

Crimp specification

Type Document	Crimp Specification	Revised /Edition	A1
Date Issued:	2020/07/27	Data Revised:	2020/11/04
Subject: 1274T-E10S-01F 1.27mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Description:

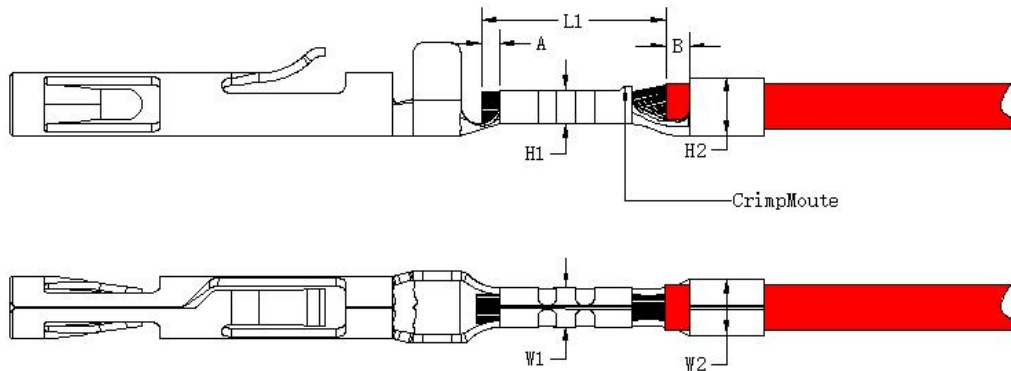
Height and width of conductor crimp core should be set as required.

(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:UL1571or 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
#30~#28	0.05mm ² ~0.08mm ²	1.0mm(max)	0.30mm~0.70mm	0.10mm~0.50mm	2.0mm~2.50mm
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
#30	0.79±0.03mm	0.43±0.03mm	0.97±0.03mm	1.00±0.05mm	0.68kgf
#28		0.46±0.03mm		1.17±0.05mm	0.91kgf

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.

Signature: FX ENG

Dongguan SESO Technology Co.,Ltd

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Date	REV	DESCRIPTION	MODIFY	APPROVAL
2020/07/27	A	Initial Issued	/	Jack Zhang
2020/11/04	A1	Modify crimping parameters	FX	Jack Zhang

Crimp specification

Type Document	Crimp Specification	Revised /Edition	A
Date Issued:	2022/09/30	Data Revised:	2022/09/30
Subject: 1274TF-PV10 1.27mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Description:

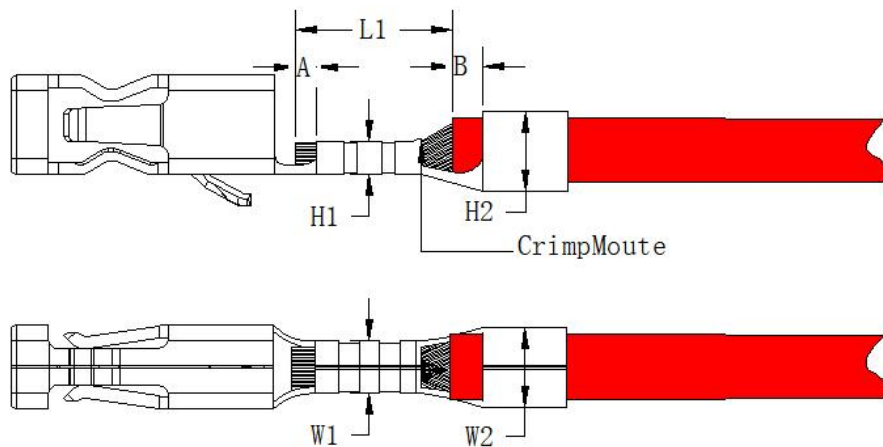
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Subject:UL1571or equivalent type electric wire

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#30~#28	0.05mm ² ~0.08mm ²	1.0mm(max)	0.20mm~0.50mm	0.30mm~0.70mm	1.0mm~1.30mm
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
#30	0.77±0.03mm	0.39±0.03mm	1.0±0.03mm	1.05±0.05mm	0.68kgf
#28		0.46±0.03mm		1.20±0.05mm	0.91kgf

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