

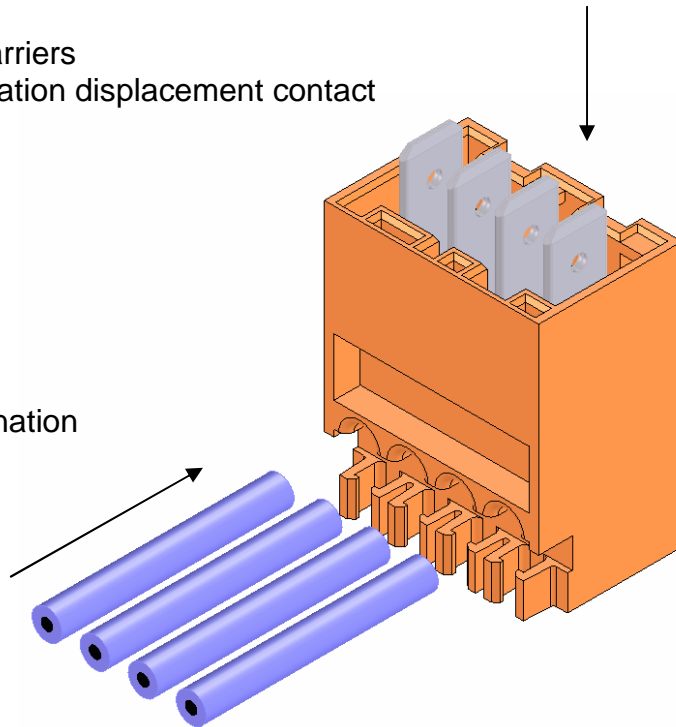
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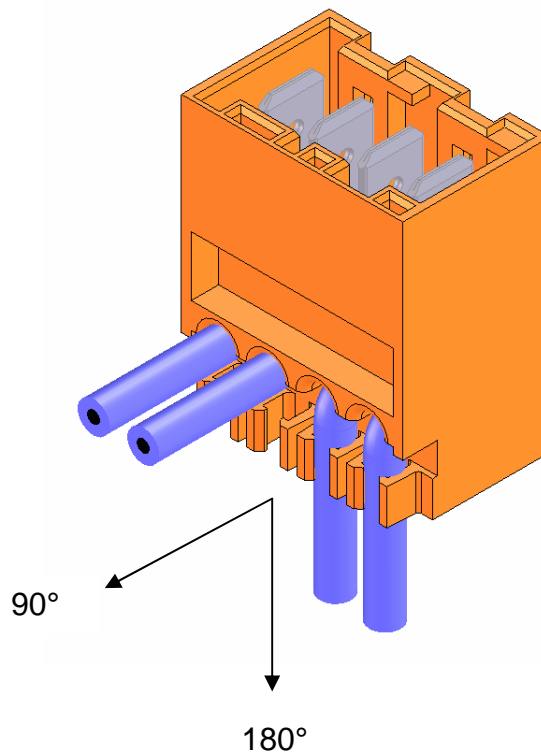
1 System features

One-piece body
Delivered in bar stock carriers
Flat connector with insulation displacement contact

