF 10127818-XX1XLF 10130517-1X1XLF 10136289-1X1XLF 10136290-1X1XLF
10159388-003	10127817-XX2XLF 10127818-XX2XLF
10159388-004	10134170-YX30LF 10136852-YX30LF
10159388-005	10134170-YX20LF 10136852-YX10LF** 10147578-XX1XLF** 10136852-YX20LF

(\* ) Use this terminal with 16AWG wire.

(\*\* ) Use this terminal with 18AWG wire.



**10129483-001LF**

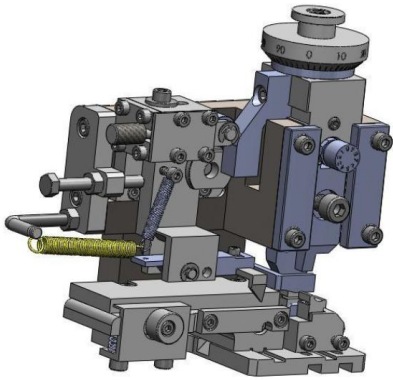


**(Crimping Die)**

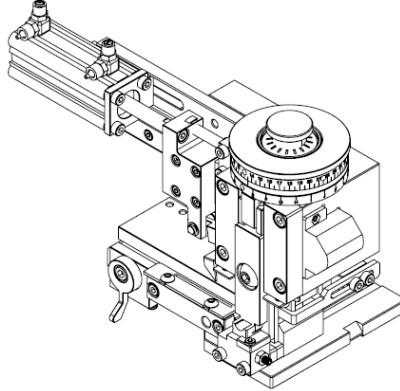


**10157923-001**

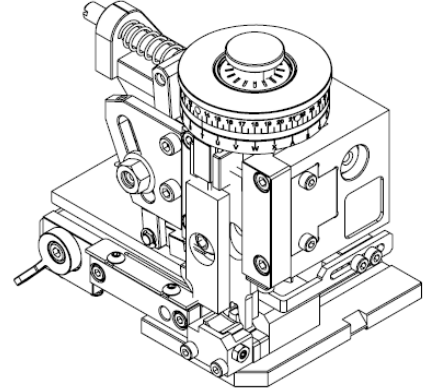
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10157894



