

# Crimp specification

|  |                     |                  |                                 |
|--|---------------------|------------------|---------------------------------|
| Type Document  | Crimp Specification | Revised /Edition | A2                              |
| Date Issued:   | 2020/08/15          | Data Revised:    | 2022/05/19                      |
| Subject: 3025TF-PSN-B<br>3.00mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

## Description:

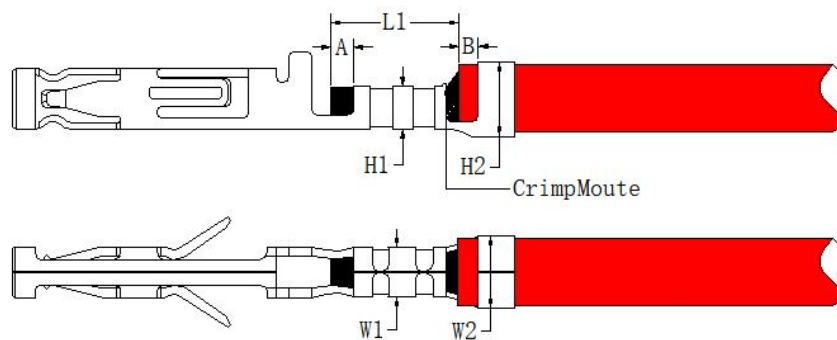
Height and width of conductor crimp core should be set as required.

(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 | A2                              |
| Date Issued:   | 2020/08/15          | Data Revised:    | 2022/05/19                      |
| Subject: 3025TF-PSN-B<br>3.00mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

Requirement:

| Subject:FLRY-A or equivalent type electric wire |  |                     |                                       |   |                              |
|---|--|---------------------|---------------------------------------|---|------------------------------|
| AWG#  | Conductor (mm <sup>2</sup> )             | Insulation Diameter | Insulator skins length<br>(Dim .B) mm | Copper wire leakage size<br>(Dim .A) mm | Dim. L1 (mm) out             |
| #24~#20   | 0.22mm <sup>2</sup> ~0.50mm <sup>2</sup> | 1.85mm(max)         | 0.20mm~0.50mm                         | 0.20mm~0.50mm                           | 2.40mm~2.70mm                |
| Wire Gauge<br>(AWG#)                            | Conductor Crimp Area                     |                     | Insulator Crimp Area                  |   | Terminal Tensile<br>Strength |
|   | Width (W1)                               | Height(H1)          | Width (W2)                            | Height(H2)                              |                              |
| 0.22mm <sup>2</sup>                             | 1.45±0.03mm                              | 0.80±0.03mm         | 1.85±0.05mm                           | 1.45±0.05mm                             | 40.0N                        |
| 0.35mm <sup>2</sup>                             |  | 0.85±0.03mm         |                                       | 1.65±0.05mm                             | 50.0N                        |
| 0.50mm <sup>2</sup>                             |  | 0.95±0.03mm         |                                       | 1.70±0.05mm                             | 60.0N                        |

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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# Crimp specification

|  |                     |                  |                                 |
|--|---------------------|------------------|---------------------------------|
| Type Document  | Crimp Specification | Revised /Edition | A1                              |
| Date Issued:   | 2021/01/04          | Data Revised:    | 2024/05/21                      |
| Subject: 3025TF-PSN-LA<br>3.0mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

## Description:

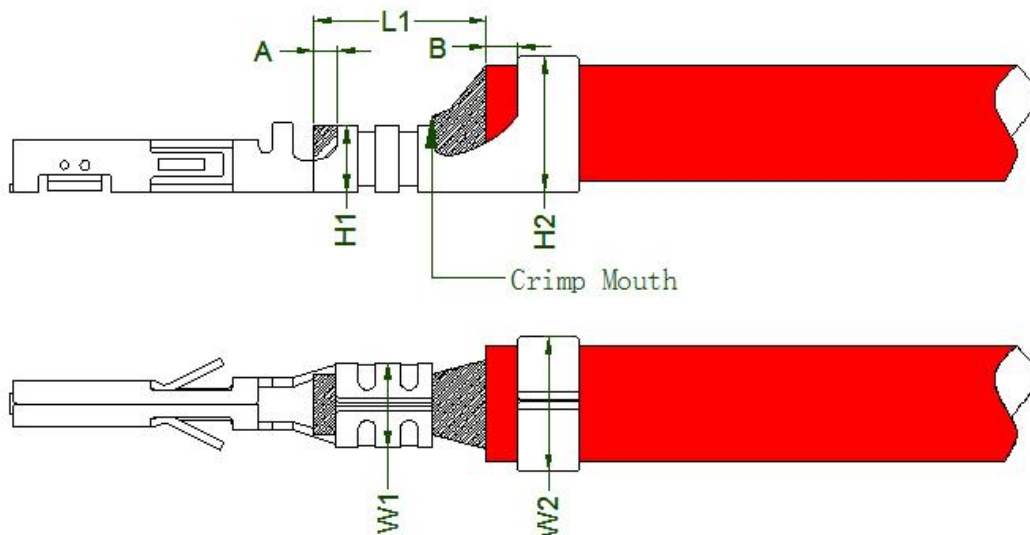
Height and width of conductor crimp core should be set as required.

