



### All Terminals

- ⚡ Solder fillet min 75% of wire/lead and terminal interface
- ⚡ Solder height greater than 50% wire diameter
- ⚡ Wire/lead discernable in solder joint
- ⚡ Wires are mechanically secure before soldering
- ⚡ Solder wetted min 75% of contact area if wrap 180 deg or more
- ⚡ Solder wetted 100% for wraps less than 180 deg



### Turret

- ⚡ wire wrapped a min 180 deg and not overlap itself
- ⚡ wire end can not overlap itself



### Bifurcated

#### Side Mount

- ⚡ Wire passes through slot and makes positive contact with at least one corner post & no portion of wire above top of terminal

- ⚡ Wire wrap at least 90 deg

#### Bottom and Top Mount

- ⚡ Wire insulation can not enter base
- ⚡ Bottom route contacts 2 parallel sides of post
- ⚡ Wire against base of terminal
- ⚡ Top route has space filled with filler wire



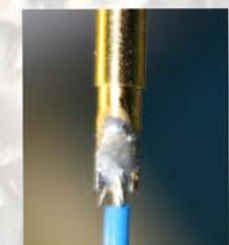
### Hook

- ⚡ Wires wrapped at least 180 deg
- ⚡ No overlap of wire turns
- ⚡ Min 1 wire diameter from end of hook to the closest wire



### Cup

- ⚡ Wire inserted full depth of cup
- ⚡ Wire in contact with back wall
- ⚡ Wire not modified to fit connector
- ⚡ Multiple conductors not twisted together
- ⚡ Thin film of solder on outside of cup
- ⚡ Solder fill 75% or more
- ⚡ Solder buildup on outside cup does not affect form fit or function



### Pierced/perforated/punched

- ⚡ Wire passes through eye
- ⚡ Wire wrapped to contact opposite side

