SPECIFICATION

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SPEC. NO.: PS-51297-TXXX-XXX **REVISION:** O

PRODUCT NAME: 1.0MM WTB CRIMPING TERMINAL

PRODUCT NO: 51297-Txxx-xxx

PREPARED:	CHECKED:	APPROVED:
XIUJIN	**BRAVE**	**FRANK**
DATE: **2015/04/30**	DATE: **2015/04/30**	DATE: **2015/04/30**

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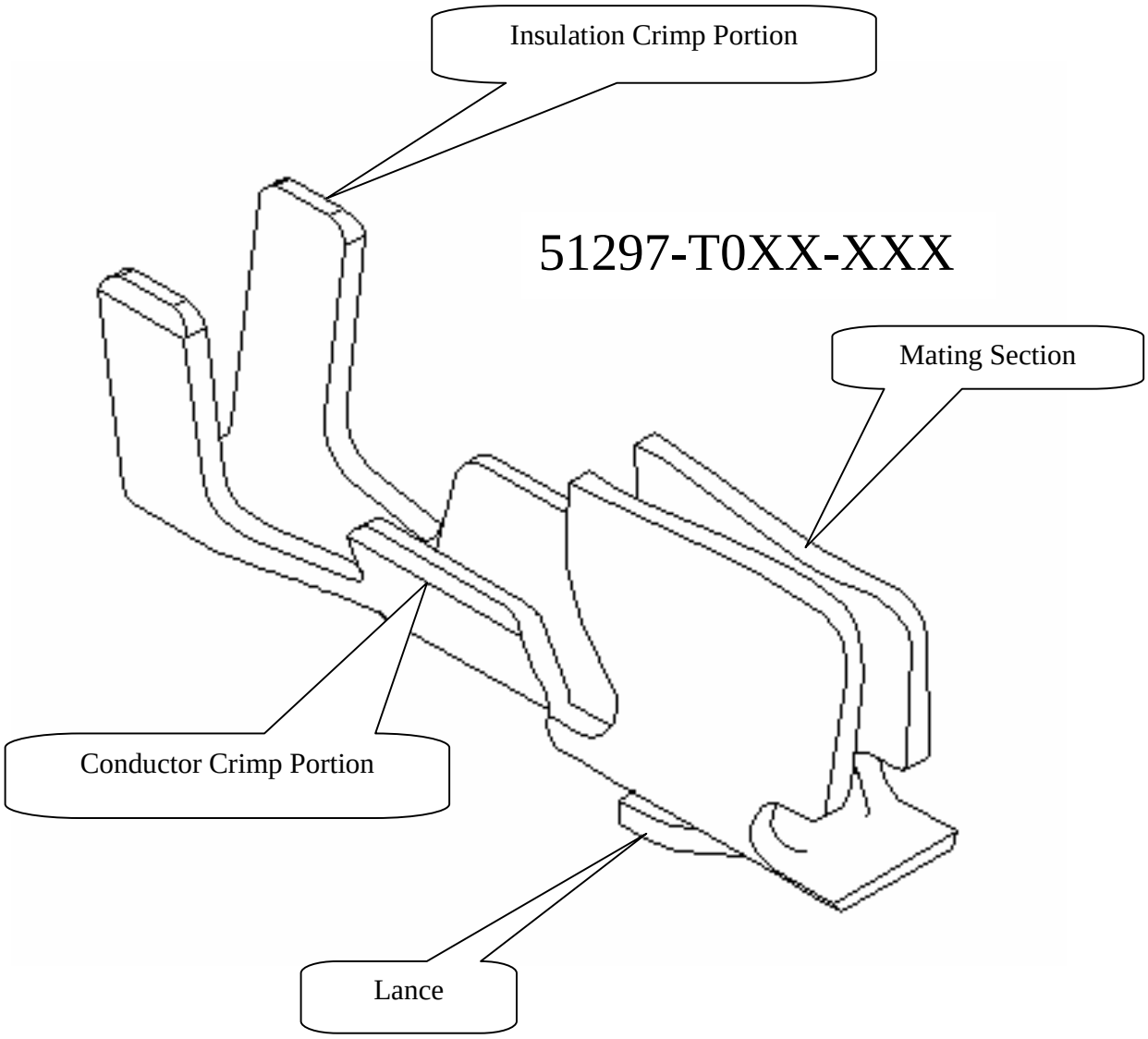
1 Revision History

Rev.	ECN #	Revision Description	Prepared	Date
O	ECN-1506164	NEW SPEC	XIUJIN	2015/5/20