10158621



10158622

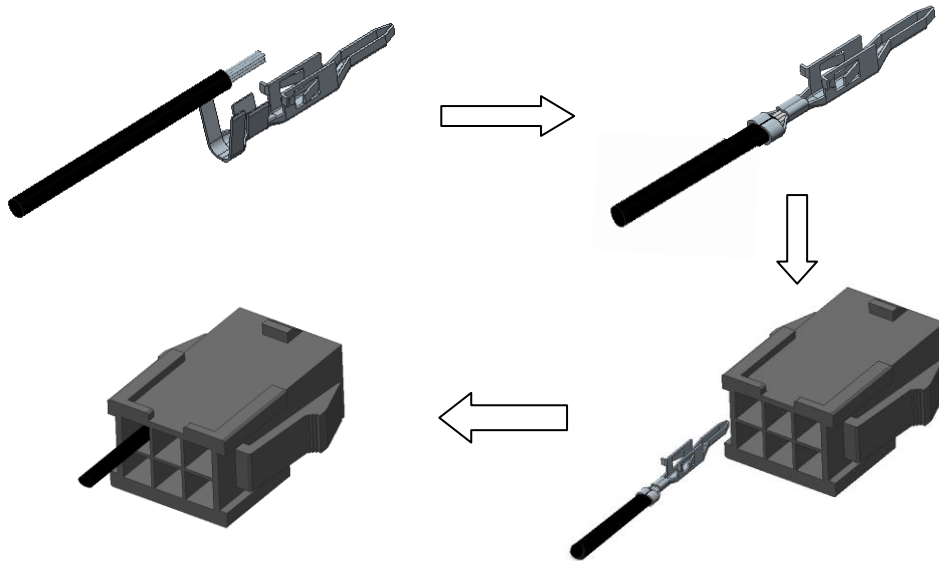


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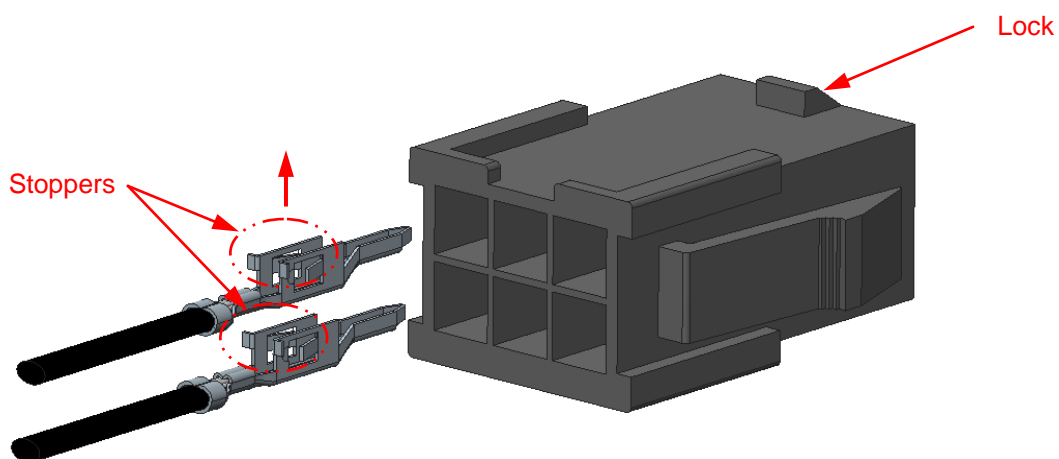
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## 7.0 APPLICATION PROCEDURE

- 7.1 Strip the wire (Table 1) Crimp wire and inserting to housing. No insertion tool is required. (Same for 10127817-XXXLF, 10127818-XXXLF, 10134170-YXXXLF, 10130517-1X1XLF, 10136289-1X1XLF, 10136290-1X1XLF, 10147578-XX1XLF and 10156852-YXXXLF)



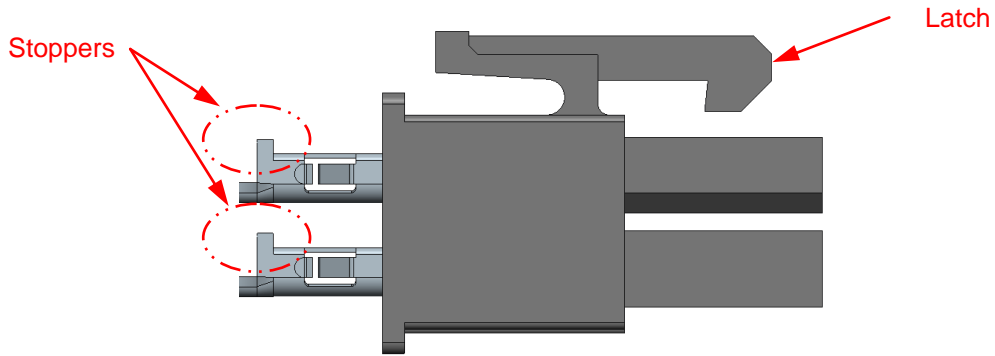
- 7.2 Make sure the stoppers on the terminals are always upwards for both rows: towards the lock (latch) of Housing. (Same for 10127817-XXXLF, 10127818-XXXLF, 10134170-XXXLF, 10130517-1X1XLF, 10136289-1X1XLF, 10136290-1X1XLF, 10147578-XX1XLF and 10156852-YXXXLF)



**10127818 Inserted to 10127816**

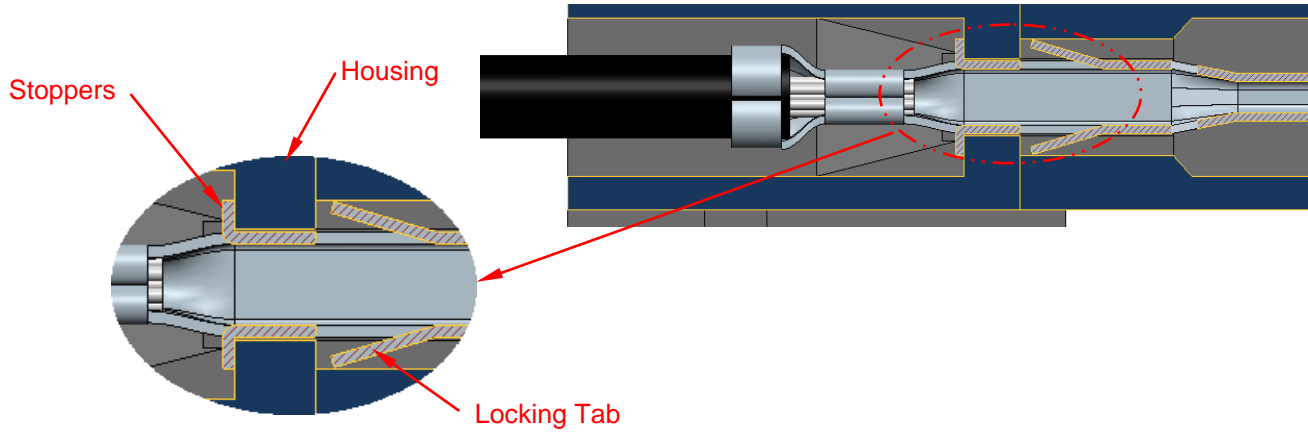


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10127817 Inserted to 10127815

- 7.3 Insert the terminal into Housing until stopped by Housing. Then locking tabs will be engaged the retention shoulder and prevent back out during mating. Pull back the wire slightly and ensure the terminal is fully seated on the Housing.