Wire termination

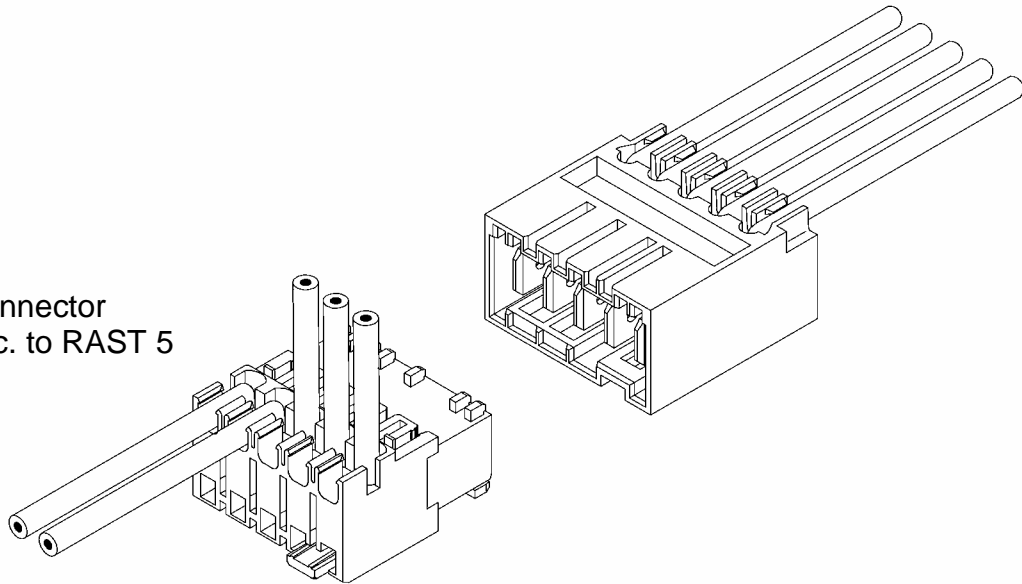


Insulation displacement connection by pressing the contacts
Wire exit 90° and 180°

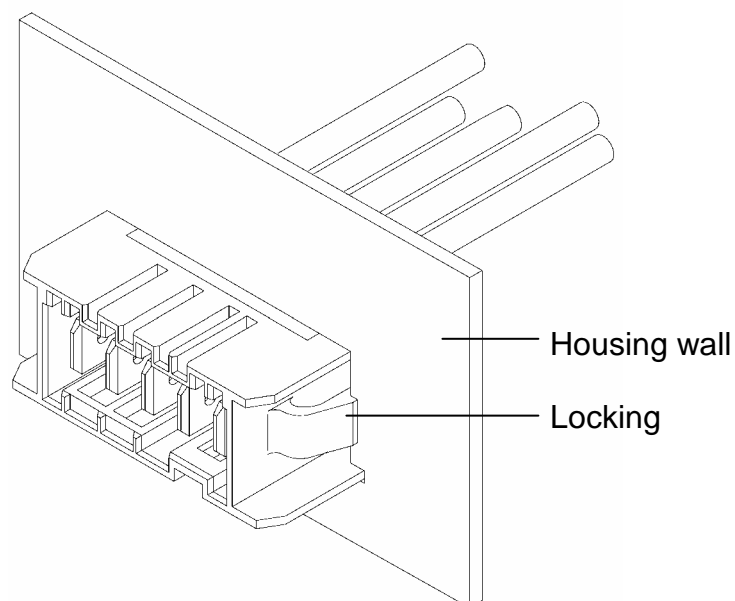


Tab header 3647 ...
for cable-to-cable connections

Connector
acc. to RAST 5



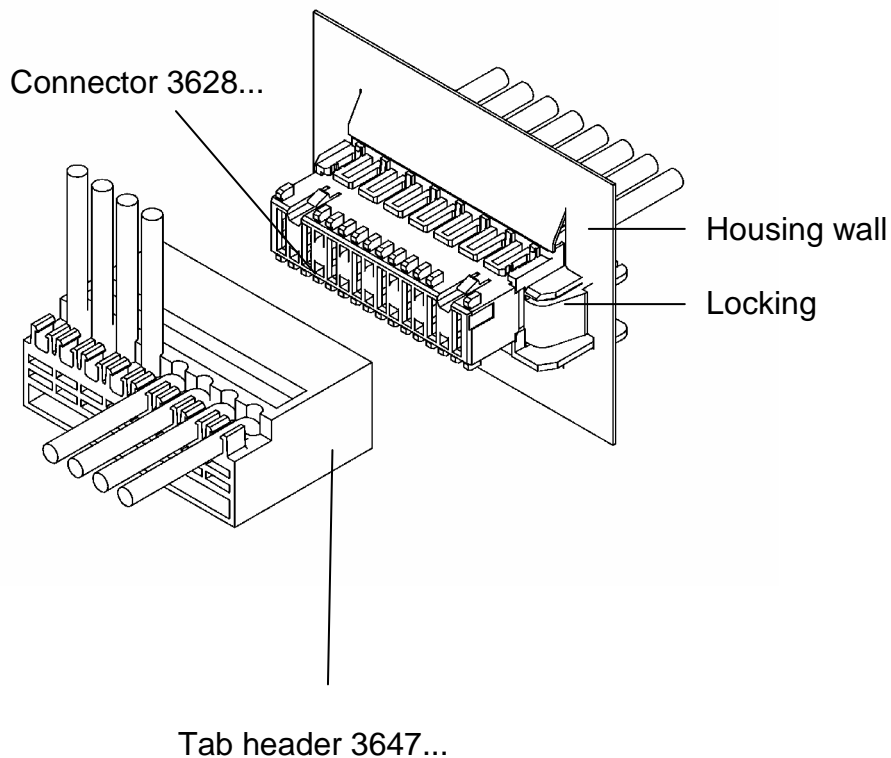
Mounting tab header 3648....
for mounting in housing



Processing Instruction

Tab headers in IDT MACROMODUL – Tab headers

Tab header 3647 ...
with mounting socket board 3628...



