

**PARAMETER OF CRIMP STUDY MDMA CONTACTS AWG 24  
- TEST RESULTS -****Object:**

- Validation crimp of contact SKT MDMA AWG 24
  - AWG 24 locator MDMA-S selector pince M22520/2-01 Position 2
  - AWG 24 locator MDMA-S selector pince M22520/2-01 Position 3
  - AWG 24 locator MDMA-S selector pince M22520/2-01 Position 4
- Designation: C252-8844-000

**Description of tests:**

- Joint Strength
- Cross Section

**Applicable documents :**

- Generic specification : ESCC 3401 - Issue 1 - October 2002
- Detail specification : ESCC 3401/078 - Issue 3 - February 2010
- ECSS Q-ST-70-26 RevC

**Conclusion :**

Joint strength values with the 3 positions of selector tested are very similar.  
Separation mode is the same with the 3 positions.  
Best aspect of the crimping area is obtain with position 3 on the selector.

**Laboratory Technician**  
**E. HAUSWIRTH**

**Chief inspector**  
**O. MASSON**

TEST : JOINT STRENGTH

Report N° 639-12C

Test Group :

Spécifications : ESCC 3401 Generic Specification § 9.15.3

Requirements : ESCC 3401/077 tab 6- ESCC 3401/078 tab 6 Appendix "A"

Test environment or special conditions :

Test equipment :

TEST PROCEDURE :

Crimp contacts :

The crimped contact-wire assemblies shall be placed in a tensile testing device and an axial load shall be applied.  
The connection shall be loaded until failure occurs.  
The value at failure shall be recorded , together with the information as to whether the failure was 'pull-out', 'broke in crimp' or break in wire.

TEST REQUIREMENTS :

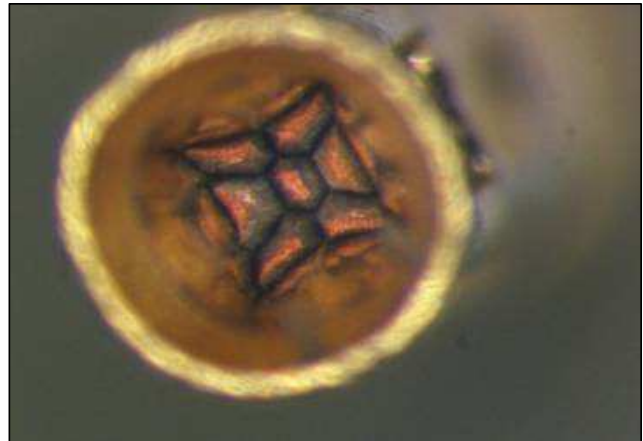
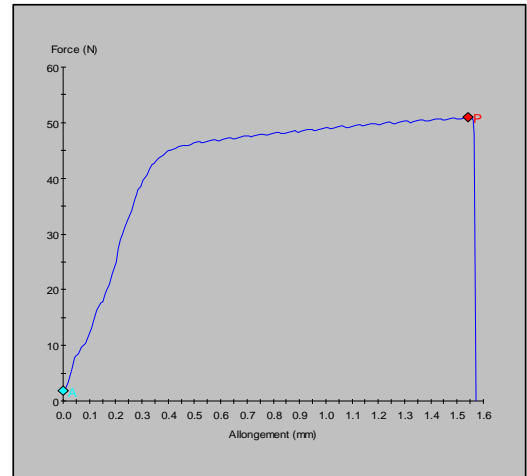
Crimp contacts :

wire size	axial strength (N) minimum value
AWG 24	30

TEST SAMPLES : ref. Contact SKT AWG 24 Crimped with locator MDMA-S /Tool M22520/2-01 position 2

ct type	wiring	ct N°	Axial Strength (N)	separation mode *	result	
					pass	fail
Skt cts	AWG 24	1	51,00	b	√	
		2	49,50	b	√	
		3	48,80	b	√	
		4	50,60	b	√	
		5	51,10	b	√	
		6	50,30	b	√	
		7	49,80	b	√	
		8	49,80	b	√	
		9	49,30	b	√	
		10	49,00	b	√	
		11	49,10	b	√	
		12	49,90	b	√	
		13	49,70	b	√	
		14	49,90	b	√	
Mini			48,80			
Maxi			51,10			
Average			49,84			