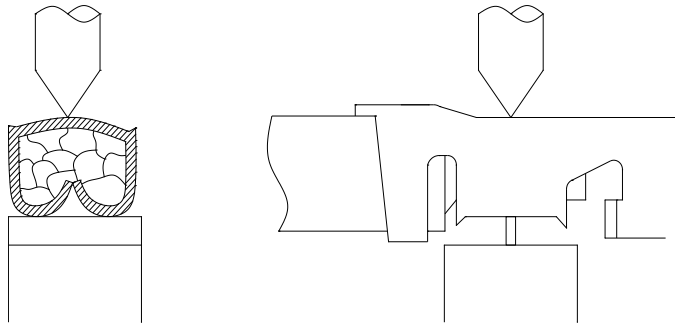


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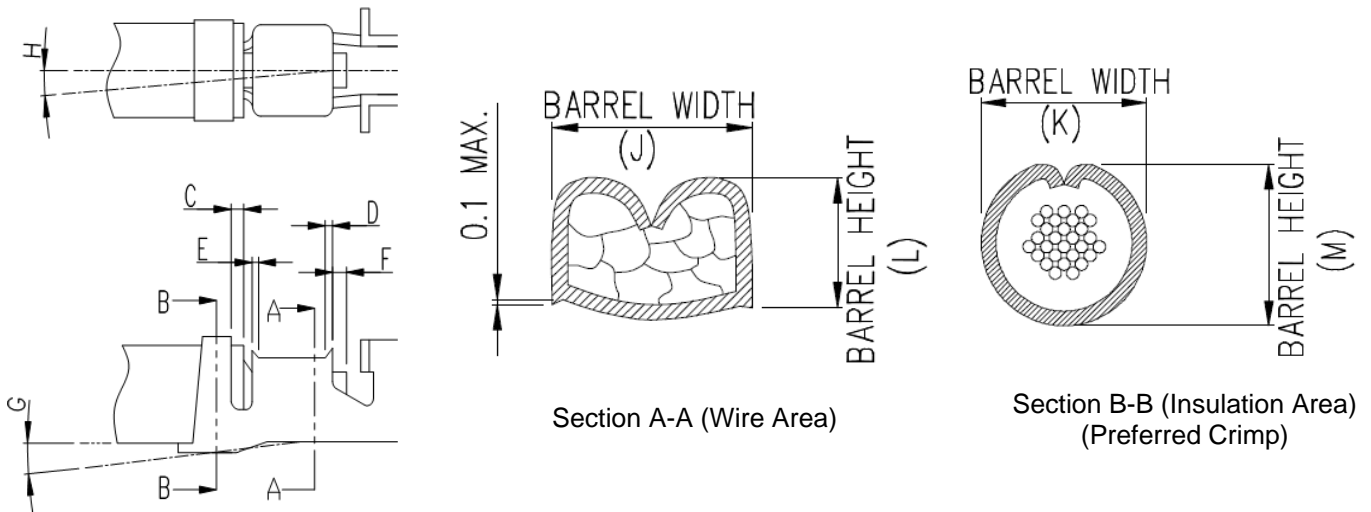
## 8.0 POST- APPLICATION INSPECTION PROCEDURES

### 8.1 Crimp height and width measurement:

8.1.1 Use Crimp Height Type Micrometers to measure crimping height.



8.2 Required crimping dimensions, crimp height and width for different wire AWG are defined in Table 3, Table 4 and Table 5.



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**Table 3 (unit: mm)**

Item		Requirement	Note
Insulation position	C	20% to 75% of Inspection window	Insulation and wire should be visual in this area
Front bell mouth	D	0.40 mm max.	
Rear bell mouth	E	0.40 mm max.	
Extruded wire length	F	0.90 Max.	
Bend up / down	G	±3° max.	
Bend right / left	H	±3° max.	

**Table 4 (Unit: mm) For Ratchet hand crimping tool**

Crimping Width & Height (mm)		AWG 16	AWG 18	AWG 20	AWG 22	AWG 24	AWG 26	AWG 28
Crimping Width (Wire barrel)	J	2.00	1.95	1.90	1.85	1.80	1.70	1.60
Crimping Width (Insulation barrel)	K	3.20	2.90	2.70	2.40	2.20	2.00	1.90
Crimping Height (Wire barrel)	L	1.60	1.50	1.30	1.20	1.10	1.00	0.90
Crimping Height (Insulation barrel)	M	3.00	2.50	2.30	2.10	2.00	1.90	1.70

\* When using hand crimping tool, crimping height K & M in this table are reference only. Because the range of wires, strands and insulation OD will affect the actual crimping height.