(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:   | 2021/01/04          | Data Revised:    | 2024/05/21                      |
| Subject: 3025TF-PSN-LA<br>3.0mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

Requirement:

Subject:UL1061 or equivalent type electric wire

| AWG#                 | Conductor (mm <sup>2</sup> )             | Insulation Diameter | Insulator skins length<br>(Dim .B) mm | Copper wire leakage size<br>(Dim .A) mm | Dim. L1 (mm) out             |
|----------------------|--|---------------------|---------------------------------------|---|------------------------------|
| #30~#26              | 0.05mm <sup>2</sup> ~0.13mm <sup>2</sup> | 1.27mm(max)         | 0.20mm~0.50mm                         | 0.20mm~0.50mm                           | 2.40mm~2.70mm                |
| Wire Gauge<br>(AWG#) | Conductor Crimp Area                     |                     | Insulator Crimp Area                  |   | Terminal Tensile<br>Strength |
|                      | Width (W1)                               | Height(H1)          | Width (W2)                            | Height(H2)                              |                              |
| #30                  | 1.14±0.03mm                              | 0.61±0.03mm         | 1.50±0.05mm                           | 1.10±0.05mm                             | 0.50kgf                      |
| #28                  |  | 0.63±0.03mm         |                                       | 1.15±0.05mm                             | 1.0kgf                       |
| #26                  |  | 0.66±0.03mm         |                                       | 1.30±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.
3. 30WAG only meets tensile standards.

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# Crimp specification

|  |                     |                  |                                 |
|--|---------------------|------------------|---------------------------------|
| Type Document  | Crimp Specification | Revised /Edition | A1                              |
| Date Issued:   | 2021/01/04          | Data Revised:    | 2024/05/21                      |
| Subject: 3025TF-PSN-LA<br>3.0mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

| Date       | REV | DESCRIPTION                   | MODIFY | APPROVAL   |
|------------|-----|-------------------------------|--------|------------|
| 2021/01/04 | A   | Initial Issued                | /      | Jack Zhang |
| 2024/05/21 | A1  | Added 30AWG crimping standard | FX     | Jack Zhang |

## Crimp specification

|   |                     |                  |                                 |
|---|---------------------|------------------|---------------------------------|
| Type Document   | Crimp Specification | Revised /Edition | A3                              |
| Date Issued:  | 2020/08/15          | Data Revised:    | 2024/03/27                      |
| Subject: 3025TF-PSN-V<br>3.0mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

### Description:

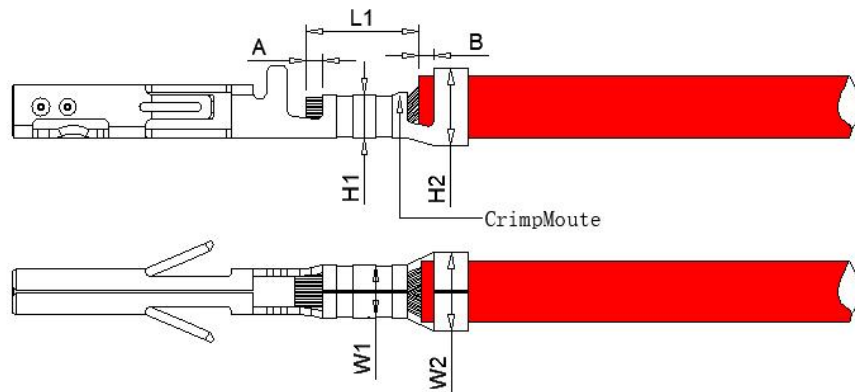
Height and width of conductor crimp core should be set as required.

