

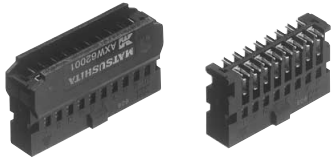
NAIS

FOR PC BOARD TO WIRE

WIRE-PRESS SOCKETS (AXW)



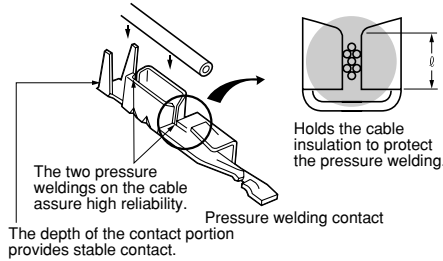
With hood cover



With semi-cover

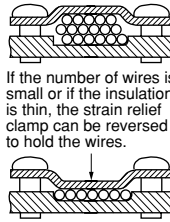
Socket

2. Two pressure weldings assure high contact reliability.

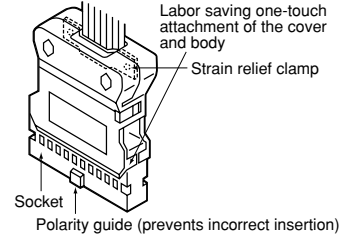


3. Labor saving one-touch attachment of the cover and socket body.

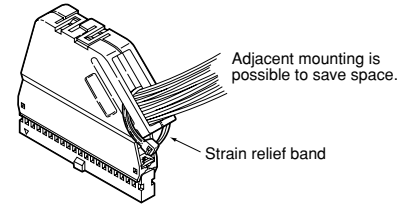
4. Even if the number of wires is small, the stable pressure welding is acquired.



5. Angled hood cover type can save space and makes adjacent mounting possible.



Vertical hood cover type



Angled hood cover type

6. Fits MIL headers and low profile headers (box and open types).

7. Useful pressure welding tools are available.

APPLICATIONS

NC machine, automated equipment, office automation equipment, ME equipment, measurement equipment, communications equipment, amusement and game equipment.

FEATURES

1. Pressure welding method for superior wiring and no need to strip wires.

Applicable wires: AWG #22, #24, #26, #28.

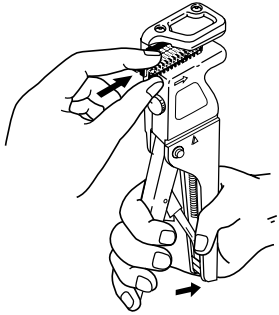
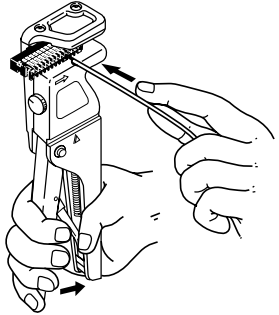

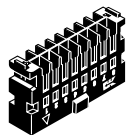
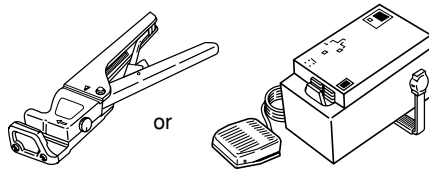

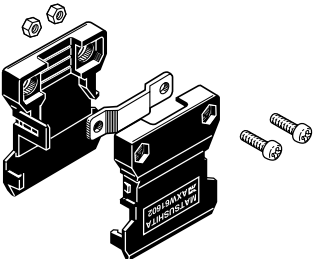
WIRING AND ASSEMBLY

1. When using small amounts (about 150 pins can be pressure welding per hour)

Process	<p>1. Bend the contact back from the carrier, and set it in the pressure welding tool.</p>	<p>2. Insert the wire without removing its insulation until it stops, and lightly grip the tool.</p>	<p>3. After press-fitting the wire, insert it into housing.</p>	<p>4. Attach the cover to complete the operation. (Note)</p>
Necessary parts	<p>Stapler type AXY52000</p> <p>Contacts (5 in line)</p>	<p>Separate wires</p>	<p>Housing without contacts</p>	<p>Vertical type hood cover block</p>