- a : pull-out
- b : broke in crimp
- c : broke in wire



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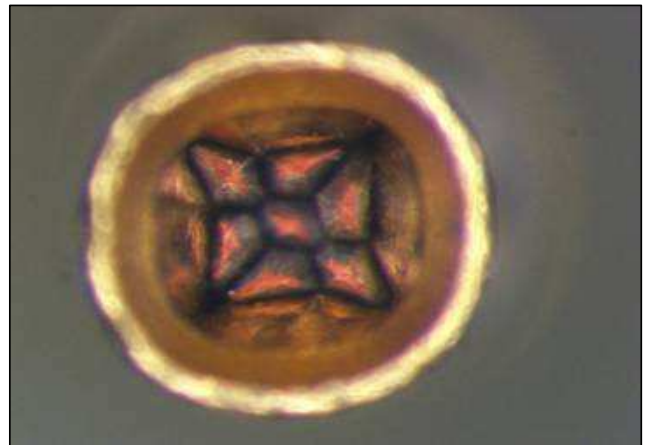
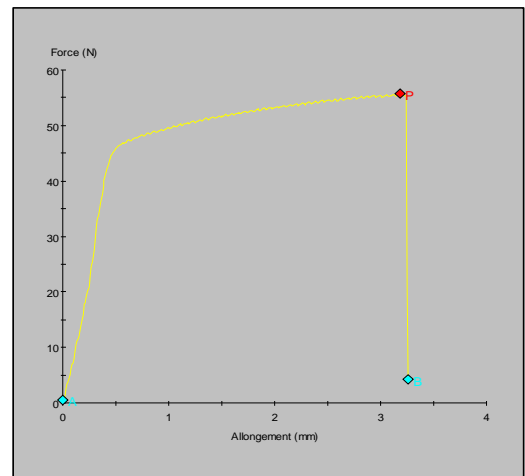
Crimp contacts :

wire size	axial strength (N) minimum value
AWG 24	30

TEST SAMPLES : ref. Contact SKT AWG 24 Crimped with locator MDMA-S /Tool M22520/2-01 position 3

ct type	wiring	ct N°	Axial Strength (N)	separation mode *	result	
					pass	fail
Skt cts	AWG 24	1	54,00	b	√	
		2	53,80	b	√	
		3	54,80	b	√	
		4	54,60	b	√	
		5	54,20	b	√	
		6	53,30	b	√	
		7	54,50	b	√	
		8	55,70	b	√	
		9	54,40	b	√	
		10	54,90	b	√	
		11	54,40	b	√	
		12	54,00	b	√	
		13	53,40	b	√	
		14	53,30	b	√	
Mini			53,30			
Maxi			55,70			
Average			54,24			

- a : pull-out
- b : broke in crimp
- c : broke in wire



TEST : JOINT STRENGTH

Report N° 639-12C

Test Group :

Spécifications : ESCC 3401 Generic Specification § 9.15.3

Requirements : ESCC 3401/077 tab 6- ESCC 3401/078 tab 6 Appendix "A"

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TEST REQUIREMENTS :

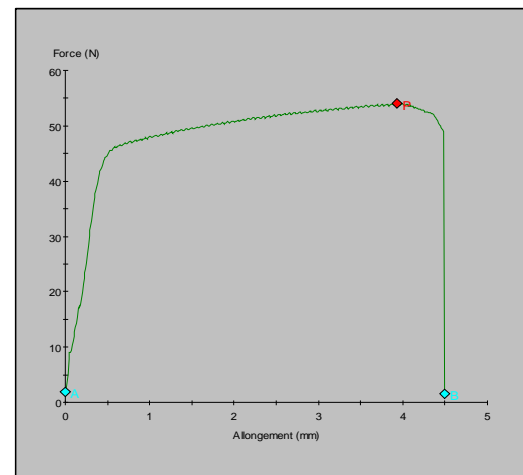
Crimp contacts :

wire size	axial strength (N) minimum value
AWG 24	30

TEST SAMPLES : ref. Contact SKT AWG 24 Crimped with locator MDMA-S /Tool M22520/2-01 position 4

ct type	wiring	ct N°	Axial Strength (N)	separation mode *	result	
					pass	fail
Skt cts	AWG 24	1	53,70	b	√	
		2	53,80	b	√	
		3	53,00	b	√	
		4	54,20	b	√	
		5	53,60	b	√	
		6	53,50	b	√	
		7	53,60	b	√	
		8	53,80	b	√	
		9	53,60	b	√	
		10	54,10	b	√	
		11	54,00	b	√	
		12	53,90	b	√	
		13	54,20	b	√	
		14	54,00	b	√	
Mini			53,00			
Maxi			54,20			
Average			53,79			

- a : pull-out
- b : broke in crimp
- c : broke in wire



TEST :

CROSS SECTION

Report N° 639-12C

Test Group :

Spécifications : ESCC 3401 Generic Specification

Requirements : ESCC 3401/078 ECSS Q-ST-70-26 RevC

Test environment or special conditions :

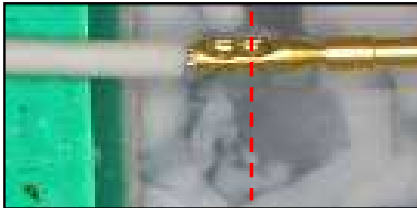
Crimped contacts shall be subjected to cross section

Test equipment :

TEST PROCEDURE :