(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 | A3                              |
| Date Issued:  | 2020/08/15          | Data Revised:    | 2024/03/27                      |
| Subject: 3025TF-PSN-V<br>3.0mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

Requirement:

| Subject:FLRY-A or equivalent type electric wire |  |                     |                                       |   |                              |
|---|--|---------------------|---------------------------------------|---|------------------------------|
| AWG#  | Conductor (mm <sup>2</sup> )             | Insulation Diameter | Insulator skins length<br>(Dim .B) mm | Copper wire leakage size<br>(Dim .A) mm | Dim. L1 (mm) out             |
| #24~#20   | 0.22mm <sup>2</sup> ~0.50mm <sup>2</sup> | 1.85mm(max)         | 0.20mm~0.50mm                         | 0.20mm~0.50mm                           | 2.40mm~2.70mm                |
| Wire Gauge<br>(AWG#)                            | Conductor Crimp Area                     |                     | Insulator Crimp Area                  |   | Terminal Tensile<br>Strength |
|   | Width (W1)                               | Height(H1)          | Width (W2)                            | Height(H2)                              |                              |
| 0.22mm <sup>2</sup>                             | 1.37±0.03mm                              | 0.83±0.03mm         | 1.85±0.05mm                           | 1.60±0.05mm                             | 40.0N                        |
| 0.35mm <sup>2</sup>                             | 1.55±0.03mm                              | 0.86±0.03mm         |                                       | 1.65±0.05mm                             | 50.0N                        |
| 0.50mm <sup>2</sup>                             |  | 0.93±0.03mm         |                                       | 1.70±0.05mm                             | 60.0N                        |

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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# Crimp specification

|   |                     |                  |                                 |
|---|---------------------|------------------|---------------------------------|
| Type Document   | Crimp Specification | Revised /Edition | A3                              |
| Date Issued:  | 2020/08/15          | Data Revised:    | 2024/03/27                      |
| Subject: 3025TF-PSN-V<br>3.0mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

| Date       | REV | DESCRIPTION                                       | MODIFY | APPROVAL   |
|------------|-----|---|--------|------------|
| 2020/08/15 | A   | Initial Issued                                    | /      | Jack Zhang |
| 2021/07/21 | A1  | Added applicable wire                             | FX     | Jack Zhang |
| 2022/05/19 | A2  | Modified tension standard                         | FX     | Jack Zhang |
| 2024/03/27 | A3  | Modify the 0.22mm <sup>2</sup> crimping parameter | FX     | Jack Zhang |



## Crimp specification

|  |                     |                  |                                 |
|--|---------------------|------------------|---------------------------------|
| Type Document  | Crimp Specification | Revised /Edition | A                               |
| Date Issued:   | 2022/12/14          | Data Revised:    | 2022/12/14                      |
| Subject: 3025TLF-PSN-V<br>3.0mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

### Description:

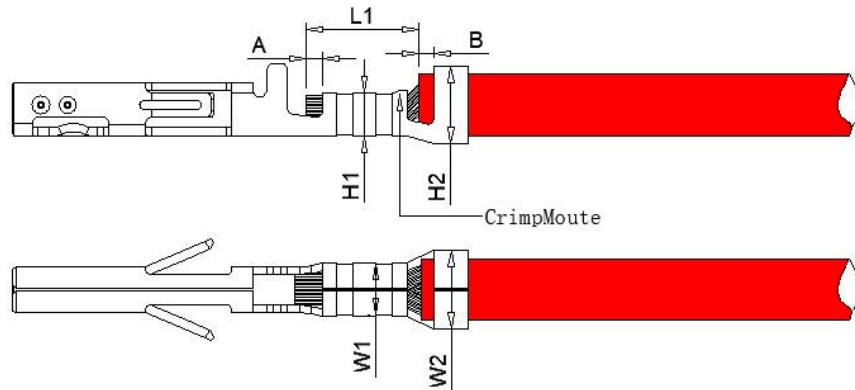
Height and width of conductor crimp core should be set as required.

