



SPECIFICATION

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SPEC. NO.: PS-88467-TXXX REVISION: A

PRODUCT NAME: 1.25mm WTB Crimp terminal

PRODUCT NO: 88467 Series

PREPARED: ZHUWEI DATE: 2018.08.14	CHECKED: BRAVE DATE: 2018.08.14	APPROVED: BRAVE DATE: 2018.08.14
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TITLE: **1.25MM WTB CRIMP TERMINAL**

RELEASE DATE: 2018/08/14

REVISION: A

ECN No: ECN-1808274

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Aces P/N: **88467 series**

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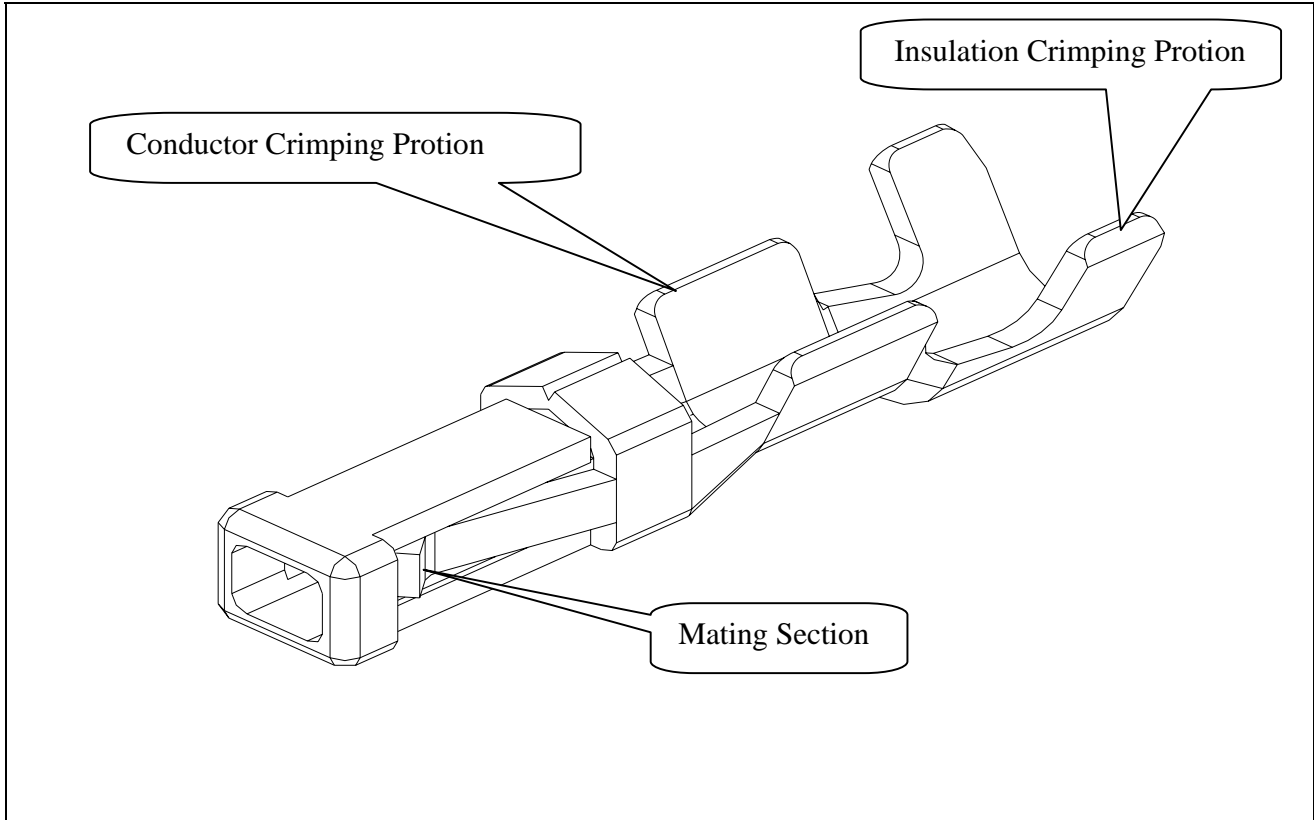
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1 Revision History

