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1. OBJECTIVE

This specification provides information and requirements regarding the crimp conditions and requirements for the Minitek[™] CTW terminals 77138, 10044403 and 10153651 series. Stranded wires 7x and 19x recommended. Other wires should be verified by trials. 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, AFCI cannot guarantee results

2. SCOPE

This specification provides information and requirements regarding the crimp conditions and requirements for the Minitek[™] CTW terminals 77138 10044403 and 10153651 series

3. DRAWINGS AND APPLICABLE DOCUMENTS

- AFCI PRODUCT SPECIFICATION GS-12-415 and 110-036
- AFCI PRODUCT DRAWINGS
- APPLICATION MANUALS/INSTRUCTION SHEETS (IF NOT INCLUDED IN THIS DOCUMENT)

Product drawings and **AFCI's GS-12-415 and 110-036**. Product Specification are available on Website 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 AFCI product drawings for appropriate details.

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4. APPLICATION REQUIREMENTS





Terminal P/N	Wire Range	Wire barrel (mm)		Insulator Barrel (mm)		AWG	Crimp Strength	
	AWG (IIIII-)	Width	Height	Width	Height		(Newton)	
10044403-X01LF	22-24 (0.35 - 0.23)	1.2	0,76 to 0,82	1,4 Max	1,4 max	22-24	35N MIN	
10044403-X01LF	26 (0.13)	1.2	0,67 to 0,75	1,4 Max	1.25 to 1.50	26	20N MIN	
						26	20N MIN	
77138-X01LF	26-30 (0.13-0.05)	1	1 0,57 to 0,68	1,5 Max	1,4 max	28	12N MIN	
						30	7 N MIN	
10153651-X01LF	30 (0.05-0.06)	0.8	0.43 to 0.49	1 max	1.1 max	30	7 N MIN	

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ltem		Requirement	Note
Bend up / down	1	±3° max.	
Twist	(1)a	3° max.	
Rolling	(1)b	8° max.	
Bell mouth	2	0.1 - 0.4mm	
Cut-off Tab length	3	0 – 0.3mm	
Strip length	4	1.2 – 2.2mm	
Soom	5	-	No evidence of seam opening
Jean			No strands out of wire barrel
Extruded wire length	6	0.6mm max.	
Inculation position	$\overline{\mathcal{O}}$	0.5	Insulation and wire should be both visual in this
insulation position	9	0.5 mm	area
Bend right / left	8	1.6 MAX.	

See figures below



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5. APPLICATION TOOLING

			Applicator P/N		
Terminal P/N	Recommended Insulator Diameter max	AWG	Manual Crimping Tool Very small volume Sample prototype	Semi-Automatic Crimping (Photo for information only)	
10044403-X01LF	Ø1.4	22-24	RCY21153W (*) 10161577-001 (**)	RCY20036	
10044403-X01LF	Ø1.1	26	RCY21151W(#26 - #30) 10161576-001 (**)	RCY20010	
77138-X01LF	Ø0.9 to Ø1.1	26-30	RCY21151W(#26 - #30) 10161576-001 (**)	RCY20010	
10153651-X01LF	Ø0.62	30	N/A	F-OSERT01 P/N: 10160412	

Manual and Semi-Automatic Application Toolings needed for installation of Housing Terminal 10153651 are defined in Table (Above).

The crimp made by using the hand tool is not recommended to production or qualification use.

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6. Crimping conditions : Incorrect and Correct.



EFCi Basics

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REVISION RECORD

Rev	Page	Description	EC#	Date
Α	ALL	New release	J07-0050	1/26/07
В	ALL	Redrawn for all Both AWG 22-24 & 26-30, add figures for crimping methods. Supersede 100-006 specification	ECN-ELX-B-011934-1	06/11/12
С	1	Change Board 3.0	F-21875	15/09/08
D	3	Delete height dimensions / add "see table"	F-29217	18/01/31
E	1	Add information about using 10044403 with AWG 26 wire and additional insulation size diameter	F-37052	20/05/15
F	1	Change wire barrel height for 10044403-X01LF AWG 26 0,67 to 0,73 change to 0,67 to 0,75	F-38281	20/09/08
G	1	Update table of P/N 3.0	F-40586	07/04/2021
Н	1	Global update of all informations and layout	F-44179	17/03/2022
J	4	Add tool 10161576-001 for 10044403-X01LF	F-49629	31/10/2023