2



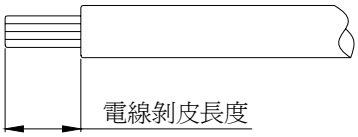
3 Applicable Wires： UL10064 wire

AWG Size： AWG＃34

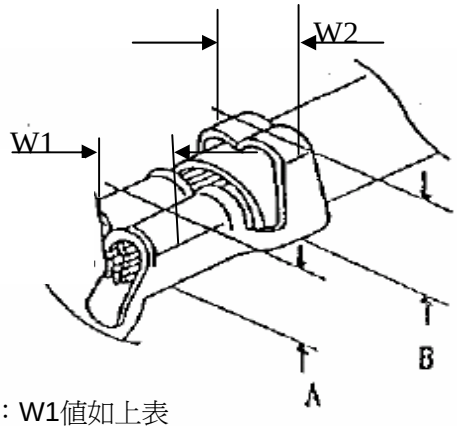
Insulation OD： Φ0.31mm

4 Crimping Condition：

鉚線條件表 CRIMPING CONDITION							
Part Number	Wire Specification			Crimp Height (mm)		Crimp Width (mm)	
	UL Style (REF.)	AWG Size	Insulation OD(mm)	Conductor A	Insulation B	Conductor W1	Insulation W2
51297-Txxx	UL10064	34	**0.3**1±0. 02	0.42~0.45	0.69~0.74	0.62~0.65	0.75~0.78



Strip length



Note:

1、W1爲芯線導體鉚壓後之寬度(Conductor Crimping Width)：W1值如上表

2、W2爲電線外被部分鉚壓後之寬度(Insulation Crimping Width)：W2值如上表

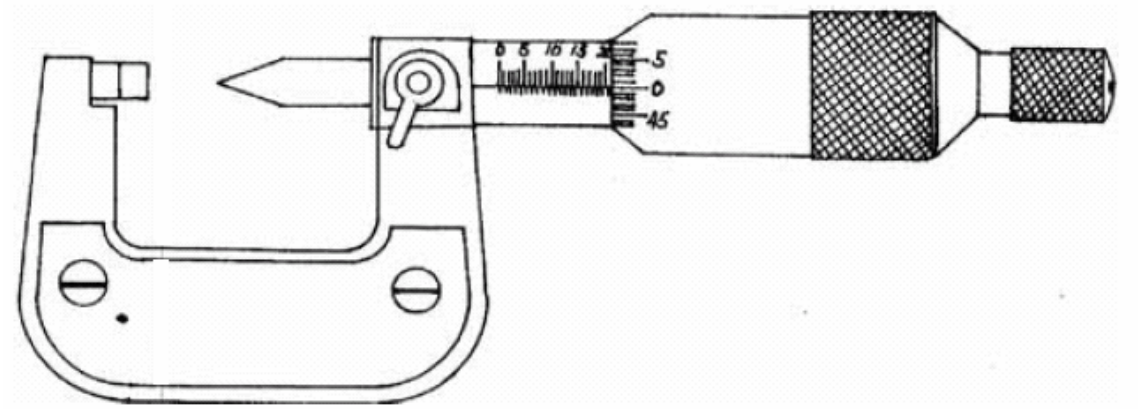
3、A爲芯線導體鉚壓後之高度(Conductor Crimping height)：A值如上表(參考值）

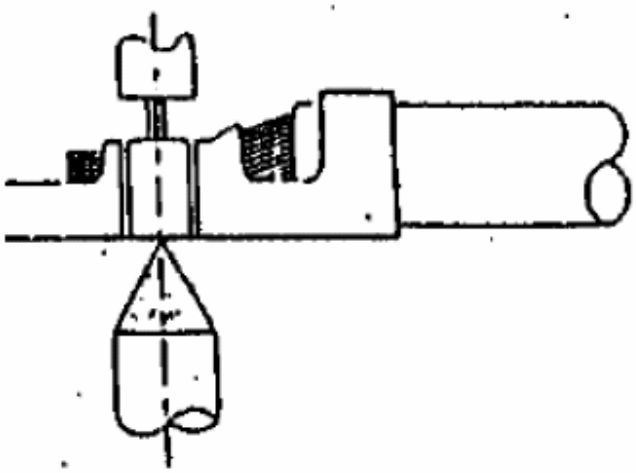
4、B爲電線外被鉚壓後之高度(Insulation Crimping height)：B值如上表(參考值）

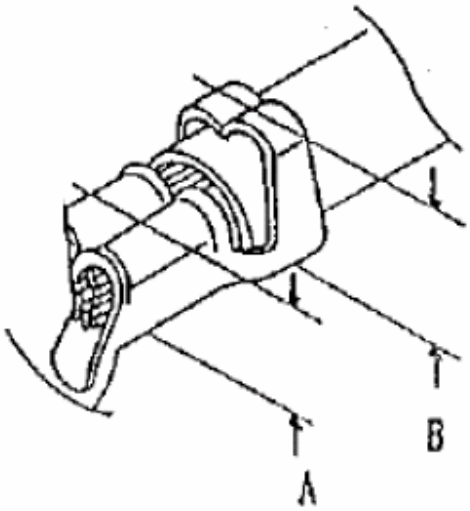
5、電線剝皮長度(Strip length)：1.5~1.9mm(參考值)