Rev.	ECN #	Revision Description	Approved	Date
O	ECN-1001103	NEW SPEC	Jason	2010/01/19
A	ECN-1808274	Updated Salt Spray	ZHUWEI	2018/08/14

2 ANATOMY OF CRIMPING TERMINAL



3 APPLICABLE WIRES: UL10064 ETFE WIRE

AWG Size:AWG34#

Insulation OD: $\Phi 0.32 \pm 0.01 \text{mm}$

4 PERFORMANCE

4.1. Test Requirements and Procedures Summary

ENVIRONMENTAL		
Item	Requirement	Standard
Salt Spray (Only for gold plating)	Subject mated/unmated connectors to 5% salt-solution concentration, 35°C	Under the condition that the electroplating layer on the metal surface is not destroyed. (I) Gold flash for 8 hours (II) Gold plating 3u" for 48 hours (III) Gold plating 5u" Min. for 96 hours (EIA-364-26)

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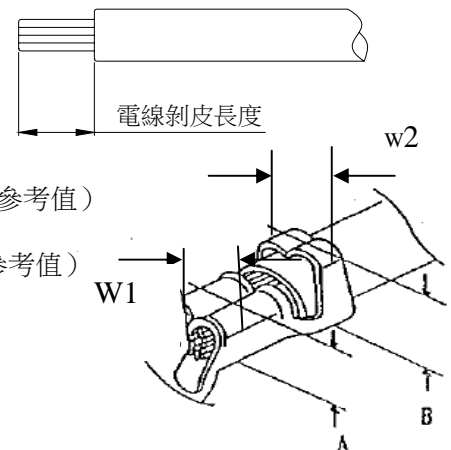
5 CRIMPING CONDITIONN

鉚線條件表 CRIMPING CONDITION

件編號 Part number	品名 Description	適用電線 Applicable wire					
		AWG Size	計算截面積 (mm ²) Sec. area	外被外徑(mm) Insulation OD			
88467-Txxx	1.25mm Pitch WTB						
	電線 Wire	34	0.031	Φ 0.32+/-0.01			
NO.	電線名	規格		芯線鉚壓 高度 Conductor crimping height (mm)	外被鉚壓 高度 Insulator crimping height (mm)	保持力 Crimping retention force	備注 Remarks
	UL Style	Specification					
1	UL10064 電子線 Stranded wire	AWG Size	34	0.35~0.50	0.7~0.8	3N 以上	鍍錫軟銅線 Tin plated annealed copper wire
		芯線構成 Construction	7C*Φ0.064+/- 0.003mm				
		計算截面積 Sec. area	0.031mm ²				
		外被外徑 Insulation OD	0.32+/-0.01mm				
		芯線 Inner Conductor Dia.	0.19mm`				

Note:

- 1、W1為芯線導體鉚壓後之寬度：W1=0.90~0.95mm(參考值)
- 2、W2為電線外被部分鉚壓後之寬度：W2=0.80~0.85mm(參考值)
- 3、A為芯線導體鉚壓後之高度(conductor Crimping height)：A值如上表(參考值)
- 4、B為電線外被鉚壓後之高度(Insulator Crimping height)：B值如上表(參考值)
- 5、電線剝皮長度：1.5~1.9mm(參考值)



