

Crimp specification

Type Document	Crimp Specification	Revised /Edition	A1
Date Issued:	2020/11/09	Data Revised:	2021/07/02
Subject: 1804TF 1.80mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Description:

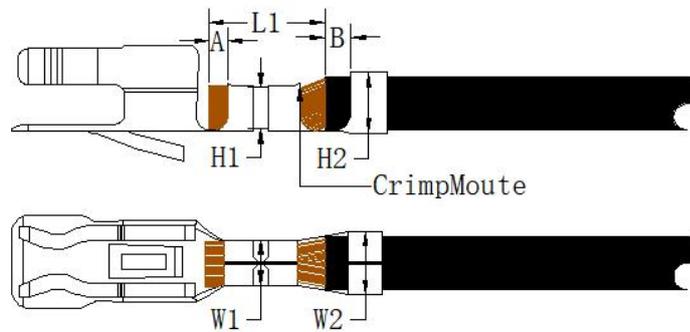
Height and width of conductor crimp core should be set as required.

(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.

Crimp specification

Type Document	Crimp Specification	Revised /Edition	A1
Date Issued:	2020/11/09	Data Revised:	2021/07/02
Subject: 1804TF 1.80mm 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	0.205mm ² ~0.325mm ²	1.10mm~1.30mm	0.30~0.50mm	1.60~1.80mm	
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
#24	1.20±0.03mm	0.77±0.03mm	1.47±0.05mm	1.35±0.05mm	2.30kgf
#22		0.87±0.03mm		1.45±0.05mm	3.60kgf

Remarks

Unlike equipment and crimp reel molds skill facility or not shall be difference to result in dissimilar.

Signature: *JACK* ENG
 SWB CONNECTOR CO.,LTD.

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Type Document	Crimp Specification	Revised /Edition	A
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Description:

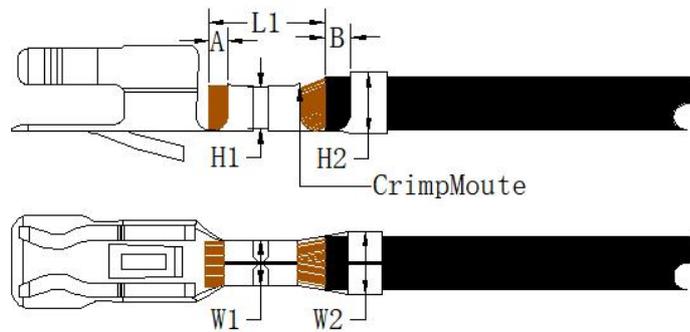
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(Crimped width of insulation barrel)

Position Graph:



Note:

1. Conductor crimp width. W1
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4. Insulator crimp height. H2
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Date Issued:	2020/11/09	Data Revised:	2020/11/09
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Requirement:

Subject:UL1061 or equivalent type electric wire					
AWG#	Conductor (mm ²)	Insulation Diameter	Insulator skins length (Dim .B) mm	Dim. L1 (mm) out	
#28~#26	0.08mm ² ~0.128mm ²	0.90mm~1.00mm	0.30~0.05mm	1.60~1.80mm	
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
#28	0.94±0.03mm	0.60±0.03mm	1.37±0.05mm	1.28±0.05mm	0.90kgf
#26		0.62±0.03mm		1.40±0.05mm	1.40kgf

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Crimp specification

Type Document	Crimp Specification	Revised /Edition	A2
Date Issued:	2020/11/09	Data Revised:	2022/05/19
Subject: 1804TF 1.80mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Description:

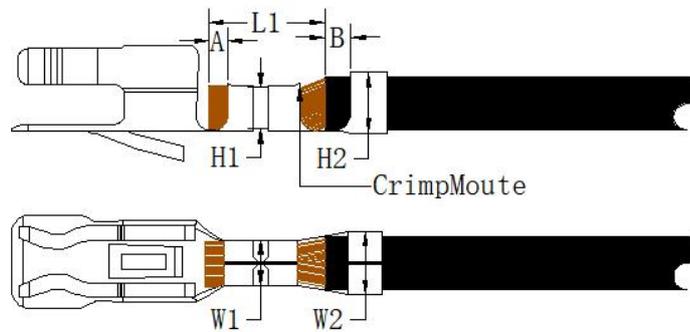
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(Crimped width of insulation barrel)

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.
6. Naked part of sheathed wire must be located in the vicinity of center B.
7. The Crimp mouth must be equipped like bell.

Crimp specification

Type Document	Crimp Specification	Revised /Edition	A2
Date Issued:	2020/11/09	Data Revised:	2022/05/19
Subject: 1804TF 1.80mm 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	Dim. L1 (mm) out	
#24~#22	0.22mm ² ~0.350mm ²	1.10mm~1.30mm	0.30~0.50mm	1.60~1.80mm	
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
0.22mm ²	1.25±0.03mm	0.75±0.03mm	1.45±0.05mm	1.45±0.05mm	40N
0.35mm ²		0.84±0.03mm		±0.05mm	50N

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Date Issued:	2020/11/09	Data Revised:	2020/11/09
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Description:

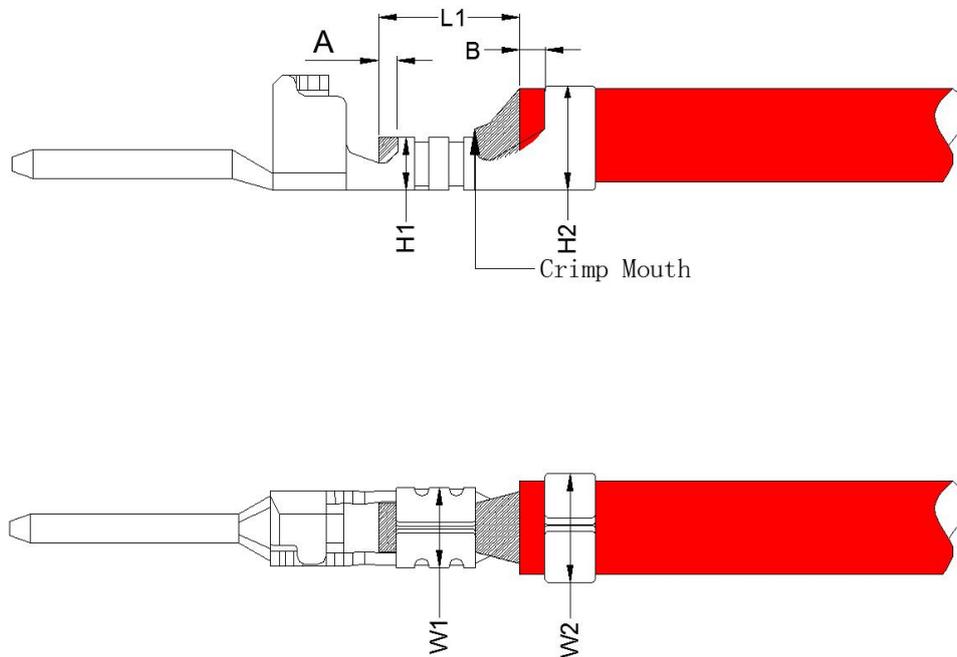
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Requirement:

Subject:UL1061 or equivalent type electric wire					
AWG#	Conductor (mm ²)	Insulation Diameter	Insulator skins length (Dim .B) mm	Dim. L1 (mm) out	
#26~#21	0.128mm ² ~0.412mm ²	1.00mm~1.35mm	0.30~0.50mm	1.60~1.80mm	
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
#26	1.23±0.03mm	0.86±0.03mm	1.43±0.05mm	1.30±0.05mm	1.40kgf
#24		0.93±0.03mm		1.40±0.05mm	2.30kgf
#22		1.02±0.03mm		1.60±0.05mm	3.60kgf
#21		1.08±0.03mm		1.75±0.05mm	4.70kgf

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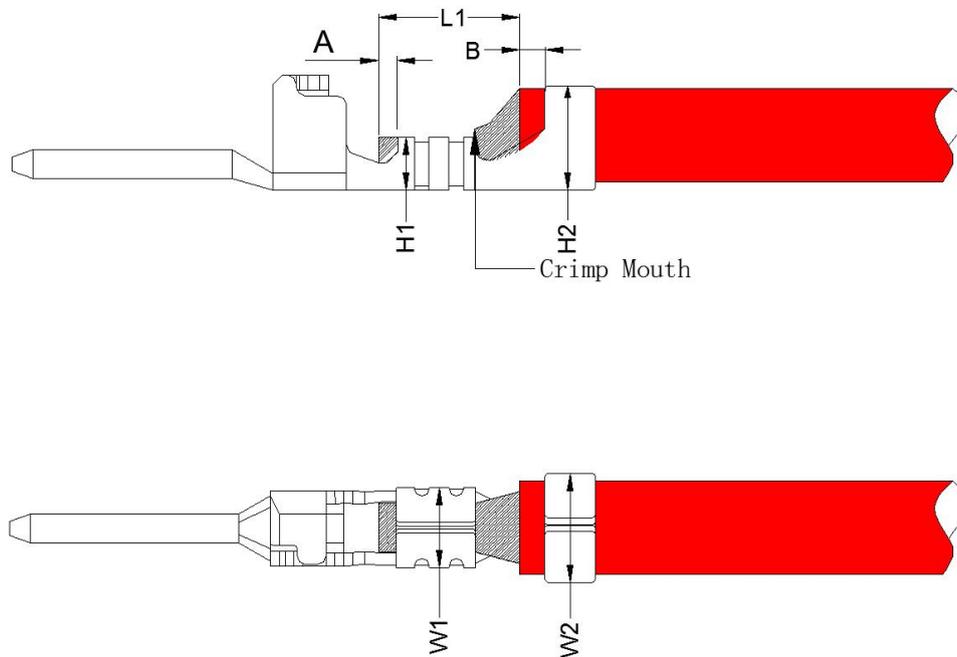
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Requirement:

Subject:FLRY-A or equivalent type electric wire					
AWG#	Conductor (mm ²)	Insulation Diameter	Insulator skins length (Dim .B) mm	Dim. L1 (mm) out	
#22	0.35mm ²	1.30mm	0.30~0.50mm	1.60~1.80mm	
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
0.35mm ²	1.27±0.03mm	1.00±0.03mm	1.43±0.05mm	1.72±0.05mm	50N

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