Cross section

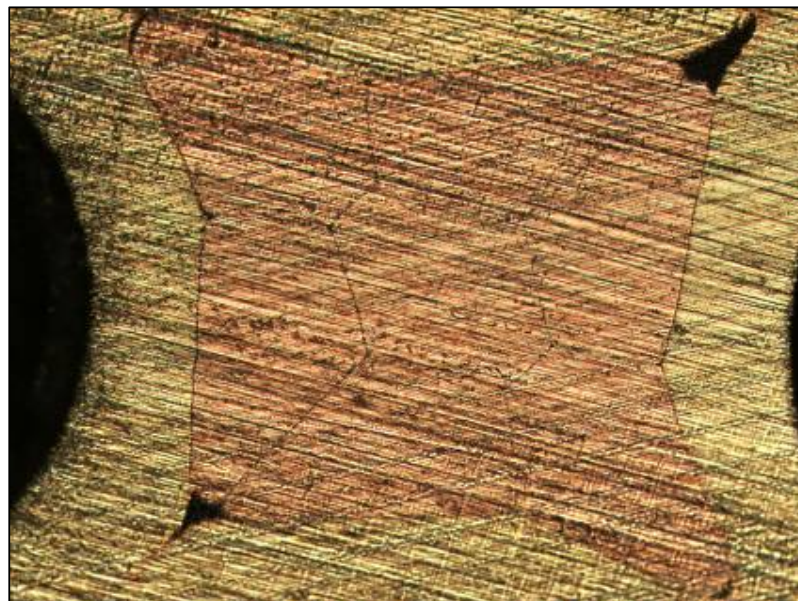
A-A



TEST REQUIREMENTS :

Final measurements :

- visual examination

TEST SAMPLES : ref. [Contact SKT AWG 24 Crimped with locator MDMA-S /Tool M22520/2-01 position 2](#)

TEST :

CROSS SECTION

Report N° 639-12C

Test Group :

Spécifications : ESCC 3401 Generic Specification

Requirements : ESCC 3401/078 ECSS Q-ST-70-26 RevC

Test environment or special conditions :

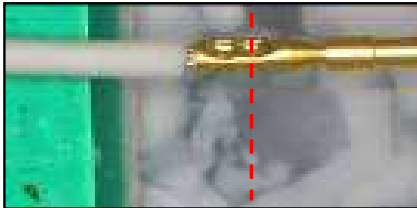
Crimped contacts shall be subjected to cross section

Test equipment :

TEST PROCEDURE :

Cross section

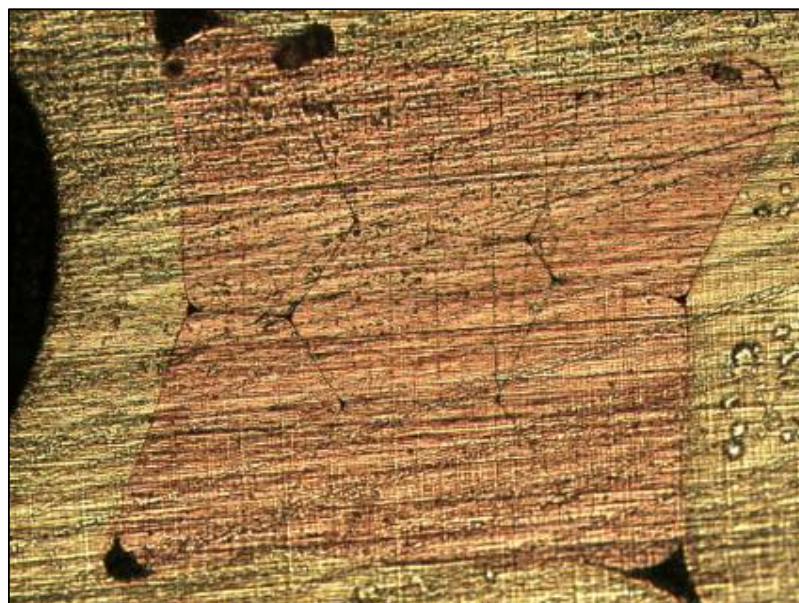
A-A



TEST REQUIREMENTS :

Final measurements :

- visual examination

TEST SAMPLES : ref. [Contact SKT AWG 24 Crimped with locator MDMA-S /Tool M22520/2-01 position 3](#)

TEST :

CROSS SECTION

Report N° 639-12C

Test Group :

Spécifications : ESCC 3401 Generic Specification

Requirements : ESCC 3401/078 ECSS Q-ST-70-26 RevC

Test environment or special conditions :

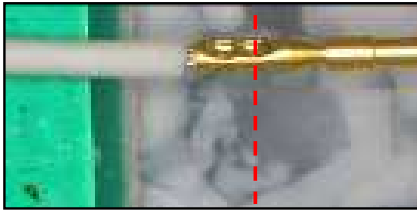
Crimped contacts shall be subjected to cross section

Test equipment :

TEST PROCEDURE :

Cross section

A-A



TEST REQUIREMENTS :

Final measurements :

- visual examination

TEST SAMPLES : ref. [Contact SKT AWG 24 Crimped with locator MDMA-S /Tool M22520/2-01 position 4](#)