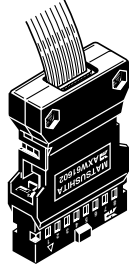
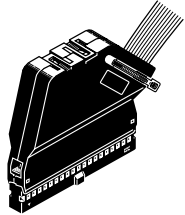
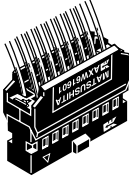


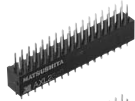

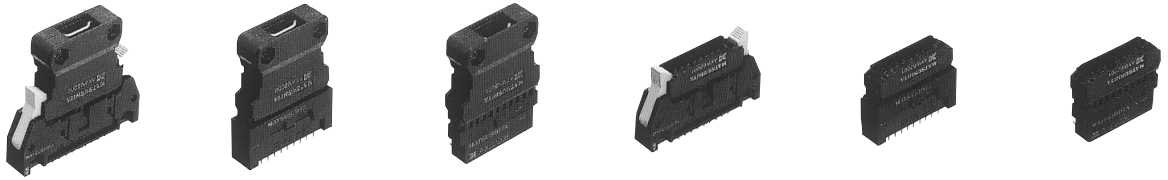
Note) There are 3 types of cover: semi-covers, vertical type hood cover blocks, and angle type hood cover blocks.

2. When using medium to large amounts (when using pliers-type pressure welding tool, about 450 pins per hour; when using desktop pressure welding tool, about 850 pins per hour)

<p style="writing-mode: vertical-rl; transform: rotate(180deg);">Process</p>	<p>1. Set the housing with contact in the pressure welding tool.</p> 	<p>2. Insert the wires with insulation attached, until they touch the back, then use the tool's pressure welding operation.</p> 	<p>4. Attach the cover to complete the operation. (Note)</p> 
<p style="writing-mode: vertical-rl; transform: rotate(180deg);">Necessary parts</p>	<p>Housing with contacts</p>  <p>or</p>  <p>Pliers-type AXY51000 Desk-top type AXY53000</p>	 <p>Separate wires</p>	 <p>Vertical type hood cover block</p>

Note) There are 3 types of cover: semi-covers, vertical type hood cover blocks, and angle type hood cover blocks.

APPLICABLE HEADERS AND COMBINATIONS

<p>Pressure socket for separate wires</p>	 <p>Vertical type hood cover block</p>	 <p>Angled type hood cover block</p>	 <p>Semi-cover Note) With cover installed on socket</p>
<p>Applicable headers</p>	 <p>Long lever type MIL header</p>	 <p>Box type low profile header</p>	 <p>7.4mm high type</p>  <p>2.54mm high type</p> <p>Open type low profile header</p>
<p>Combinations</p>	 <p>Note) Loose wires omitted from photos</p>		