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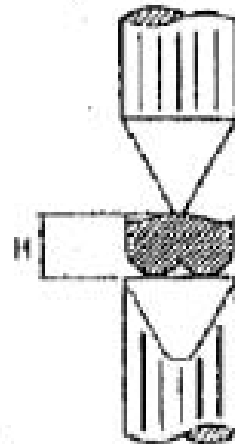
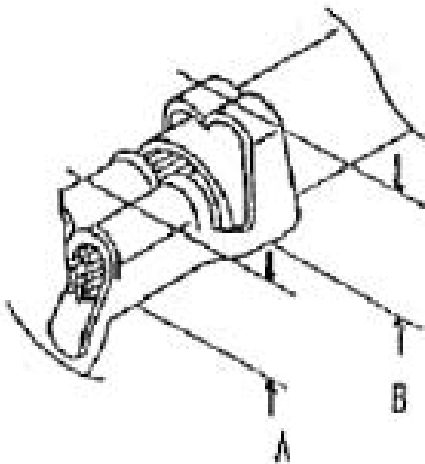
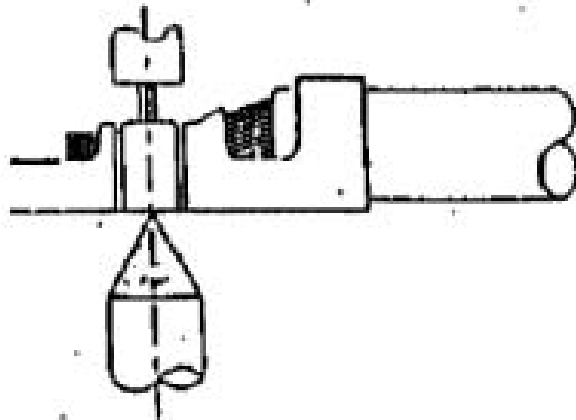
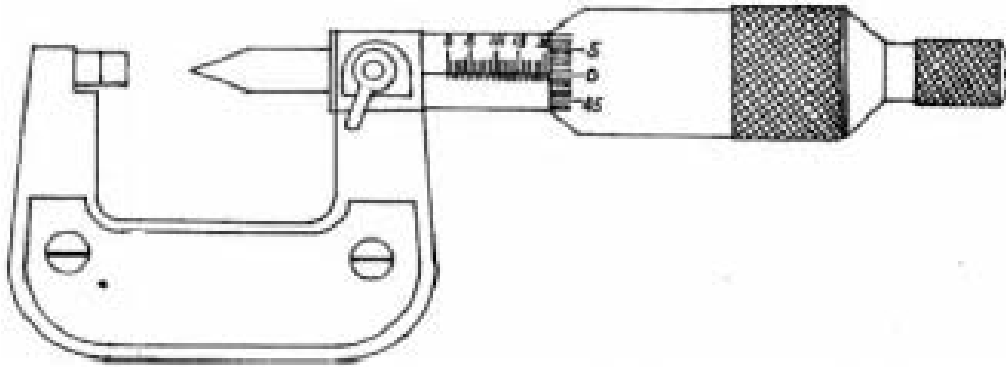
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6 CRIMPING HEIGHT MEASUREMENT



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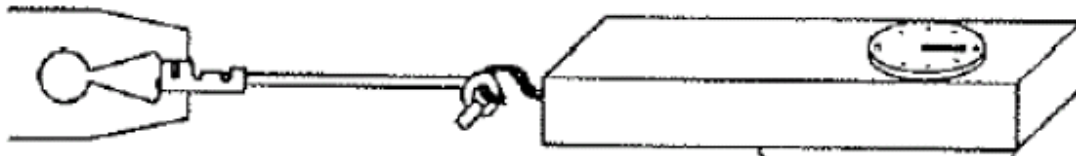
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7 PULL FORCE OF CRIMPING SECTION MEASUREMENT

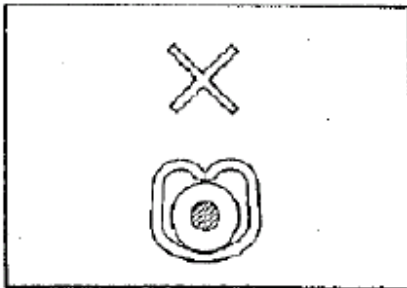


Before test samples, please measure crimp height and do not crimp insulation.