\*\* Pullout force should be performed to check the hand crimping tool.

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**Table 5 (Unit: mm) For Crimping Applicators**

Series	Part Number	Tool Part Number	AWG Range	Conductor		Insulation	
				Crimp Height	Crimp Width	Crimp Height (Max)	Crimp Width
10134170	10134170-YX10LF	10157894-006	16	1.20 – 1.30	1.90	3.35 Ref	2.76 Ref
		10158621-006					
		10158622-006					
	10134170-XX20LF	10157894-004 10158621-004 10158622-004	18	1.05 – 1.15	1.55	3.35 Ref	2.70 Ref
			20	1.00 – 1.10	1.55	3.35 Ref	2.70 Ref
			22	0.85 – 0.95	1.55	3.35 Ref	2.70 Ref
			24	0.85 – 0.95	1.55	3.35 Ref	2.70 Ref
	10134170-XX30LF	10157894-002 10158621-002 10158622-002	22	0.77 – 0.87	1.40	1.70 Ref	2.05 Ref
			24	0.70 – 0.80	1.40	1.70 Ref	2.05 Ref
			26	0.70 – 0.80	1.40	1.70 Ref	2.05 Ref
28			0.70 – 0.80	1.40	1.70 Ref	2.05 Ref	
10127818 10136290	10127818-XX2XLF	10157894-001	24	0.92 – 1.02	1.45	2.25 Ref	2.30 Ref
		10158621-001	26	0.90 – 1.00	1.45	2.25 Ref	2.30 Ref
		10158622-001	28	0.88 – 0.98	1.45	2.25 Ref	2.30 Ref
	10127818-XX1XLF 10136290-1X1XLF	10157894-007 10158621-007 10158622-007	18	1.10 – 1.20	1.65	3.35 Ref	2.70 Ref
			20	0.95 – 1.05	1.65	3.35 Ref	2.70 Ref
			22	0.95 – 1.05	1.65	3.35 Ref	2.70 Ref
10127817 10130517 10136289	10127817-XX2XLF	10157894-003	24	0.92 – 1.02	1.45	2.25 Ref	2.30 Ref
		10158621-003	26	0.90 – 1.00	1.45	2.25 Ref	2.30 Ref
		10158622-003	28	0.88 – 0.98	1.45	2.25 Ref	2.30 Ref
	10127817-XX1XLF 10130517-1X1XLF 10136289-1X1XLF	10157894-005 10158621-005 10158622-005	18	1.10 – 1.20	1.65	3.35 Ref	2.70 Ref
			20	0.95 – 1.05	1.65	3.35 Ref	2.70 Ref
			22	0.95 – 1.05	1.65	3.35 Ref	2.70 Ref
10156852	10156852-YX10LF	10157894-008	16	1.20 – 1.30	1.90	3.35 Ref	2.76 Ref
		10158621-008 10158622-008	18	1.05 – 1.15	1.90	3.35 Ref	2.76 Ref
	10156852-YX20LF	10157894-009 10158621-009 10158622-009	20	1.00 – 1.10	1.55	3.35 Ref	2.70 Ref
			22	0.85 – 0.95	1.55	3.35 Ref	2.70 Ref
			24	0.85 – 0.95	1.55	3.35 Ref	2.70 Ref
	10156852-YX30LF	10157894-010 10158621-010 10158622-010	26	0.70 – 0.80	1.40	1.70 Ref	2.05 Ref
			28	0.70 – 0.80	1.40	1.70 Ref	2.05 Ref
10147578	10147578-XX1XLF	10157894-011	16	1.20 – 1.30	1.90	3.35 Ref	2.76 Ref
		10158621-011 10158622-011	18	1.05 – 1.15	1.90	3.35 Ref	2.76 Ref

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Table 6 (Unit: mm) For Hand Crimping tool