1.1 Product types

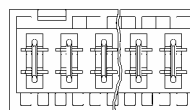
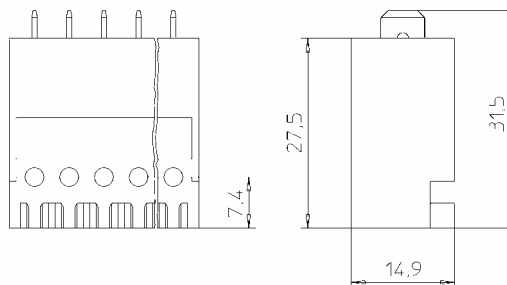
Tab headers in IDT,
pitch 5 mm

Tab header 3647

for 6A/10A
2...8-pole

cross section for connection 0,50...0,75 mm²

acc. to spec sheet 3647 01

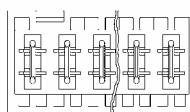
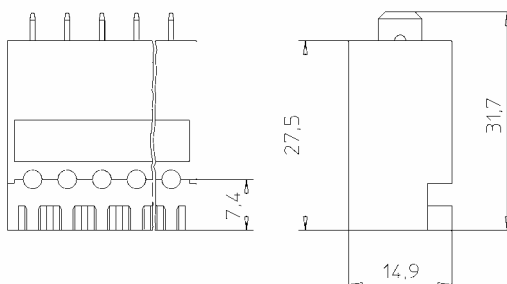


Tab header 3647 - 1

for 5A/10A (high temperature)
2...8-pole

cross section for connection 1,0 mm²

acc. to spec sheet 3647 05

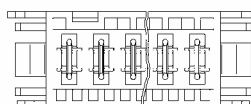
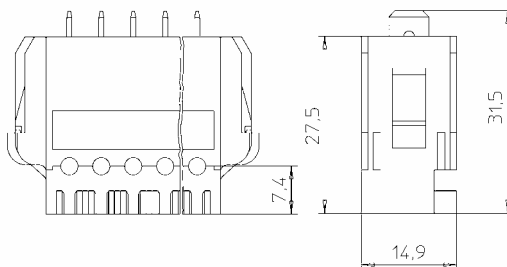


Mounting tab header 3648

for 6A/10A
2...8-pole

cross section for connection 0,5...0,75 mm²

acc. to spec sheet 3648 01

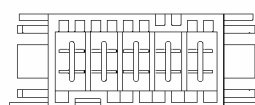
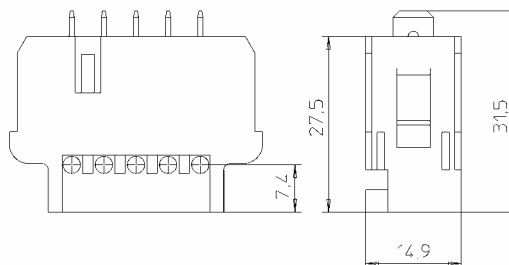


Mounting tab header 3648 - 2

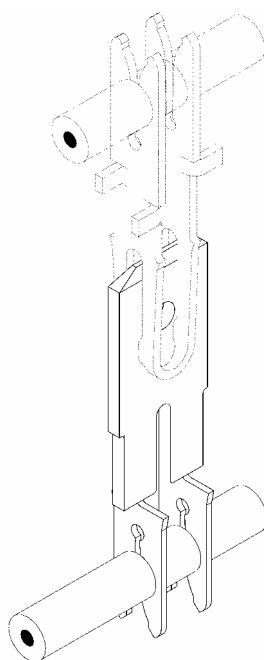
for 6A / 10A (bus application)
2...8-pole

cross section for connection 0,5...0,75 mm²

acc. to spec sheet 3648 02

**2 Contact principle**

Flat connector
acc. to DIN 46244
6,8 x 0,8



Insulation displacement connection
(test acc. to DIN EN/IEC 60352-4)

3 Application tooling and machines

Function, safety and quality of the connectors are only guaranteed by using of LUMBERG processing equipment.

The user bears full responsibility if any other processing equipment is used.

In case of using any lubricants or sliding agents in the feed and press areas residues (impurities) must not come into contact with the connectors.

3.1 Tools

3.1.1 Hand press type KHP364

For termination of single wires or ribbon cables. For single and small series.

