

Crimp specification

Type Document	Crimp Specification	Revised /Edition	A3
Date Issued:	2020/11/18	Data Revised:	2023/09/08
Subject: 2022T-HY2B 2.0mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Description:

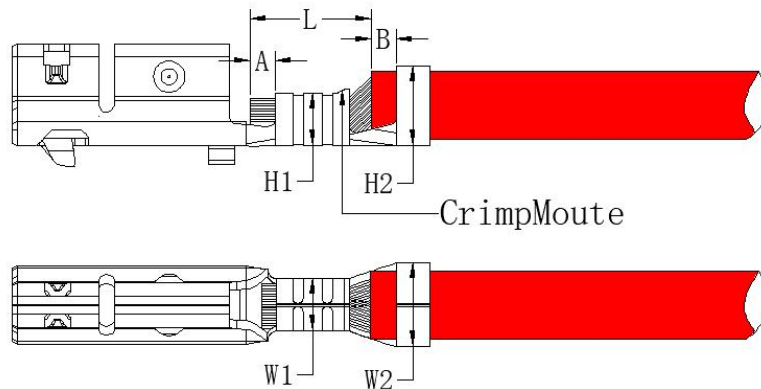
Height and width of conductor crimp core should be set as required.

(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-A or UL1061 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
#26~#24	0.128mm ² ~0.22mm ²	1.40mm(max)	0.40mm~0.80mm	0.5mm(max)	1.90mm~2.10mm
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
#26	1.05±0.03mm	0.63±0.03mm	1.45±0.05mm	1.32±0.05mm	13.7N
0.22mm ²		0.69±0.03mm		1.45±0.05mm	40.0N

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.

Signature: FX ENG

Dongguan SESO Technology Co.,Ltd

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Date	REV	DESCRIPTION	MODIFY	APPROVAL
2020/11/18	A	Initial Issued	/	Kim Huang
2021/06/18	A1	Modify H1 crimping parameters	FX	Kim Huang
2021/02/17	A2	Change the wire specification	FX	Jack Zhang
2023/09/08	A3	Add A-size data	FX	Jack Zhang

Crimp specification

Type Document	Crimp Specification	Revised /Edition	A6
Date Issued:	2020/11/18	Data Revised:	2023/12/16
Subject: 2022TH 2.00mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Description:

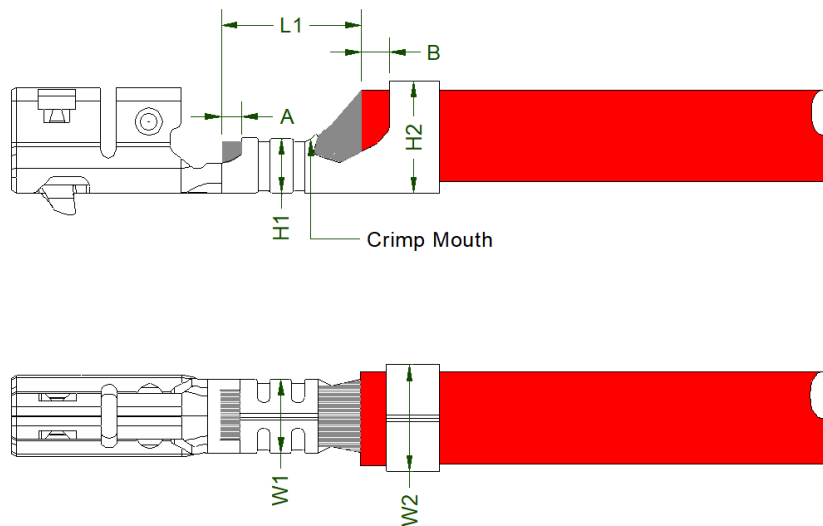
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(conductor crimp height and width of conductor barrel)

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Crimp specification			
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Subject: 2022TH 2.00mm 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	1.50mm(max)	0.40mm~0.80mm	0.5mm(max)	1.90mm~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	1.25±0.03mm	0.71±0.03mm	1.57±0.05mm	1.45±0.05mm	40.0N
0.35mm ²		0.78±0.03mm		1.50±0.05mm	50.0N

Remarks

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Signature: JACK ENG
Dongguan SESO Technology Co.,Ltd

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2020/11/18	A	Initial Issued	/	Kim Huang
2021/06/18	A1	Modify H1 crimping parameters	FX	Kim Huang
2023/02/15	A2	Change the wire specification	FX	Jack Zhang
2023/09/04	A3	Modifying H1 dimensions	FX	Jack Zhang
2023/09/08	A4	Add A-size data	FX	Jack Zhang
2023/09/15	A5	Updated 0.22mm ² H1 crimping height	FX	Jack Zhang
2023/12/16	A6	Riveting foot set change	FX	Jack Zhang