

## Crimp specification

Type Document	Crimp Specification	Revised /Edition	A
Date Issued:	2020/11/09	Data Revised:	2020/11/09
Subject: 1804TF-B03SL-01Q 1.80mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

### Description:

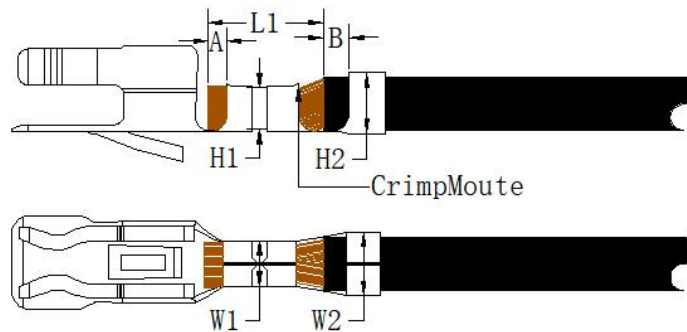
Height and width of conductor crimp core should be set as required.

(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

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Date Issued:	2020/11/09	Data Revised:	2020/11/09
Subject: 1804TF-B03SL-01Q 1.80mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Requirement:

Subject:UL1061 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
#28~#26	0.08mm <sup>2</sup> ~0.128mm <sup>2</sup>	1.20mm~1.30mm	0.30mm~0.60mm	0.10mm~0.40mm	1.30mm~1.60mm
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	1.0kgf
#26		0.62±0.03mm		1.40±0.05mm	2.0kgf

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

<b>Crimp specification</b>			
Type Document	Crimp Specification	Revised /Edition	A2
Date Issued:	2020/11/09	Data Revised:	2022/05/19
Subject: 1804TF-P03S-01Q 1.80mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

**Description:**

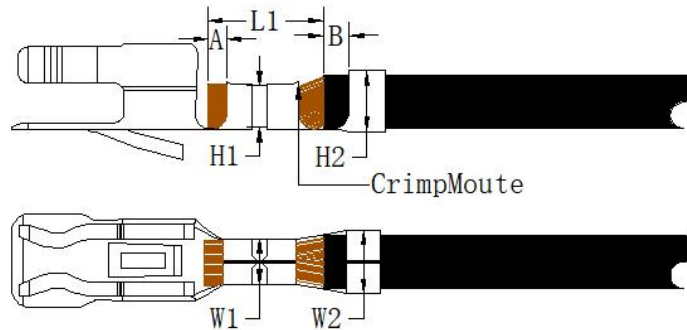
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**Position Graph:**



**Note:**

1. Conductor crimp width. W1
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4. Insulator crimp height. H2
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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-P03S-01Q 1.80mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Requirement:

Subject:FLRY-A 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
#24~#22	0.22mm <sup>2</sup> ~0.350mm <sup>2</sup>	1.20mm~1.30mm	0.30mm~0.60mm	0.10mm~0.40mm	1.30mm~1.60mm
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
0.22mm <sup>2</sup>	1.25±0.03mm	0.75±0.03mm	1.45±0.05mm	1.45±0.05mm	40.0N
0.35mm <sup>2</sup>		0.84±0.03mm		1.55±0.05mm	50.0N

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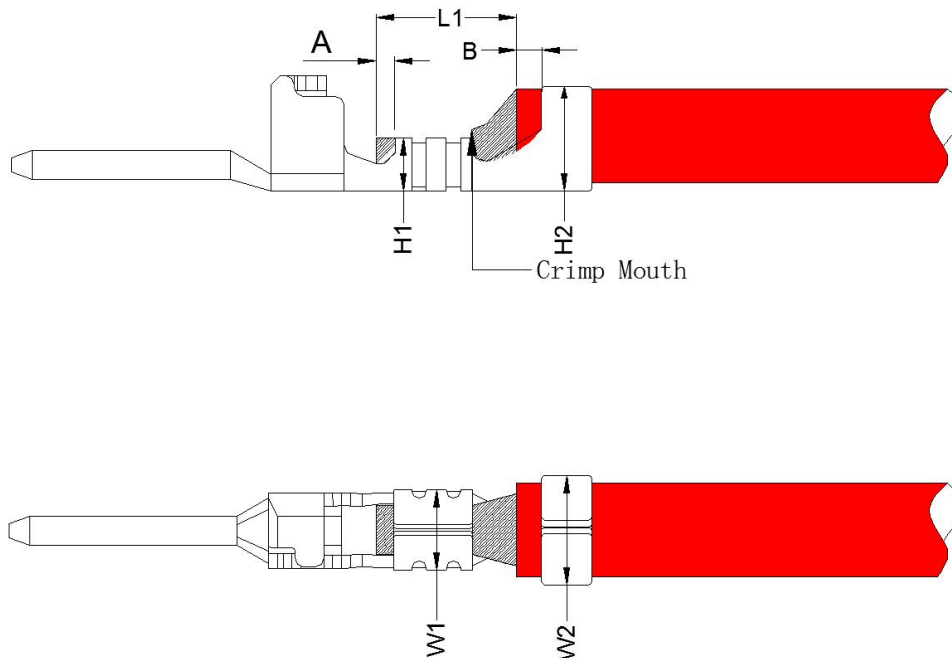
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Requirement:

Subject:UL1061 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
#26~#21	0.128mm <sup>2</sup> ~0.412mm <sup>2</sup>	1.30mm(Max)	0.20mm~0.50mm	0.20mm~0.50mm	1.10mm~1.50mm
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	2.0kgf
#24		0.93±0.03mm		1.40±0.05mm	3.0kgf
#22		1.02±0.03mm		1.60±0.05mm	5.0kgf
#21		1.08±0.03mm		1.75±0.05mm	5.0kgf

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## Crimp specification

Type Document	Crimp Specification	Revised /Edition	A
Date Issued:	2021/07/07	Data Revised:	2021/07/07
Subject: 1804TM-B03S-01Q 1.80mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

### Description:

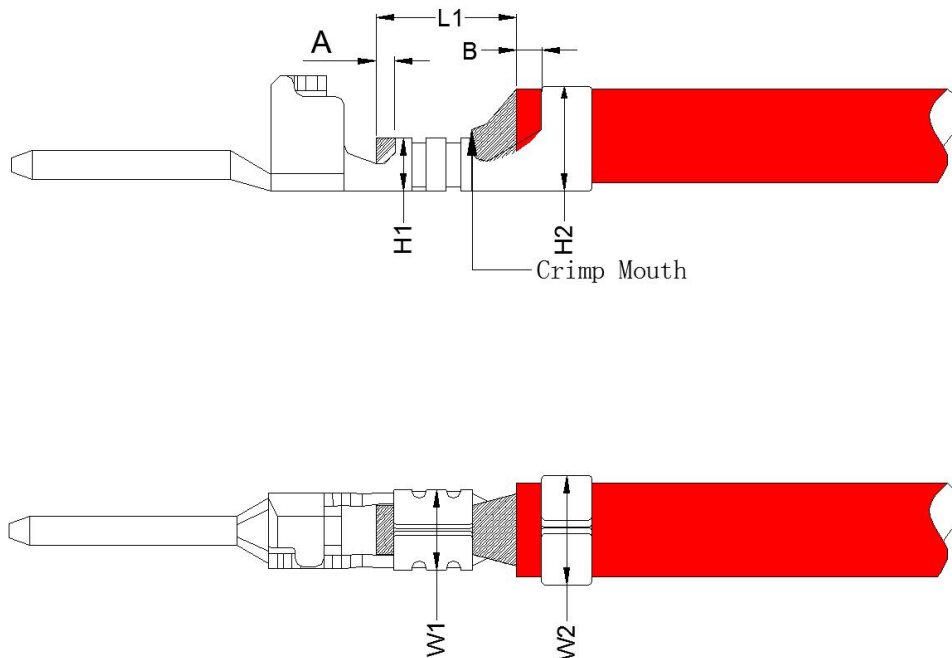
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Date Issued:	2021/07/07	Data Revised:	2021/07/07
Subject: 1804TM-B03S-01Q 1.80mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Requirement:

Subject:FLRY-A 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
#22	0.35mm <sup>2</sup>	1.30mm(Max)	0.20mm~0.50mm	0.20mm~0.50mm	1.10mm~1.50mm
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
0.35mm <sup>2</sup>	1.27±0.03mm	1.0±0.03mm	1.43±0.05mm	1.72±0.05mm	50.0N

Remarks

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Date Issued:	2020/11/09	Data Revised:	2024/05/25
Subject: 1804TF-B03S-01Q 1.80mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

### Description:

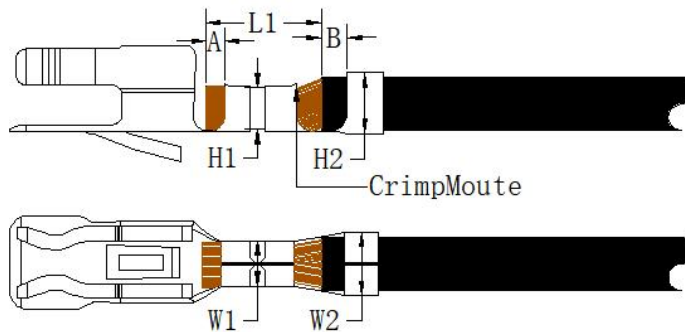
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Subject: 1804TF-B03S-01Q 1.80mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Requirement:

Subject:UL1061or 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
#26~#22	0.13mm <sup>2</sup> ~0.325mm <sup>2</sup>	1.20mm~1.30mm	0.30mm~0.60mm	0.10mm~0.40mm	1.30mm~1.60mm
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
#26	1.20±0.03mm	0.74±0.03mm	1.47±0.05mm	1.20±0.05mm	2.0kgf
#24		0.77±0.03mm		1.35±0.05mm	3.0kgf
#22		0.87±0.03mm		1.45±0.05mm	5.0kgf

Remarks

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Date	REV	DESCRIPTION	MODIFY	APPROVAL
2020/11/09	A	Initial Issued	/	Jack Zhang
2021/07/02	A1	Modified tension standard	FX	Jack Zhang
2024/05/25	A2	Added 26AWG crimping standard	FX	Jack Zhang