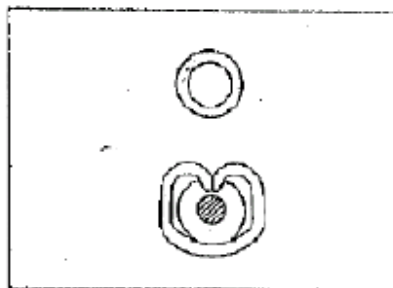


Pull Force of Crimp Section Measurement

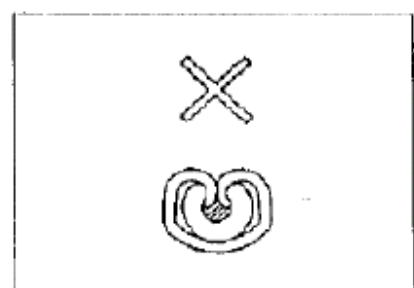
8 STANDARD INSULATION CRIMPING



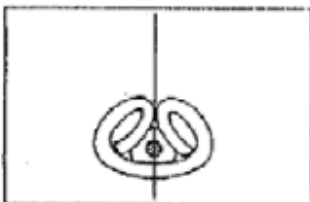
Not enough crimp



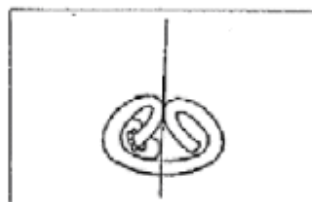
Good



Crimp too much

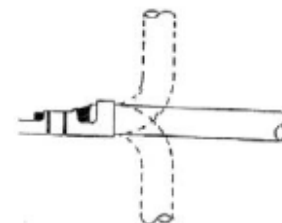


Good



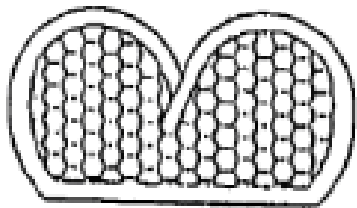
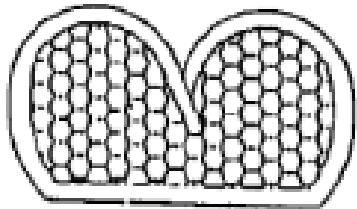
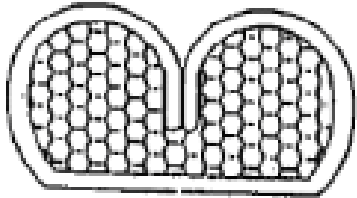
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Insulation Crimp Condition

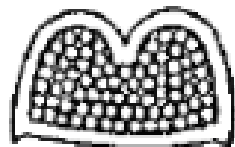


As following figure shown. It is no problem if wire bent up down 90 degrees 1 cycle and insulation position still in ideal position.

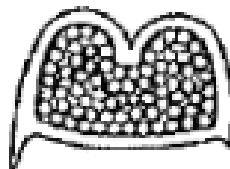
9 CONDUCTORS CRIMPING CONDITION



Lower conduct
retension force



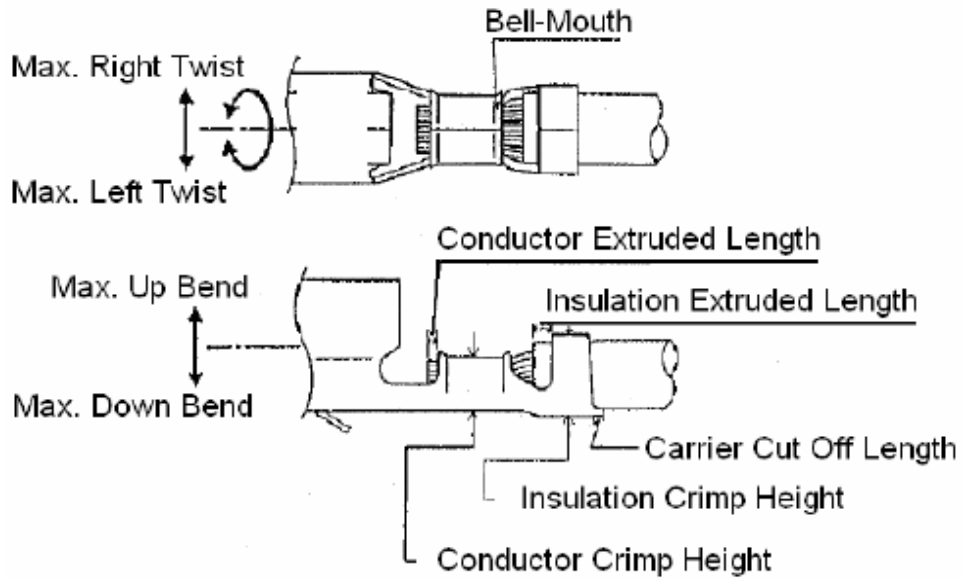
Good



Large burr

NG

10 CRIMPING REQUIREMENT



Item	Range (Ref.)
Max. Up Bend	6°
Max. Down Bend	6°
Max. Left Twist	5°
Max. Right Twist	5°
Bell-Mouth Length	0.1~0.3 mm
Carrier Cut Off Length	0~0.5 mm
Conductor Extruded Length	0.3~0.6 mm