Series	Part Number	Tool Part Number	AWG Range	Conductor		Insulation	
				Crimp Height	Crimp Width	Crimp Height (Max)	Crimp Width
10134170	10134170-YX10LF 10156852-YX10LF 10147578-XX1XLF	10159388-001	16	1.20 – 1.30	1.90	3.35 Ref	2.76 Ref
	10134170-XX20LF 10156852-YX20LF 10156852-YX10LF 10147578-XX1XLF	10159388-001	18	1.05 – 1.15	1.55	3.35 Ref	2.70 Ref
			20	1.00 – 1.10	1.55	3.35 Ref	2.70 Ref
			22	0.85 – 0.95	1.55	3.35 Ref	2.70 Ref
			24	0.85 – 0.95	1.55	3.35 Ref	2.70 Ref
	10134170-XX30LF 10156852-YX30LF	10159388-001	22	0.77 – 0.87	1.40	1.70 Ref	2.05 Ref
			24	0.70 – 0.80	1.40	1.70 Ref	2.05 Ref
			26	0.70 – 0.80	1.40	1.70 Ref	2.05 Ref
			28	0.70 – 0.80	1.40	1.70 Ref	2.05 Ref
	10127818 10136290 10127817 10130517 10136289	10127818-XX2XLF	10157894-001	24	0.92 – 1.02	1.45	2.25 Ref
10158621-001			26	0.90 – 1.00	1.45	2.25 Ref	2.30 Ref
10158622-001			28	0.88 – 0.98	1.45	2.25 Ref	2.30 Ref
10127818-XX1XLF 10136290-1X1XLF		10157894-007	18	1.10 – 1.20	1.65	3.35 Ref	2.70 Ref
		10158621-007	20	0.95 – 1.05	1.65	3.35 Ref	2.70 Ref
		10158622-007	22	0.95 – 1.05	1.65	3.35 Ref	2.70 Ref
10127817 10130517 10136289	10127817-XX2XLF	10157894-003	24	0.92 – 1.02	1.45	2.25 Ref	2.30 Ref
		10158621-003	26	0.90 – 1.00	1.45	2.25 Ref	2.30 Ref
		10158622-003	28	0.88 – 0.98	1.45	2.25 Ref	2.30 Ref
	10127817-XX1XLF 10130517-1X1XLF 10136289-1X1XLF	10157894-005	18	1.10 – 1.20	1.65	3.35 Ref	2.70 Ref
		10158621-005	20	0.95 – 1.05	1.65	3.35 Ref	2.70 Ref
		10158622-005	22	0.95 – 1.05	1.65	3.35 Ref	2.70 Ref
10156852	10156852-YX10LF	10157894-008	16	1.20 – 1.30	1.90	3.35 Ref	2.76 Ref
		10158621-008	18	1.05 – 1.15	1.90	3.35 Ref	2.76 Ref
		10158622-008	20	1.00 – 1.10	1.40	1.70 Ref	2.05 Ref
	10156852-YX20LF	10157894-009	22	0.77 – 0.87	1.40	1.70 Ref	2.05 Ref
		10158621-009	24	0.70 – 0.80	1.40	1.70 Ref	2.05 Ref
		10158622-009	26	0.70 – 0.80	1.40	1.70 Ref	2.05 Ref
	10156852-YX30LF	10157894-010	28	0.70 – 0.80	1.40	1.70 Ref	2.05 Ref
10158621-010 10158622-010							
10147578	10147578-XX1XLF	10157894-011	16	1.20 – 1.30	1.90	3.35 Ref	2.76 Ref
		10158621-011 10158622-011	18	1.05 – 1.15	1.90	3.35 Ref	2.76 Ref

8.3 Pullout force measurement:

- 8.3.1 After crimping, pullout force measurement should be applied to ensure the performance. Follow test procedure of GS-12-1181, GS-12-1377, GS-12-1333, GS-12-1232, GS-12-1626 and GS-12-1626.
- 8.3.2 Apply an axial pullout force on the wire at a rate of 25 ± 6 mm.
- 8.3.3 Pullout force should not be less than those listed in Table 7.

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**Table 7 (unit: N)**

Wire AWG	AWG 16	AWG 18	AWG 20	AWG 22	AWG 24	AWG 26	AWG 28
Wire Pullout Force	88	88	59	39	29	19	9.8

8.4 Visual Inspection:

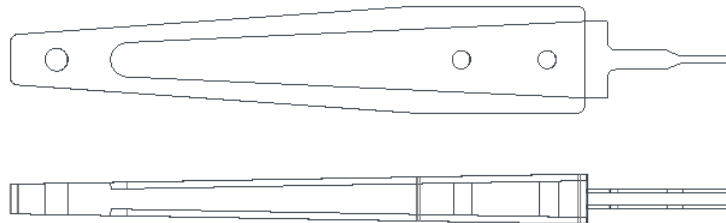
- 8.4.1 No damage, deformation on locking tabs, contact area or other portion of the terminals.
- 8.4.2 Insulation should not be crimped into wire barrel.
- 8.4.3 Wire should not be cut-off and insulation should not be broken after crimping process.