PRODUCT TYPES

1. Individual parts (Standard)

Type	No. of contacts	Part No.		Packing			
		Applicable cable		Inner carton	Outer carton		
		AWG #22, 24	AWG #26, 28				
Housing	Housing with contacts Note) Suitable for use of pliers type or desktop type pressure welding tool.	10	AXW110421A	AXW110431A	100 pcs.	400 pcs.	
		14	AXW114421A	AXW114431A			
		16	AXW116421A	AXW116431A			
		20	AXW120421A	AXW120431A			
		26	AXW126421A	AXW126431A			
		30	AXW130421A	AXW130431A			
		34	AXW134421A	AXW134431A			
		40	AXW140421A	AXW140431A			
		50	AXW150421A	AXW150431A			
	60	AXW160421A	AXW160431A				
	64	AXW164421A	AXW164431A				
	Housing without contacts Note) Suitable for use of stapler-type pressure welding tool.	10	AXW1104A		100 pcs.	400 pcs.	
		14	AXW1144A				
		16	AXW1164A				
		20	AXW1204A				
		26	AXW1264A				
		30	AXW1304A				
		34	AXW1344A				
40		AXW1404A					
50		AXW1504A					
60	AXW1604A						
64	AXW1644A						
Cover	Hood cover block	Vertical type	16	AXW61602A		100 pcs.	400 pcs.
			20	AXW62002A			
			26	AXW62602A			
			30	AXW63002A		50 pcs.	200 pcs.
			34	AXW63402A			
			40	AXW64002A			
			50	AXW65002A			
			60	AXW66002A			
			64	AXW66402A			
	Angled type	26	AXW62603A		50 pcs.	200 pcs.	
		30	AXW63003A				
		34	AXW63403A				
		40	AXW64003A				
		50	AXW65003A				
		60	AXW66003A				
	Semi-cover	10	AXW61001A		100 pcs.	400 pcs.	
		14	AXW61401A				
		16	AXW61601A				
20		AXW62001A					
26		AXW62601A					
30		AXW63001A					
34		AXW63401A					
40		AXW64001A					
50		AXW65001A					
60	AXW66001A						
64	AXW66401A						
Contacts (5 in line) (Notes 6 and 7)		5	AXW7221 (for AWG #22, 24)	AXW7231 (for AWG #26, 28)	40 rows (200pcs.)	400 rows (2,000 pcs.)	

Notes) 1. The parts above are packaged individually.

2. The vertical type hood cover block is packaged with two covers (one with nuts), one wire bunding metal.

3. The angled type hood cover block is packaged with two covers and one wire bunding band.

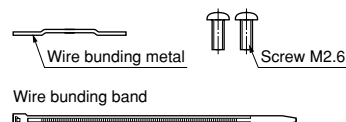
4. The angled type hood cover for less than 20 contacts and the vertical type hood cover for less than 14 contacts are not available. Please use the semi-cover.

5. There is a mark "22" on contacts for AWG #22 and #24, and mark "26" for AWG #26 and #28.

6. Remarks for contacts

1) Reel packaging is available.

2) 10 contacts type does not have a polarity guide.



2. Set products (produced after order)

Set products are produced after an order is received, so if you have a tight deadline, please order the products on the above as stand-alone products.

Type	Set product		No. of contacts	Part No.		Packing					
	Socket	Cover		Applicable cable		Inner carton	Outer carton				
				AWG #22, 24	AWG #26, 28						
Full set (Note 1)	Housing with contacts	Vertical type hood cover block	16	AXW3162421A	AXW3162431A	50 pcs.	200 pcs.				
			20	AXW3202421A	AXW3202431A						
			26	AXW3262421A	AXW3262431A						
			30	AXW3302421A	AXW3302431A						
			34	AXW3342421A	AXW3342431A						
			40	AXW3402421A	AXW3402431A						
			50	AXW3502421A	AXW3502431A						
			60	AXW3602421A	AXW3602431A						
			64	AXW3642421A	AXW3642431A						
		26	AXW3263421A	AXW3263431A							
		30	AXW3303421A	AXW3303431A							
		34	AXW3343421A	AXW3343431A							
		40	AXW3403421A	AXW3403431A							
		50	AXW3503421A	AXW3503431A							
		60	AXW3603421A	AXW3603431A							
		64	AXW3643421A	AXW3643431A							
		10	AXW3101421A	AXW3101431A							
		14	AXW3141421A	AXW3141431A							
		16	AXW3161421A	AXW3161431A							
		20	AXW3201421A	AXW3201431A							
		26	AXW3261421A	AXW3261431A							
		30	AXW3301421A	AXW3301431A							
		34	AXW3341421A	AXW3341431A							
		40	AXW3401421A	AXW3401431A							
		50	AXW3501421A	AXW3501431A							
		60	AXW3601421A	AXW3601431A							
		64	AXW3641421A	AXW3641431A							
		Half-set (Note 2)	Housing without contacts	Vertical type hood cover block	16			AXW31624A		50 pcs.	200 pcs.
					20			AXW32024A			
					26			AXW32624A			
30	AXW33024A										
34	AXW33424A										
40	AXW34024A										
50	AXW35024A										
60	AXW36024A										
64	AXW36424A										
26	AXW32634A										
30	AXW33034A										
34	AXW33434A										
40	AXW34034A										
50	AXW35034A										
60	AXW36034A										
64	AXW36434A										
10	AXW31014A										
14	AXW31414A										
16	AXW31614A										
20	AXW32014A										
26	AXW32614A										
30	AXW33014A										
34	AXW33414A										
40	AXW34014A										
50	AXW35014A										
60	AXW36014A										
64	AXW36414A										

Notes) 1. Full-set products (Housing with contact and cover included)

(1) Suitable for use with pliers type or desktop type pressure welding tool.