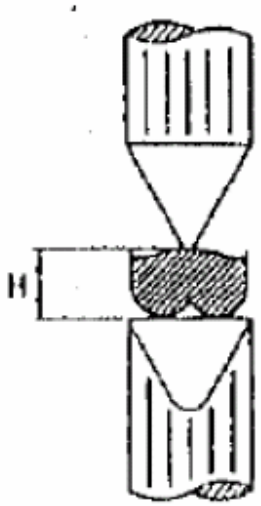
6、Crimping retention force：0.5Kgf MIN

5 Crimp Height Measurement：

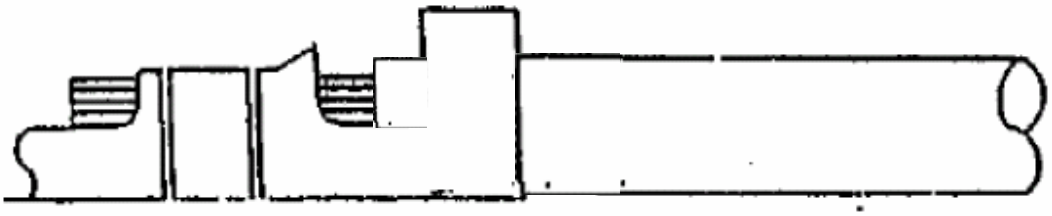




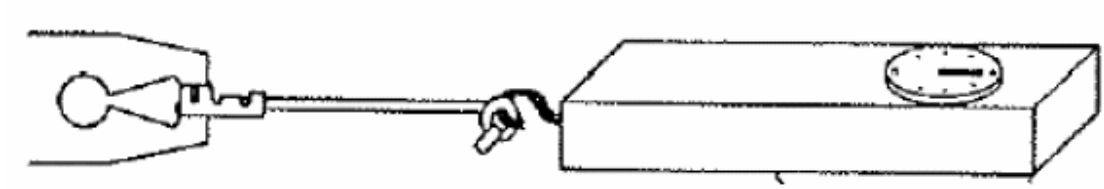




6 Pull Force of Crimp Section Measurement：

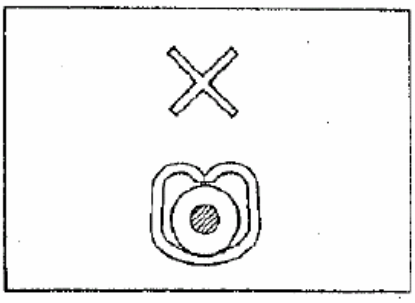


Before test, please make sure the crimp height/width meet the crimping condition

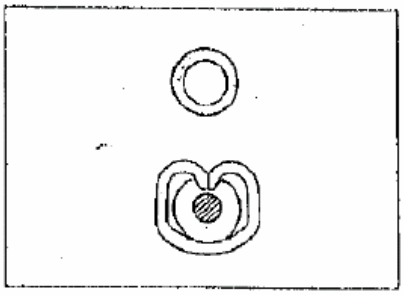


Pull Force of Crimp Section Measurement

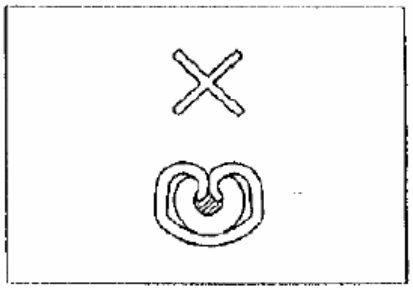
7 Standard Insulation Crimp：



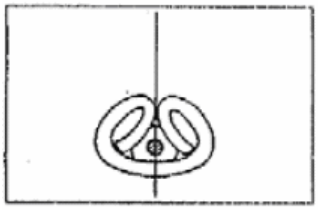
Not enough crimp



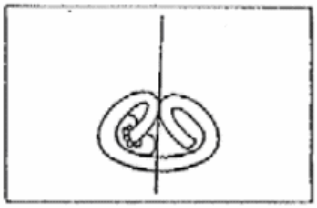
Good



Crimp too much



Good