(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 | A                               |
| Date Issued:   | 2022/12/14          | Data Revised:    | 2022/12/14                      |
| Subject: 3025TLF-PSN-V<br>3.0mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

Requirement:

Subject:UL1061 or equivalent type electric wire

| AWG#                 | Conductor (mm <sup>2</sup> )             | Insulation Diameter | Insulator skins length<br>(Dim .B) mm | Copper wire leakage size<br>(Dim .A) mm | Dim. L1 (mm) out             |
|----------------------|--|---------------------|---------------------------------------|---|------------------------------|
| #28~#26              | 0.08mm <sup>2</sup> ~0.13mm <sup>2</sup> | 1.27mm(max)         | 0.20mm~0.50mm                         | 0.20mm~0.50mm                           | 2.40mm~2.70mm                |
| Wire Gauge<br>(AWG#) | Conductor Crimp Area                     |                     | Insulator Crimp Area                  |   | Terminal Tensile<br>Strength |
|                      | Width (W1)                               | Height(H1)          | Width (W2)                            | Height(H2)                              |                              |
| #26                  | 1.10±0.03mm                              | 0.70±0.03mm         | 1.45±0.05mm                           | 1.35±0.05mm                             | 2.0kgf                       |
| #28                  |  | 0.65±0.03mm         |                                       | 1.25±0.05mm                             | 1.0kgf                       |

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.

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## Crimp specification

|   |                     |                  |                                 |
|---|---------------------|------------------|---------------------------------|
| Type Document   | Crimp Specification | Revised /Edition | A                               |
| Date Issued:  | 2020/08/15          | Data Revised:    | 2020/08/15                      |
| Subject: 3025TM-PSN<br>3.0mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

### Description:

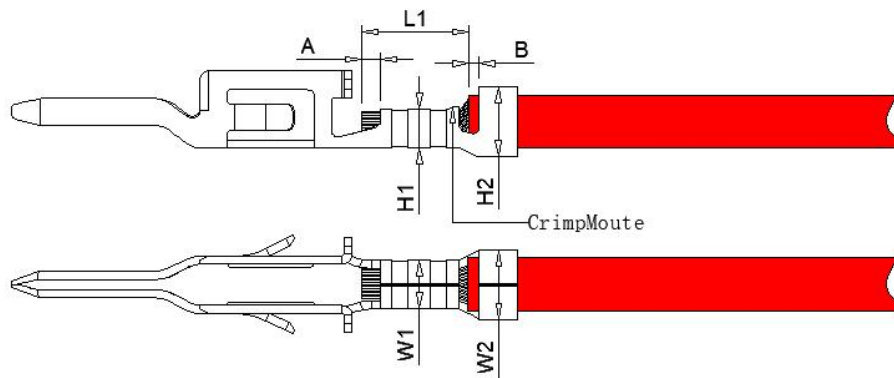
Height and width of conductor crimp core should be set as required.

(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 | A                               |
| Date Issued:  | 2020/08/15          | Data Revised:    | 2020/08/15                      |
| Subject: 3025TM-PSN<br>3.0mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

Requirement:

| Subject:FLRY-A or equivalent type electric wire |  |                     |                                       |   |                              |
|---|--|---------------------|---------------------------------------|---|------------------------------|
| AWG#  | Conductor (mm <sup>2</sup> )             | Insulation Diameter | Insulator skins length<br>(Dim .B) mm | Copper wire leakage size<br>(Dim .A) mm | Dim. L1 (mm) out             |
| #22~#20   | 0.35mm <sup>2</sup> ~0.50mm <sup>2</sup> | 1.85mm(max)         | 0.20mm~0.40mm                         | 0.20mm~0.50mm                           | 2.40mm~2.70mm                |
| Wire Gauge<br>(AWG#)                            | Conductor Crimp Area                     |                     | Insulator Crimp Area                  |   | Terminal Tensile<br>Strength |
|   | Width (W1)                               | Height(H1)          | Width (W2)                            | Height(H2)                              |                              |
| 0.35mm <sup>2</sup>                             | 1.45±0.03mm                              | 0.92±0.03mm         | 1.85±0.05mm                           | 1.65±0.05mm                             | 50.0N                        |
| 0.50mm <sup>2</sup>                             |  | 1.00±0.03mm         |                                       | 1.70±0.05mm                             | 60.0N                        |

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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# Crimp specification

|  |                     |                  |                                 |
|--|---------------------|------------------|---------------------------------|
| Type Document  | Crimp Specification | Revised /Edition | A                               |
| Date Issued:   | 2022/01/12          | Data Revised:    | 2022/01/12                      |
| Subject: 3025TM-PSN-LA<br>3.0mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