(2) Produced after an order is received. If you are in a hurry, please order a housing with contact and cover separately from the list above.

2. Half-set products (Housing without contact and cover included)

(1) Suitable for use with stapler-type pressure welding tool

(2) As half-sets do not include a contact, order the appropriate stand-alone contact from the list above.

(3) Produced after an order is received. If you are in a hurry, please order a housing without contact, contacts and cover separately from the list on page 156.

SPECIFICATIONS

1. Characteristics

Item		Specifications	Conditions
Electrical characteristics	Rated current	AWG#22, 24: 3A, AWG#26: 2A, AWG#28: 1A	
	Rated voltage	250V AC	
	Breakdown voltage	1,000V AC for 1 min.	Detection current: 1mA
	Insulation resistance	Min. 1,000MΩ	Using 500V DC megger
	Contact resistance	Max. 20mΩ	Measured based on the HP4338B measurement method of JIS C 5402
Mechanical characteristics	Unit removal force	Min. 0.343N {35gf}	Measured by steel-pin-gauge with 0.64±0.01mm square (surface roughness 0.1μm)
	Composite insertion force	Max. 2.94N {300gf} × No. of contacts	
Life time characteristics	Insertion and removal life	500 times	Repeat insertion and removal speed of max. 600 times/hour
Environmental characteristics	Ambient temperature	-50°C to 105°C	No freezing at low temperatures Ambient temperature of cables should be considered
	Vibration resistance	Double amplitude: 1.52mm Frequency: 10 to 55Hz (for 3 axes)	No interruption of current longer than 1μs (Max. carrying current 100mA should be impressed during the test)
	Shock resistance	490m/s ² {50G} (for 3 axes)	No interruption of current longer than 1μs (Max. carrying current 100mA should be impressed during the test)

2. Materials and surface treatment

Part name		Materials	Surface treatment
Housing		Glass fiber reinforced PBT (UL94V-0)	—
Cover	Semi-cover	Glass fiber reinforced PBT (UL94V-0)	—
	Hood cover	Glass fiber polycarbonate resin (UL94V-0)	—
Contact		Copper alloy	Contact portion: Au plating over Ni Contact pressure portion: Sn plating over Ni
Lead wire bundling metal (enclosed with vertical type hood cover)		Steel plate	—
Lead wire bundling band (enclosed with angled type hood cover)		Polyimide resin	—

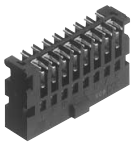
3. Applicable cable

No.	Cross section area	External figure	Rated current	Remarks
AWG#22	0.3 mm ²	1.1 to 1.5 dia.	3A	12 wires/0.18 should used
AWG#24	0.2 mm ²		3A	
AWG#26	0.14mm ²	1.1 to 1.3 dia.	2A	
AWG#28	0.08mm ²		1A	

DIMENSIONS

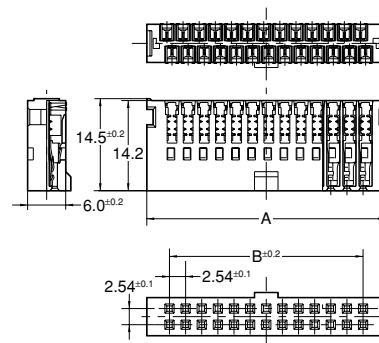
mm General tolerance: ±0.3

• Housing with contacts



Dimension table (mm)

No. of contacts	Polarity guide	A	B
10	0	17.3	10.16
14	1	22.4	15.24
16	1	24.9	17.78
20	1	30.0	22.86
26	1	37.6	30.48
30	1	42.7	35.56
34	1	47.8	40.64
40	1	55.4	48.26
50	1	68.1	60.96
60	1	80.8	73.66
64	1	85.9	78.74



Note) Dimensions of the housing without contact is the same as the right figure.