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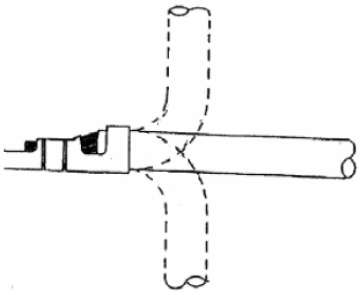
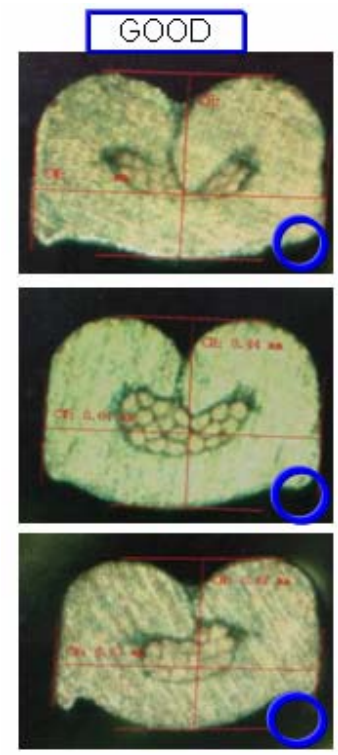
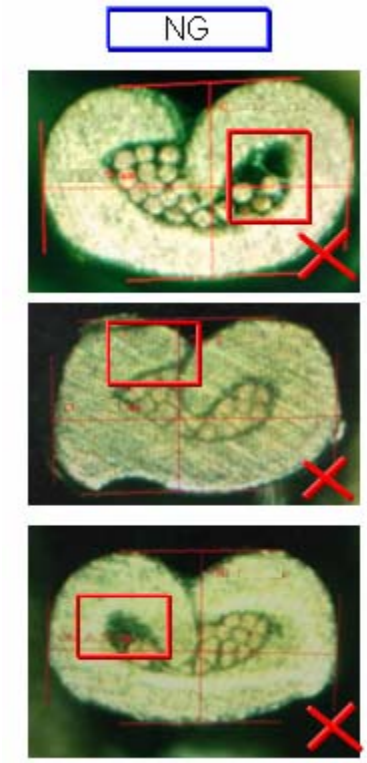
Insulation Crimp Condition

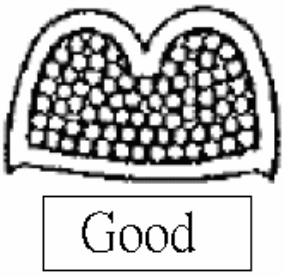


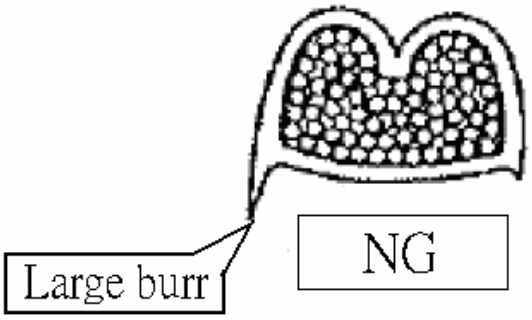
As following figure shown.
It is no problem if wire bent up down 90 degrees 1 cycle and insulation position still in ideal position.

8 Conductors Crimp Condition：

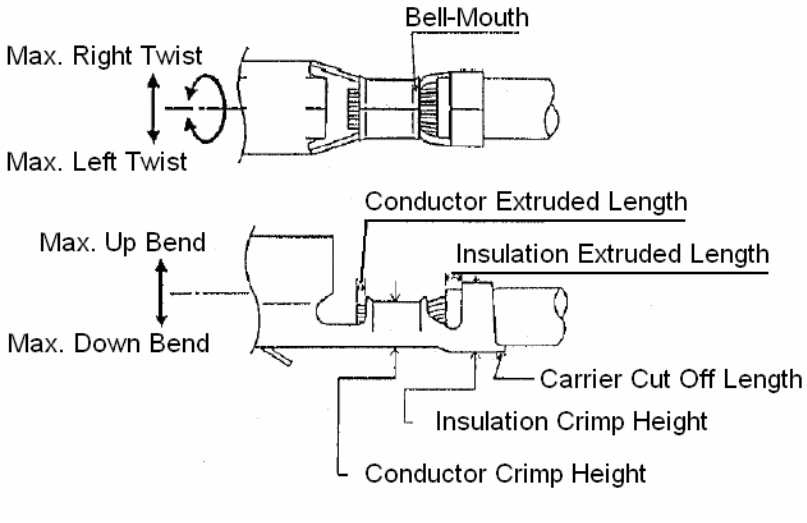








9 Crimping Requirements：



Item	Range (Ref.)
Max. Up Bend	6°
Max. Down Bend	6°
Max. Left Twist	5°
Max. Right Twist	5°
Bell-Mouth Length	0.24 mm
Carrier Cut Off Length	0.2mm MAX
Conductor Extruded Length	0.35 mm