3.2 Semi-automatic machines

3.2.1 Semi-automatic termination machine type HA364

For cost-effective termination of single wires and ribbon cables to automatic-feed connectors. For series manufacture.

3.3 Fully automatic machines

3.3.1 Fully automatic termination machine type Varicon 6000

For termination of connections with multiple cable pulling and automatic magazine bar feed. After termination an electric continuity check and a short circuit test will be carried out. According to the test result the connectors will be selected. For large-scale industrial series production.

4 Cable specification

The cable specifications must be kept. Any deviation must be discussed and approved by LUMBERG.

4.1 Cable specifications cross section for connection 0,5...0,75 mm²

Technical specification sheet 908 03 stranded wire = 0,50 mm²

Technical specification sheet 908 15 PVC – stranded wire = 0,50 mm²

Technical specification sheet 908 06 stranded wire = 0,75 mm²

Technical specification sheet 908 13 PVC – stranded wire = 0,75 mm²

4.2 Cable specifications cross section for connection 1,0mm²

Technical specification sheet has to be defined.

Other cables see LUMBERG release list.

5 Assembly

5.1 Connector feed

Depending on the kind of delivery the connector feed is as follows

- bar stock carrier of transparent PVC

5.2 Cutting clearance

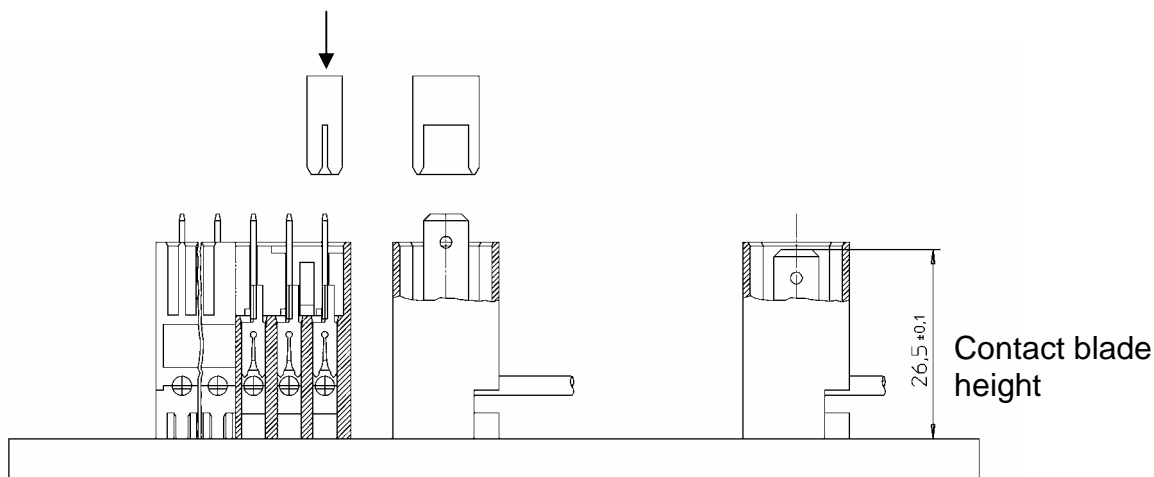
Wire cross section for connection (conductor) and insulation displacement area (ID slots) have to correspond. Only released cables are to be used for the ID slots.

5.3 Termination head

In order to guarantee a correct positioning of the contacts and not to damage the bodies during the termination of the contacts, termination head, contact and connector have to correspond. The termination heads are part of the application machines.

5.4 Shut height dimension of the termination head and contact blade height

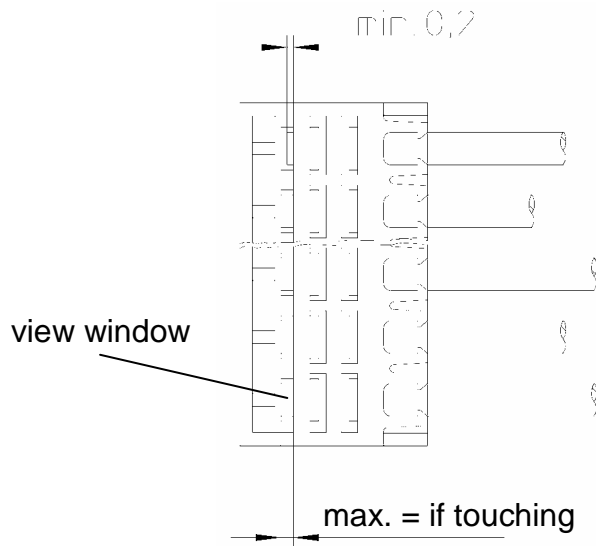
An important feature for the correct function of the connector is the contact blade height after termination. It is determined by the shut height dimension of the termination machine. Depending on the used tab header and cable an adjustment of the shut height dimension could be required in order to keep the contact blade height.



