

Crimp Contact for Direct Joining Thick Wire PCB Thick Wire Crimp Contact for Direct Soldering to PCB

MDF12/27 Series



■ Features

1. Allows for direct soldering of wires to the PCB

The MDF12 and MDF27 eliminates the traditional crimp housing/receptacle combination by crimping the contact on to the wire and then directly soldering it to the PCB. This improves assembly times and connection reliability.

- Has temporary PCB hold retention ability which allows for easier soldering and helps to reduce labor costs.
- The contact crimps both around the center conductor and the jacket. The jacket crimp prevents breakage or damage to the center conductor at the solder joint by transferring stress to the jacket portion of the terminated wire.

2. Vertical and right angle versions

The MDF12 contact is designed for when a vertical connection to the PCB is needed. Please use the MDF27 contact for applications that require a right angle orientation.

3. Supports larger gauge wires and higher current ratings

The MDF12 and MDF27 can be used with wire diameters ranging from 22 to 14 AWG and provides for a current capacity of up to 15 A when using 14 AWG. Contacts are suitable for use with readily available UL1007 and UL1015 wire types.

■ Product specifications

Rated value	Rated current (Note 1)	14 AWG : 15A 16 AWG : 10A 18 AWG : 9A 20 AWG : 5A 22 AWG : 5A	Operating temperature range Operating humidity range	-35 to 85 °C (Note 2) 20 to 80 %
	Rated voltage	300V AC	Storage temperature range Storage humidity range	-10 to 60 °C (Note 3) 40 to 70 % (Note 3)

Items	Specifications	Conditions	
1. Crimp Contact resistance	15 mΩ min.	Measured at 100 mA	
2. Vibration resistance	No damaged or loosened parts.	Frequency: 10 to 55 Hz; half amplitude: 0.75 mm, in 3 directions for 2 hours	
3. Moisture resistance	No damaged or loosened parts.	Left for 96 hours at a temperature of 40 °C ±2 °C and with humidity of 90 to 95 %	
4. Temperature cycle	No damaged or loosened parts.	(-55 °C for 30 minutes → 5 to 35 °C for 10 minutes → 85 °C for 30 minutes → 5 to 35 °C for 10 minutes) in 5 cycles for 5 cycles	
5. Solder heat resistance	No loosening affecting the performance.	Flow: 250 °C for 10 seconds	Hand soldering: soldering iron temperature 300 °C for 3 seconds

Note 1: The rated current differs depending on the wire size used.

Note 2: Includes the temperature rise when energized.

Note 3: Storage described here indicates the long-term-storage of unused items before they are mounted on PCB.

Operating humidity range applies to the non-energized state after the items are mounted on PCB.

■ Material

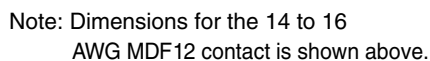
Product	Component	Material	Finish
Crimping contact	Contact	Brass	Tin plating

Note: Our tin plating process helps prevent whiskering.

●Contact

1 2 3 4 5

MDF12 Series

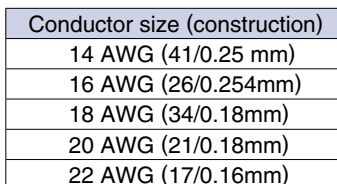


- Recommended through-hole diameter on PCB $1.8^{+0.1}_0$
- Applicable thickness of the PCB 1.6

Part No.	HRS No.	Applicable wire		Type
		AWG	Jacket outer diameter	
MDF27-1822PCF	547-0286-0	18 to 22 AWG	1.5mm to 2.2mm	5,000 pcs/reel
MDF27-1822PC	————		2.1mm to 2.9mm	100 pcs/package
MDF27A-1822PCF	————		2.4mm to 2.7mm	3,500 pcs/reel
MDF27A-1822PC	————		2.6mm to 3.6mm	100 pcs/package
MDF27-1416PCF	————	14 to 16 AWG	2.4mm to 2.7mm	2,500 pcs/reel
MDF27-1416PC	————		2.6mm to 3.6mm	100 pcs/package
MDF27A-1416PCF	547-0296-3		2.4mm to 2.7mm	2,500 pcs/reel
MDF27A-1416PC	————		2.6mm to 3.6mm	100 pcs/package

●Applicable thickness of the PCB is 1.6 mm

● **Wire strip length**
3.3 to 4.2 mm



Note: Please contact our Sales Dept. when using wires other than those noted above.

◆ Applicable crimping tools

Type	Part No.	HRS No.	Applicable contacts
Applicator	AP105-MDF12-1822P	901-4514-0	MDF12-1822PCF
	AP105-MDF12A-1822P	901-4515-2	MDF12A-1822PCF
	AP105-MDF12-1416P	_____	MDF12-1416PCF
	AP105-MDF12A-1416P	901-4533-4	MDF12A-1416PCF
	AP105-MDF27-1822P	_____	MDF27-1822PCF
	AP105-MDF27A-1822P	_____	MDF27A-1822PCF
	AP105-MDF27-1416P	_____	MDF27-1416PCF
	AP105-MDF27A-1416P	_____	MDF27A-1416PCF
Press body	CM-105	901-0005-4	_____
	MDF12-TA1822HC	550-0238-0	MDF12-1822PC
	MDF12A-TA1822HC	550-0239-2	MDF12A-1822PC
	MDF12-TA1416HC	_____	MDF12-1416PC
Manual crimping tools	MDF12A-TA1416HC	550-0237-7	MDF12A-1416PC
	HT104/MDF27-1822P	_____	MDF27-1822PC
	MDF27A-TA1822HC	_____	MDF27A-1822PC
	MDF27-TA1416HC	_____	MDF27-1416PC
	MDF27A-TA1416HC	_____	MDF27A-1416PC

Note 1: Issues caused by use of tools other than the ones designed or recommended by Hirose are not covered by warranty.

Note 2: Please contact our Sales Dept. When you are placing an order for products listed above that show no HRS Part Number.

◆ Usage recommendations

1. Recommended soldering conditions	■Flow conditions using an automatic soldering device: Soldering temperature: 250 ±5℃; soldering time: within 3 seconds ■Hand soldering conditions: Soldering iron temperature: 290 ±10℃; soldering time: within 3 seconds ■After soldering, be sure not to disturb the connectors before they have returned to their normal temperature because the coating presser part is likely to be loosened when a load is applied on the cables while the connectors and the cables are still heated.
2. Cleaning conditions	Please refer to the "Handbook on the Use of Nylon Connectors". Do not use solvents which will impair the cable jacket, such as trichloroethane. Additionally, avoid heating cleaning using solvents. Additionally, avoid using heated cleaning solvents.
3. Wire connecting conditions	Please refer to the "Handbook on the Use of Nylon Connectors".

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