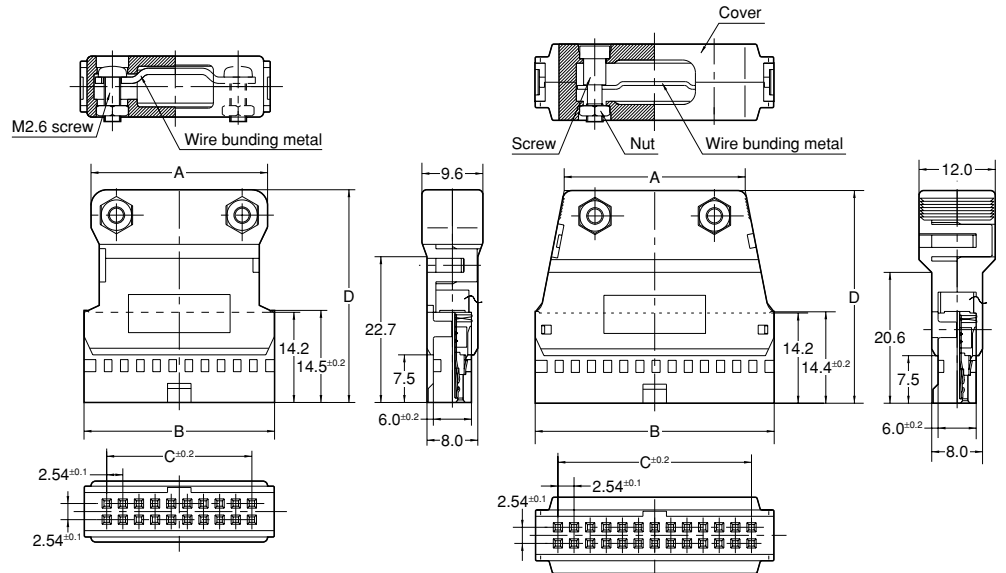
• Socket

1) When vertical type hood covers are mated (16, 20, 26, 30, 34, 40, 50, 60 and 64 contacts)



16 and 20 contacts

26 to 64 contacts



Dimension table (mm)

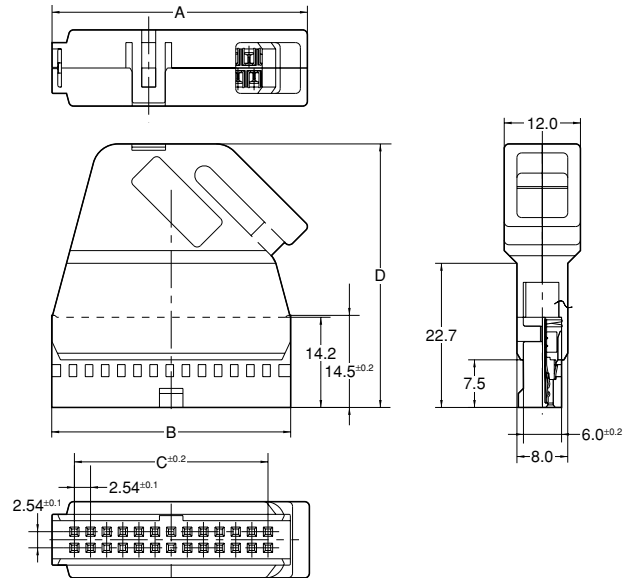
No. of contacts	A	B	C	D
16	24.0	24.92	17.78	33.5
20	27.8	30.0	22.86	33.5
26	28.5	37.6	30.48	33.5
30	33.5	42.7	35.56	33.5
34	38.6	47.8	40.64	33.5
40	43.6	55.4	48.26	41.5
50	56.0	68.1	60.96	41.5
60	68.7	80.8	73.66	41.5
64	73.8	85.9	78.74	41.5