Tab header 3647, 3647-1
Tab header 3648, 3648-2

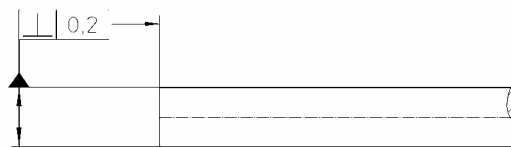
5.5 Cable protrusion

There must be the correct cable protrusion to guarantee good wire termination in the ID slots. After termination the cable protrusion must be visually checked.

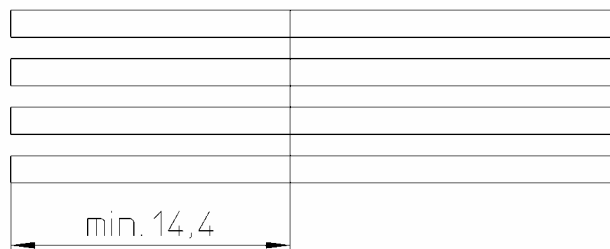


5.6 Cable

No cuts in the insulation are allowed in wire exit direction (visual check). The cables must be cut off without burr and deformity.

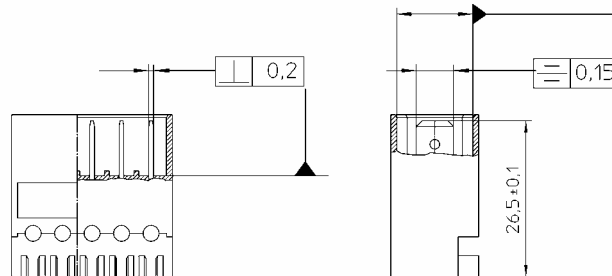


Flat cables must be punched out.



5.7 Housing

After termination no visual damages of the housing are allowed (visual check).
The mating function must be guaranteed (functional test).
The contact must be in correct position in the housing (visual check).
The pressing height of the contact blade must be kept (dimensional inspection).



6 Quality assurance

For all working and processing steps and alterations (e. g. product launch, changes of the cable, changes of the tool or machine ...), which may affect the product quality, the responsible departments have to take care for appropriate quality assurance steps.

6.1 Quality features

The following quality features must be taken into consideration.

6.2 Quality features / IDC

- ID slot width
- Symmetry of the ID slot
- Cable quality
- Cable insertion depth
- Cable protrusion

6.2.1 ID slot width

LUMBERG guarantees correct ID slot.

6.2.2 Symmetry of the ID slot

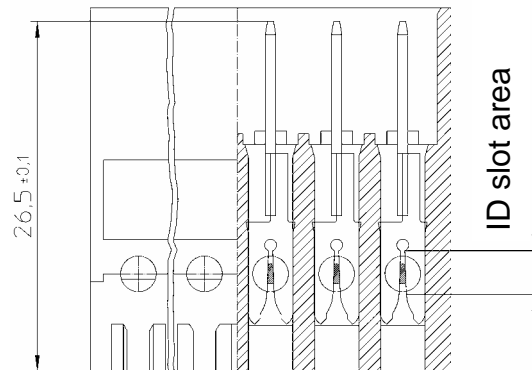
Symmetry of the ID slot (cable tolerance $\pm 0,1$) is guaranteed by the body.

6.2.3 Cable quality

The cable must meet LUMBERG specification acc. to point 4.1.
Customized cables, which are listed in the release lists, have to correspond with the available specification sheets.

6.2.4 Contact insertion depth

The contact insertion depth must be kept, it determines the position of the conductor in the ID slot area. All single wires must be in the ID slot area.



6.2.5 Cable protrusion

The cable protrusion acc. to point 6.5 must be kept. A protrusion of the cable in the housing leads to an incorrect mating.

6.3 Retention force of the wire

The retention force of the wire in the ID slot must be as follows:

PVC – stranded wire:	0,50 mm ² > 100N
PVC – stranded wire:	0,75 mm ² > 100N
Silicon – stranded wire:	1,00 mm ² >N (to be defined)

