

## Crimp specification

Type Document	Crimp Specification	Revised /Edition	A
Date Issued:	2023/07/12	Data Revised:	2023/07/12
Subject: 2803TF 2.80mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

### Description:

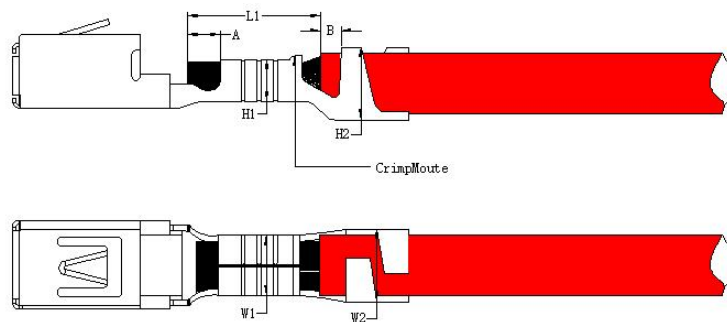
Height and width of conductor crimp core should be set as required.

(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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Requirement:

Subject: FLRY-B or equivalent type electric wire					
AWG#	Conductor (mm <sup>2</sup> )	Insulation Diameter	Insulator skins length (Dim .B) mm	Copper wire leakage size (Dim .A) mm	Dim. L1 (mm) out
#16~#14	1.50mm <sup>2</sup> ~2.50mm <sup>2</sup>	2.40mm~3.00mm	0.50mm~1.40mm	0.30mm~1.00mm	4.50mm~5.00mm
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width(W2)	Height(H2)	
1.50mm <sup>2</sup>	2.75±0.05mm	1.47±0.05mm	3.35±0.05mm	2.80±0.05mm	150.0N
2.00mm <sup>2</sup>		1.64±0.05mm		2.95±0.05mm	180.0N
2.50mm <sup>2</sup>		1.78±0.05mm		3.15±0.05mm	200.0N

## 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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Subject: 2803THF 2.80mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

### Description:

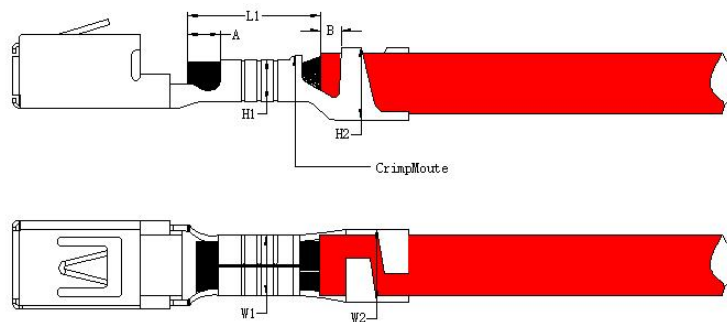
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AWG#	Conductor (mm <sup>2</sup> )	Insulation Diameter	Insulator skins length (Dim .B) mm	Copper wire leakage size (Dim .A) mm	Dim. L1 (mm) out
3.00mm <sup>2</sup> ~4.00mm <sup>2</sup>	3.00mm <sup>2</sup> ~4.00mm <sup>2</sup>	3.20mm~3.70mm	0.50mm~1.70mm	0.3mm~1.00mm	4.90mm~5.40mm
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
3.00mm <sup>2</sup>	3.40±0.05mm	1.88±0.05mm	4.00±0.05mm	3.50±0.05mm	240.0N
4.00mm <sup>2</sup>		2.08±0.05mm	4.30±0.05mm	4.00±0.05mm	310.0N

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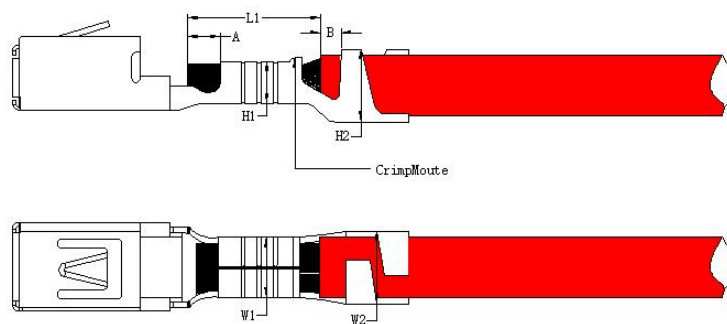
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Subject: FLRY-B or equivalent type electric wire					
AWG#	Conductor (mm <sup>2</sup> )	Insulation Diameter	Insulator skins length (Dim .B) mm	Copper wire leakage size (Dim .A) mm	Dim. L1 (mm) out
#20~#18	0.50mm <sup>2</sup> ~1.00mm <sup>2</sup>	1.60mm~2.10mm	0.50mm~1.40mm	0.3mm~1.00mm	3.80mm~4.30mm
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
0.50mm <sup>2</sup>	1.98±0.03mm	1.17±0.03mm	2.45±0.05mm	2.12±0.05mm	60.0N
0.75mm <sup>2</sup>		1.25±0.03mm		2.35±0.05mm	85.0N
1.00mm <sup>2</sup>		1.40±0.03mm		2.45±0.05mm	108.0N

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