## Description:

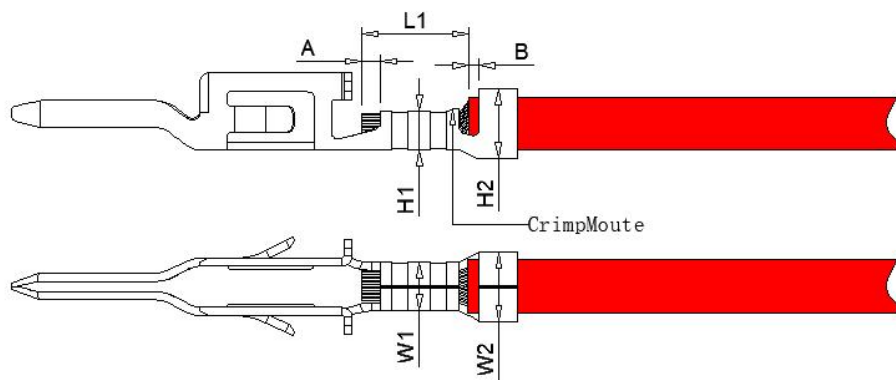
Height and width of conductor crimp core should be set as required.

(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 | A                               |
| Date Issued:   | 2022/01/12          | Data Revised:    | 2022/01/12                      |
| Subject: 3025TM-PSN-LA<br>3.0mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

Requirement:

| Subject:UL1061 or UL1571 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          |
| #30~#26  | 0.05mm <sup>2</sup> ~0.13mm <sup>2</sup> | 1.27mm (max)        | 0.20mm~0.40mm                      | 0.20mm~0.50mm                        | 2.40mm~2.70mm             |
| Wire Gauge (AWG#)                                      | Conductor Crimp Area                     |                     | Insulator Crimp Area               |                                      | Terminal Tensile Strength |
|  | Width (W1)                               | Height(H1)          | Width (W2)                         | Height(H2)                           |                           |
| #26  | 1.10±0.03mm                              | 0.69±0.03mm         | 1.45±0.05mm                        | 1.35±0.05mm                          | 2.0kgf                    |
| #28  |  | 0.63±0.03mm         |                                    | 1.25±0.05mm                          | 1.0kgf                    |
| #30  |  | 0.60±0.03mm         |                                    | 1.15±0.05mm                          | 0.50kgf                   |

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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| Crimp specification   |                     |                  |                                 |
|---|---------------------|------------------|---------------------------------|
| Type Document   | Crimp Specification | Revised /Edition | A                               |
| Date Issued:  | 2024/05/24          | Data Revised:    | 2024/05/24                      |
| Subject: 3025TM-PSN<br>3.0mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

Description:

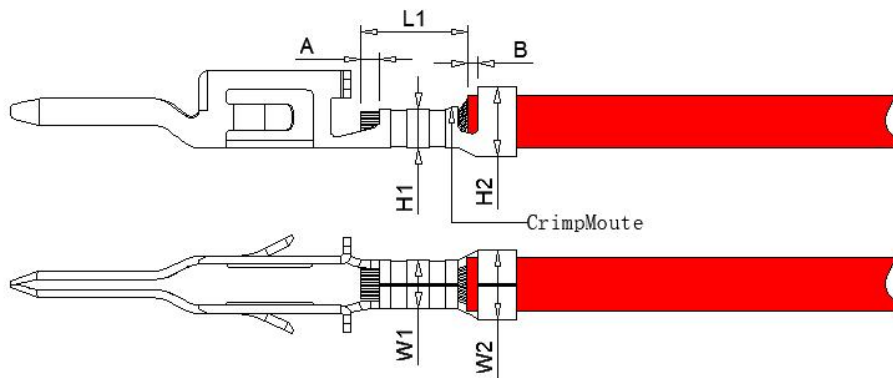
Height and width of conductor crimp core should be set as required.

(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 | A                               |
| Date Issued:  | 2024/05/24          | Data Revised:    | 2024/05/24                      |
| Subject: 3025TM-PSN<br>3.0mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

Requirement:

Subject:FLRY-A or UL1061 equivalent type electric wire

| AWG#                 | Conductor (mm <sup>2</sup> )             | Insulation Diameter | Insulator skins length<br>(Dim .B) mm | Copper wire leakage size<br>(Dim .A) mm | Dim. L1 (mm) out             |
|----------------------|--|---------------------|---------------------------------------|---|------------------------------|
| #24~#20              | 0.20mm <sup>2</sup> ~0.50mm <sup>2</sup> | 1.85mm(max)         | 0.20mm~0.40mm                         | 0.20mm~0.50mm                           | 2.40mm~2.70mm                |
| Wire Gauge<br>(AWG#) | Conductor Crimp Area                     |                     | Insulator Crimp Area                  |   | Terminal Tensile<br>Strength |
|                      | Width (W1)                               | Height(H1)          | Width (W2)                            | Height(H2)                              |                              |
| #24                  | 1.45±0.03mm                              | 0.77±0.03mm         | 1.85±0.05mm                           | 1.60±0.05mm                             | 2.0kgf                       |
| 0.35mm <sup>2</sup>  |  | 0.92±0.03mm         |                                       | 1.65±0.05mm                             | 4.0kgf                       |
| 0.50mm <sup>2</sup>  |  | 1.00±0.03mm         |                                       | 1.70±0.05mm                             | 6.0kgf                       |

## 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.

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# Crimp specification

|  |                     |                  |                                 |
|--|---------------------|------------------|---------------------------------|
| Type Document  | Crimp Specification | Revised /Edition | A                               |
| Date Issued:   | 2023/10/11          | Data Revised:    | 2023/10/11                      |
| Subject:3025TLF-PG03-B<br>3.0mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

## Description:

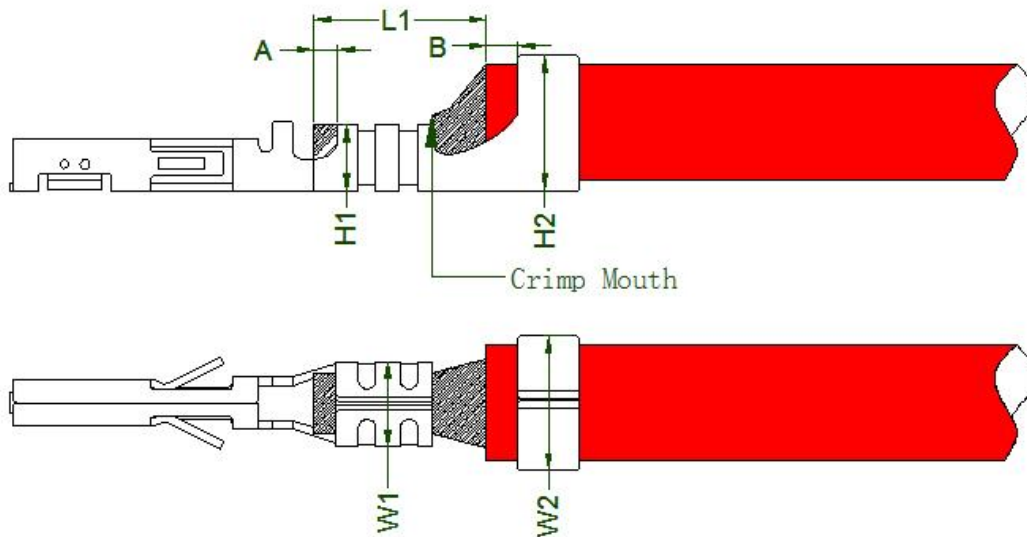
Height and width of conductor crimp core should be set as required.

(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 | A                               |
| Date Issued:   | 2023/10/11          | Data Revised:    | 2023/10/11                      |
| Subject:3025TLF-PG03-B<br>3.0mm Pitch Terminal crimp specification |                     |                  | Issued By:<br>Engineering Dept. |

Requirement:

Subject: FLRYW-A or UL1061 equivalent type electric wire

| AWG#                 | Conductor (mm <sup>2</sup> ) | Insulation Diameter | Insulator skins length<br>(Dim .B) mm | Copper wire leakage size<br>(Dim .A) mm | Dim. L1 (mm) out             |
|----------------------|------------------------------|---------------------|---------------------------------------|---|------------------------------|
| #26~#24              | 0.13~0.22mm <sup>2</sup>     | 1.10mm(max)         | 0.20mm~0.40mm                         | 0.10mm~0.50mm                           | 2.40mm~3.10mm                |
| Wire Gauge<br>(AWG#) | Conductor Crimp Area         |                     | Insulator Crimp Area                  |   | Terminal Tensile<br>Strength |
|                      | Width (W1)                   | Height(H1)          | Width (W2)                            | Height(H2)                              |                              |
| 0.13mm <sup>2</sup>  | 1.18±0.03mm                  | 0.66±0.03mm         | 1.35±0.05mm                           | 1.25±0.05mm                             | 13.7N                        |
| 0.22mm <sup>2</sup>  |                              | 0.77±0.03mm         |                                       | 1.30±0.05mm                             | 30.0N                        |

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

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