**9.0 REPAIR TOOLING**

The tool needed for extracting terminals from Housing is defined in Table 7:

**Table 7**

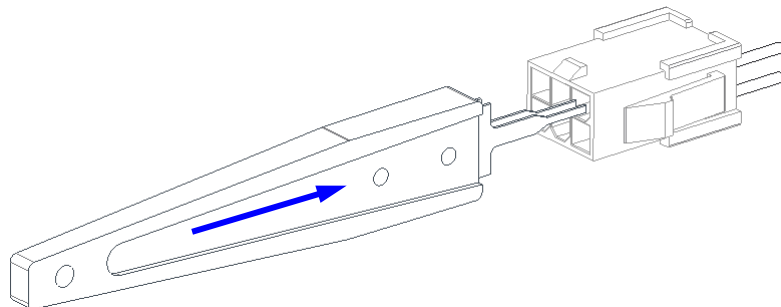
Tool P/N	Tool Description	Applicable Terminal P/N
FCI 10129274-042LF	Terminal extract tool	10127817 , 10127818, 10134170, 10130517, 10136289, 10136290 and 10147578 series



**10.0 REPAIR / REMOVAL PROCEDURE**

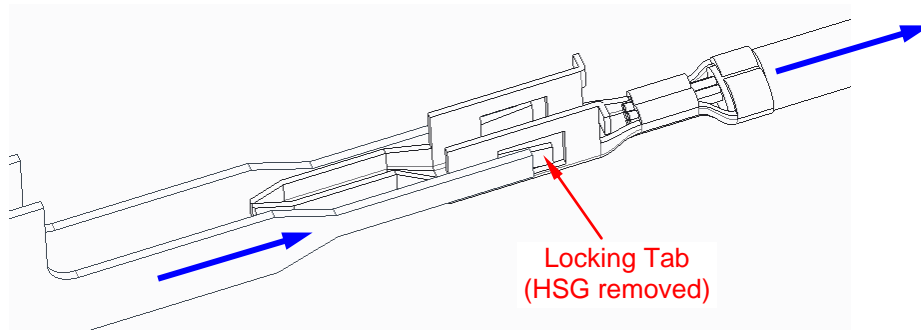
10.1 Use the extract tool 10129274-042LF to replace or repair individual terminal which is in the Housing.

10.1.1 Insert the extract tool into Housing.

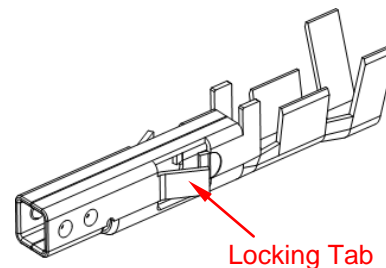
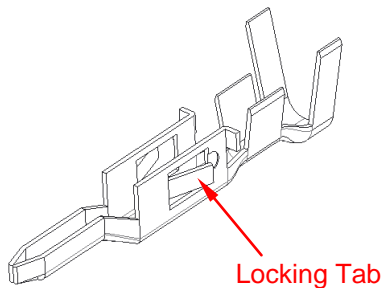


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10.1.2 Depress locking tabs on the terminals and pull out terminal from HSG.



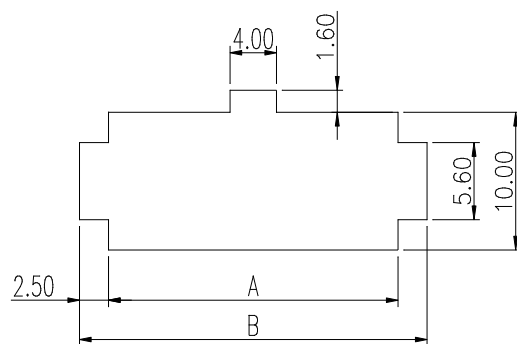
10.2 To reuse the removed terminal, need to reset the locking tabs before the terminal is inserted into the Housing. (not recommend)



## 11.0 OTHERS

### 11.1 Panel mount application

11.1.1 Applicable for plug Housing 10127816 series + Terminal 10127818 and 10136290 series.

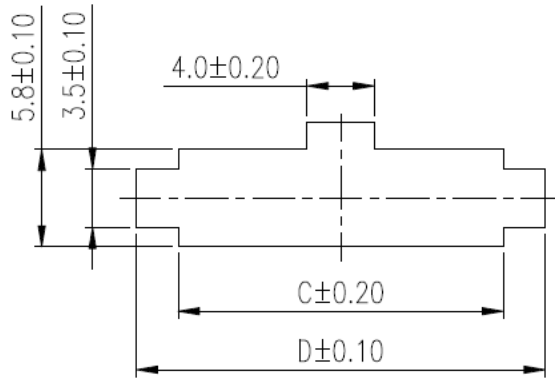


Opening for panel mount application  
Recommended maximum panel thickness: 2.54mm

