

Crimp specification

Type Document	Crimp Specification	Revised /Edition	A2
Date Issued:	2020/07/10	Data Revised:	2023/09/06
Subject:9025TR-PSN 2.50mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Description:

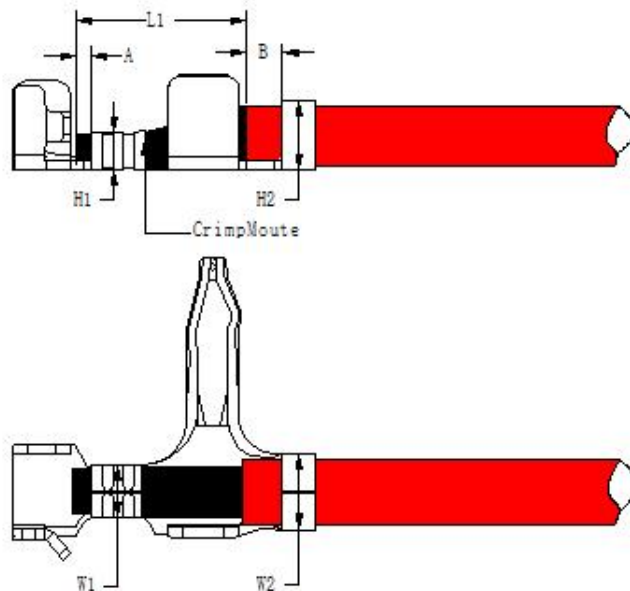
Height and width of conductor crimp core should be set as required.

(conductor crimp height and width of conductor barrel)

According to the external diameter and the type of electric wire, the width of crimped sheath shall be adjusted, wire won't be easily taken off from contact nor too much crimped.

(Crimped width of insulation barrel)

Position Graph



Note:

1. Conductor crimp width. W1
2. Conductor crimp height. H1
3. Insulator crimp width. W2
4. Insulator crimp height. H2
5. Conductor wire shall be dimension long (mm) out A.
6. Naked part of sheathed wire must be located in the vicinity of center B.
7. The Crimp mouth must be equipped like bell.

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Date Issued:	2020/07/10	Data Revised:	2023/09/06
Subject:9025TR-PSN 2.50mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Requirement:

Subject:FLRY-A or equivalent type electric wire

AWG#	Conductor (mm ²)	Insulation Diameter	Insulator skins length (Dim .B) mm	Copper wire leakage size (Dim .A) mm	Dim. L1 (mm) out
#24~#22	0.22mm ² ~0.35mm ²	1.60mm(max)	0.90mm~2.50mm	0.10mm~0.40mm	1.60mm~2.10mm
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
0.22mm ²	1.34±0.03mm	0.77±0.03mm	1.90±0.05mm	1.55±0.05mm	40.0N
0.35mm ²		0.83±0.03mm		1.65±0.05mm	50.0N

Remarks

1. Unlike equipment and crimp reel molds skill facility or not shall be difference to result in dissimilar.
2. This crimping specification is not limited to material changes.

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Dongguan SESO Technology Co.,Ltd

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Date	REV	DESCRIPTION	MODIFY	APPROVAL
2018/05/17	A	Initial Issued	/	Kim Huang
2022/05/19	A1	Modify cable OD	Fx	Kim Huang
2023/09/06	A2	Modifying H1 dimensions	Fx	Jack Zhang

Crimp specification

Type Document	Crimp Specification	Revised /Edition	A
Date Issued:	2020/11/02	Data Revised:	2020/05/19
Subject:9025TV-PSN 2.50mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Description:

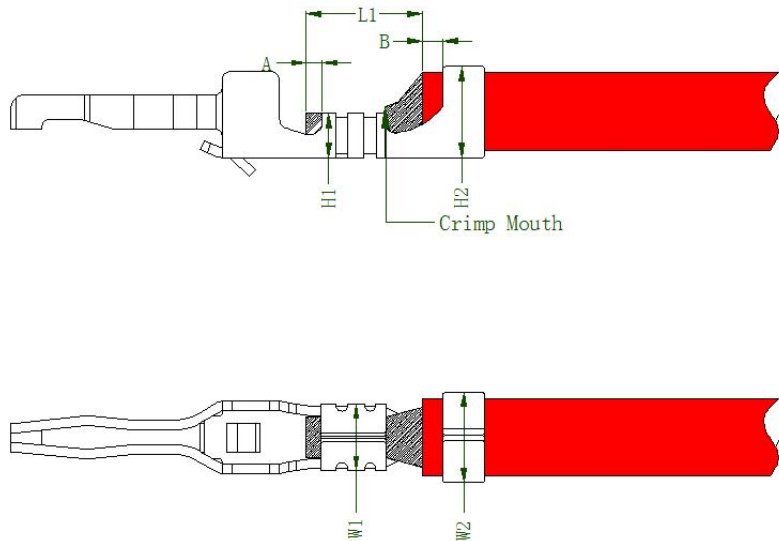
Height and width of conductor crimp core should be set as required.

(conductor crimp height and width of conductor barrel)

According to the external diameter and the type of electric wire, the width of crimped sheath shall be adjusted, wire won't be easily taken off from contact nor too much crimped.

(Crimped width of insulation barrel)

Position Graph:



Note:

1. Conductor crimp width. W1
2. Conductor crimp height. H1
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5. Conductor wire shall be dimension long (mm) out A.
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Requirement:

Subject:FLRY-A or equivalent type electric wire					
AWG#	Conductor (mm ²)		Insulation Diameter	Insulator skins length (Dim .B) mm	Dim. L1 (mm) out
#24~#22	0.22mm ² ~0.35mm ²		1.60mm(max)	0.30mm~0.50mm	1.50mm~1.70mm
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
0.22mm ²	1.30±0.03mm	0.80±0.03mm	1.85±0.05mm	1.40±0.05mm	40.0N
0.35mm ²		0.86±0.03mm		1.55±0.05mm	50.0N

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Crimp specification

Type Document	Crimp Specification	Revised /Edition	A
Date Issued:	2021/07/12	Data Revised:	2021/07/12
Subject:9025TV-PSN-H1 2.50mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Description:

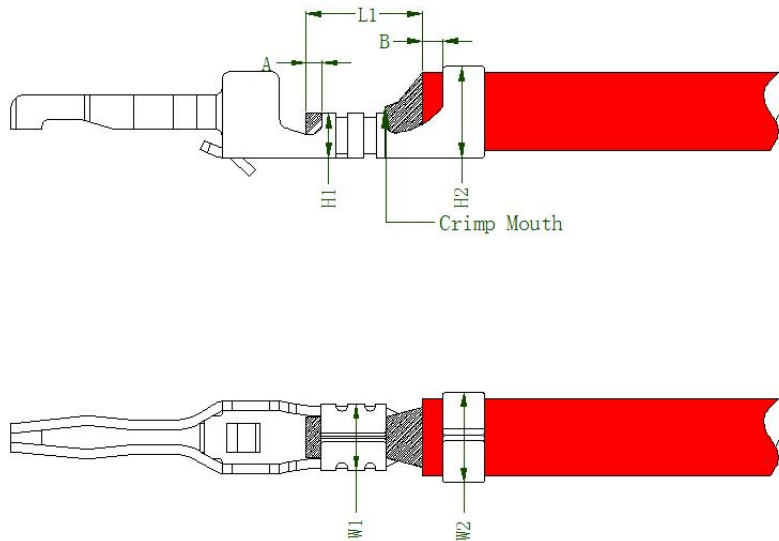
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(conductor crimp height and width of conductor barrel)

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(Crimped width of insulation barrel)

Position Graph:



Note:

1. Conductor crimp width. W1
2. Conductor crimp height. H1
3. Insulator crimp width. W2
4. Insulator crimp height. H2
5. Conductor wire shall be dimension long (mm) out A.
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Subject:9025TV-PSN-H1 2.50mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Requirement:

Subject:FLRY-A or equivalent type electric wire					
AWG#	Conductor (mm ²)		Insulation Diameter		Insulator skins length (Dim .B) mm
#22~#20	0.35mm ² ~0.50mm ²		1.60mm(max)		0.30mm~0.50mm
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
0.35mm ²	1.30±0.03mm	0.89±0.03mm	1.85±0.05mm	1.70±0.05mm	50.0N
0.50mm ²		0.94±0.03mm		1.85±0.05mm	60.0N

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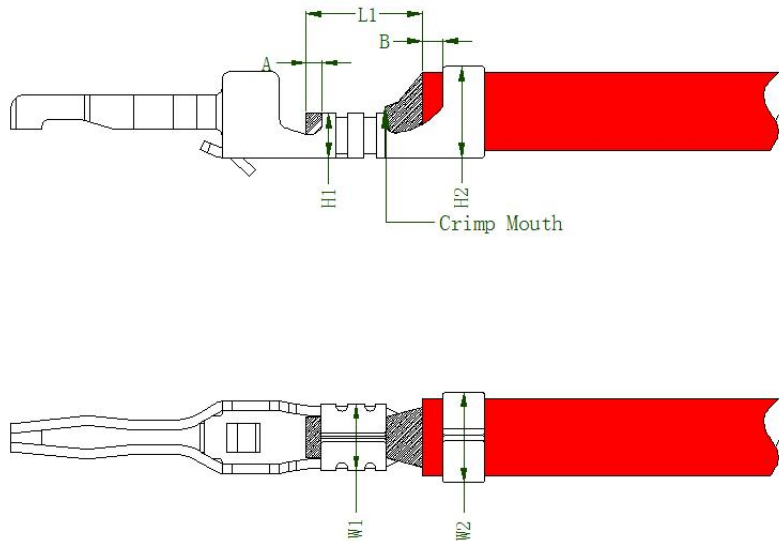
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Subject:9025TV-PSN 2.50mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Requirement:

Subject:UL1061or equivalent type electric wire					
AWG#	Conductor (mm ²)	Insulation Diameter	Insulator skins length (Dim .B) mm	Dim. L1 (mm) out	
#24~#22	0.22mm ² ~0.305mm ²	1.70mm(max)	0.30~0.50mm	1.50~1.70mm	
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
#24	1.30±0.03mm	0.75±0.03mm	1.85±0.05mm	1.55±0.05mm	3.0kgf
#22		0.81±0.03mm		1.65±0.05mm	5.0kgf

Remarks

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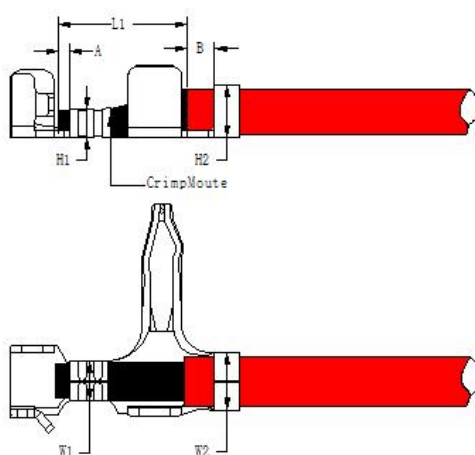
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Subject:UL1061 or equivalent type electric wire					
AWG#	Conductor (mm ²)	Insulation Diameter	Insulator skins length (Dim .B) mm	Copper wire leakage size (Dim .A) mm	Dim. L1 (mm) out
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Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
#24	1.27±0.03mm	0.76±0.03mm	1.85±0.05mm	1.55±0.05mm	3.0kgf
#22		0.80±0.03mm		1.65±0.05mm	5.0kgf

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