2) When angle type hood covers are mated (26, 30, 34, 40, 50, 60 and 64 contacts)



Dimension table (mm)

No. of contacts	A	B	C	D
26	40.5	37.6	30.48	41.5
30	45.6	42.7	35.56	41.5
34	50.7	47.82	40.64	41.5
40	62.5	55.4	48.26	52.5
50	75.2	68.1	60.96	52.5
60	87.9	80.8	73.66	52.5
64	93.0	85.9	78.74	52.5

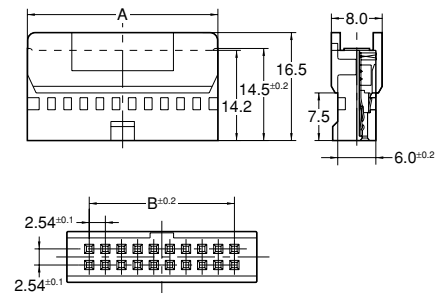


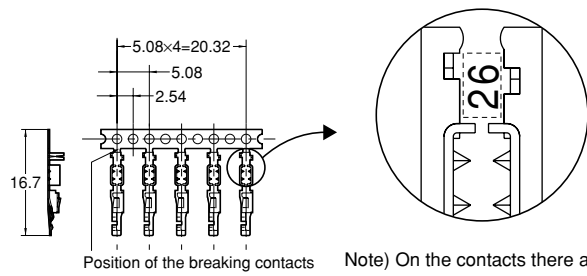
3) When semi-covers are mated



Dimension table (mm)

No. of contacts	A	B
10	17.3	10.16
14	22.38	15.24
16	24.92	17.78
20	30.0	22.86
26	37.62	30.48
30	42.7	35.56
34	47.78	40.64
40	55.4	48.26
50	68.1	60.96
60	80.8	73.66
64	85.88	76.74





Position of the breaking contacts

Note) On the contacts there are stamps "22" for AWG #22 and #24 types, and "26" for AWG #26 and #28 types.

NOTES

1. Use wires and contact types that match.

The contact's clamp is stamped with 22 or 26.

Use AWG#22 or #24 wire with the type 22 contact and AWG #26 or #28 wire with the type 26 contact.

An incorrect combination will cause faulty connections.

2. Use wires having a correct outer insulation diameter.

The use of a wire with an outer insulation diameter larger than the allowable value or a wire with a hard material for the insulation will cause faulty connections. Furthermore, the use of a wire with an outer insulation diameter less than the allowable value will cause a drop in the clamp strength. Use wires with a suitable outer diameter and insulation material. Suitable wire diameters are shown in the table below.

Suitable wire diameters

Size	Insulation outer diameter	Remark
AWG#22	1.5 dia. to 1.1 dia.	AWG #22 is Stranded wire of 12 stands/0.18
AWG#24		Stranded wire
AWG#26	1.3 dia. to 1.1 dia.	Stranded wire
AWG#28		

* AWG#22 and #24 use different contacts from AWG#26 and #28. Refer to the part number chart for the part number.

3. Inserted wire length during wire pressure welding

Insert the wire to a proper length and perform the pressure welding.

If the inserted length is too short, the wire will be pressure welded only at one location.

If the inserted length is too long, the wire will end up on the lance portion and a proper pressure welding will not be obtained.

4. Cut the end of the wire so that it is straight and flat. Be sure no uneven strands remain.

5. When pressure welding a wire, fully insert it to the proper position. Be sure to squeeze the lever unit it reaches the end position of the stroke.

6. After connecting the wire, check that the wire clamp firmly clamps the wire.

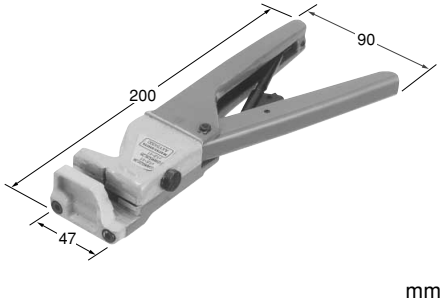
7. The contact holder should be replaced as needed.