PART NUMBER	POS.	A	B
10127816-02LF	2	5.8	10.8
10127816-04LF	4	10.0	15.0
10127816-04LF	6	14.2	19.2
10127816-08LF	8	18.4	23.4
10127816-10LF	10	22.6	27.6
10127816-12LF	12	26.8	31.8
10127816-14LF	14	31.0	36.0
10127816-16LF	16	35.2	40.2
10127816-18LF	18	39.4	44.4
10127816-20LF	20	43.6	48.6
10127816-22LF	22	47.8	52.8
10127816-24LF	24	52.0	57.0

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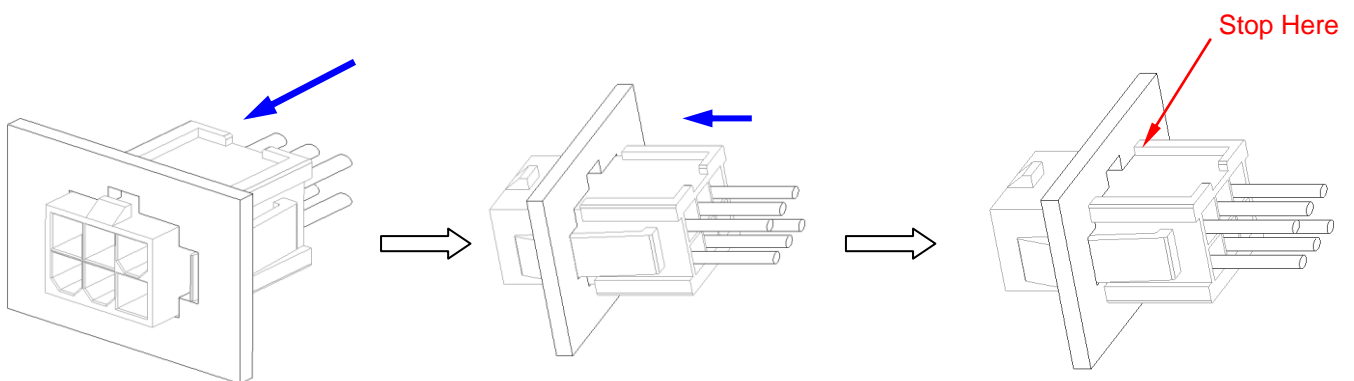
11.1.2 Applicable for plug Housing 10136645 series + Terminal 10127818 and 10136290 series.



POS.	A	B	C	D
03	13.8	8.4	14.4	19.4
04	18.0	12.6	18.6	23.6
05	22.2	16.8	22.8	27.8

Opening for panel mount application  
Recommended maximum panel thickness: 2.54mm

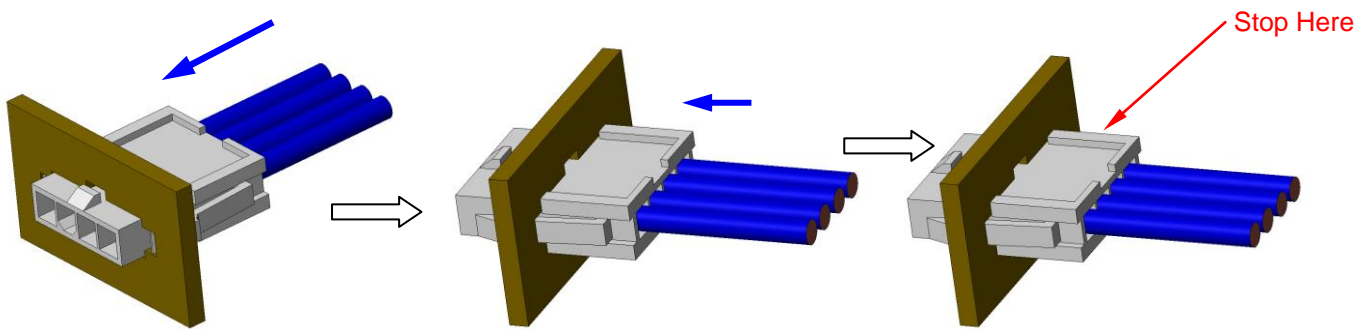
11.1.3 When plug Housing (10127816 series) is assembled with crimped terminals (10127818 and 10136290 series), insert it to the panel until it is stopped on the panel. No mounting tool is required.





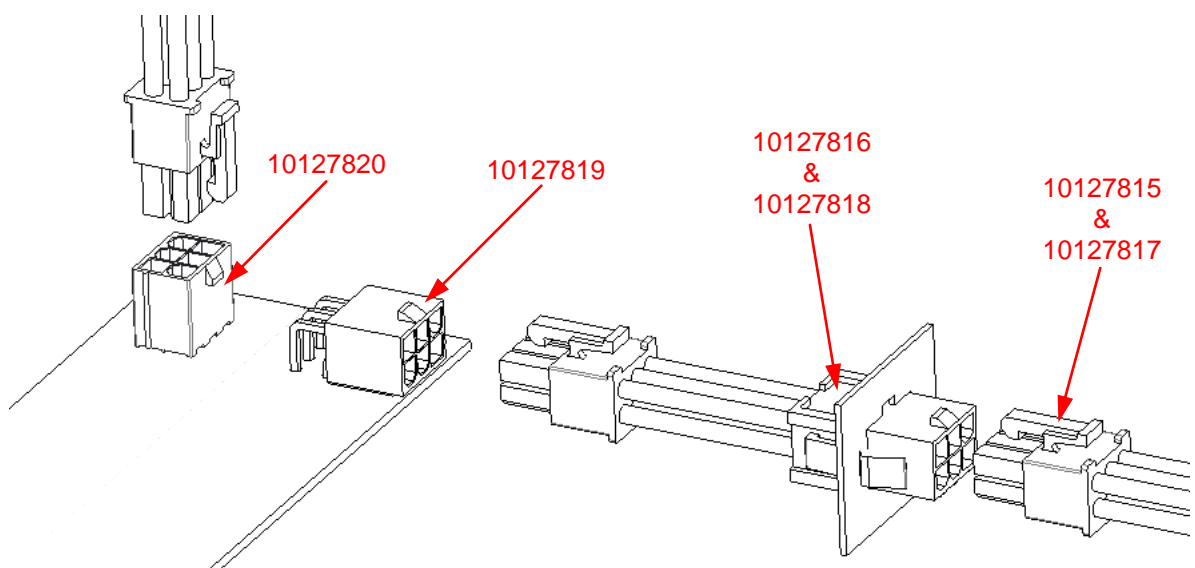
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11.1.4 When plug housing (10136645 series) is assembled with crimped terminals (10127818 and 10136290 series), Insert it to the panel until it is stopped on the panel. No mounting tool is required.



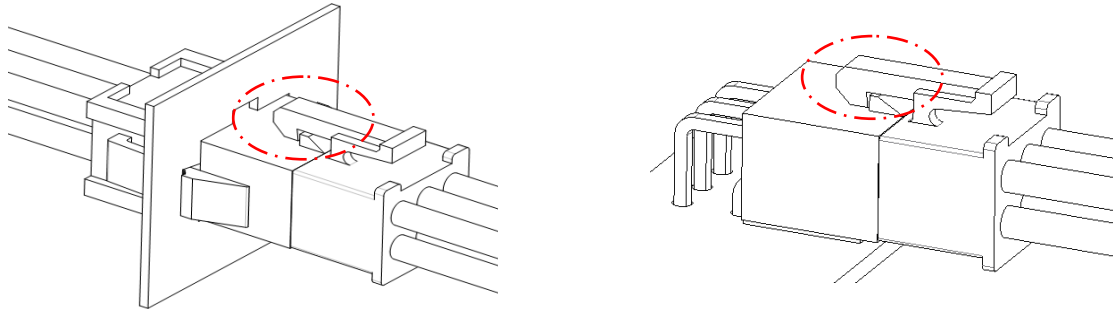
11.2 Mating Pairs: Receptacle wire connector 10127815, with receptacle crimping terminals 10127817 inserted, can mate with the following Amphenol FCI wire / board connectors:

- 11.2.1 Plug wire connector 10127816 with plug crimping terminals 10127818 inserted;
- 11.2.2 Right angle board connector 10127819;
- 11.2.3 Vertical board connector 10127820;



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11.3 During connectors mating, make sure latch on the receptacle wire connector is fully secured to the lock on plug wire connector or board connectors.



11.4 Mating Pairs: Receptacle wire connector 10147577, with receptacle crimping terminals 10147578 inserted, can mate with the following Amphenol FCI wire / board connectors:

- 11.4.1 Vertical Board connector 10147579.
- 11.4.2 Right Angle Board connector 10147580.

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**RECORD RETENTION**

REV	PAGE	DESCRIPTION	EC#	DATE
A	All	New Release		2014/3/17
B	All	<ul style="list-style-type: none"> <li>• Change Authorized and Sign in all page</li> <li>• Added 10134170, 10136289, 10136290 and 10130517 terminal series.</li> <li>• Added 10136645, 10144559, 10136644 series Receptacle and plug housings.</li> <li>• Added 10153466, 10153467, 10147578, 10147577, 10147578 and 10153592 series TPA receptacle and plug housings.</li> <li>• Updated 10134170 terminal series Crimping Specification with new developed crimping machine.</li> <li>• Added Panel mounting view for 10136645 series.</li> </ul>	ELX-I-40965	2021/05/20