PRESSURE WELDING TOOLS FOR SEPARATE WIRES

PRODUCT TYPES

Product name		Part No.	Packaging	
			Inner carton	Outer carton
Pressure welding tool	Pliers type pressure welding tool for separate wires (with feed mechanism)	AXY51000	—	1 pc.
	Stapler type pressure welding tool for separate wires	AXY52000	—	
	Desk-top type pressure welding tool for separate wires	AXY53000	—	
Accessory	Contact holder	AXY5801	—	200 pcs.

• Pliers-type (with feed mechanism)



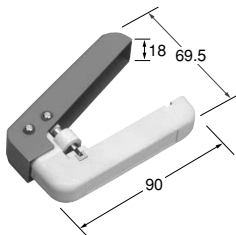
Pliers-type pressure welding tool for separate wires (with feed mechanism)
AXY51000

FEATURES

- 1. Weight balanced design for lightweight handling.**
- 2. Lever Lock Mechanism Allows Reliable Pressure Welding**
The lever lock mechanism prevents the lever from returning until the predetermined stroke is reached. This allows for reliable pressure welding, preventing variation due to differences between individual workers.
- 3. Automatic feed mechanism indicates the pressure welding terminal number after a pressure welding.**
After each pressure welding, the automatic feed is performed one pitch at a time (2.54mm). At the same time, the number of the connector terminal being pressure-welded is indicated. If the terminal number is set initially, the connector can be moved to any position with the correct terminal number always displayed since the tool is directly linked with the connector.

- 4. Stroke adjustment feature.**
The pressure welding stroke can be adjusted to match the diameter of the cable wire for reliable connections.
- 5. Enables pressure welding of both the socket with contacts and individual contacts.**
A cable can be connected with the contacts positioned in the socket housing (socket housing with contacts) or with the individual contacts separated from the socket housing.
- 6. Contact puller feature.**
The contact puller permits incorrectly connected or unnecessary contacts to be pulled out.

• Stapler type



Stapler type pressure welding tool for separate wires
AXY52000

FEATURES

1. Compact and lightweight, it fits in a pocket.
2. Pressure-weld individual contacts.
3. Convenient for on-site maintenance work since connection is possible in small spaces.
4. Includes a contact puller.

AXW

- Desk-top pressure welding tool for separate wires



AXY53000

FEATURES

1. Semi-automatic desk-top pressure welding tool for medium-scale harnessing

Capable of 0.7 second/cycle for efficient harnessing from small-scale to medium-scale processing.

2. Highly reliable pressure welding and one pitch socket advance are performed simply by positioning the wire and pressing the switch.

3. Convenient functions

- Terminal no. display of the pressure welding contact
- Stroke selection
- Empty advance

4. Operating by foot switch is possible

Use of the foot switch frees both hands for complex harnessing processes.

APPLICATIONS

Separate wire pressure connection sockets

For users

For harnessing manufacturers

MAJOR FUNCTIONS

1. Terminal no. display of the pressure welding contact

When the counter reset button is pressed after the connector is placed in the tool, the counter displays "1". The counter increments by one each time a pressure welding or empty advance is performed.

2. Stroke selection

The stroke can be selected from two settings so that an optimum pressure welding height is obtained to match the wire size.

Stroke selection knob	Suitable wire size
22	AWG 22 or 24 (Stranded)
26	AWG 26 or 28 (Stranded)

3. Empty advance

Advances the connector by one pitch without performing a pressure connection.

4. Safety detection and wire insulation diameter check holes

To prevent accidents, a sensor is provided at the connector insertion hole so that the pressure connect operation is not performed unless a connector is mounted.

Furthermore, to prevent incorrect connections, holes are provided to allow checking of the wire size.

NOTES

1. Never disassemble the tool. Also, do not subject it to shock or drop it from a high place.
2. After using a desktop type pressure welding tool, turn off the power switch and unplug the tool.