

CRIMPING SPECIFICATION

PRODUCT NAME; .062 MINIATURE CRIMP PIN / RECEPTACLE.

1. SCOPE

THIS STANDARD SPECIFIES THE DIMENSIONS AFTER CRIMPING OF THE TERMINALS UNDERMENTIONED.

| PARTS NO. | WIRE SIZE | | INSULATION DIA. (mm) |
|-----------|-----------|-----------------|-------------------------|
| | AWG | mm ² | |
| 1560* | #18 ~ #24 | 0.20 ~ 0.75 | φ(1.5) ~ 3.1 |
| 1561* | #18 ~ #24 | 0.20 ~ 0.75 | φ(1.5) ~ 3.1 |

2. DEFINITION (TERMS)

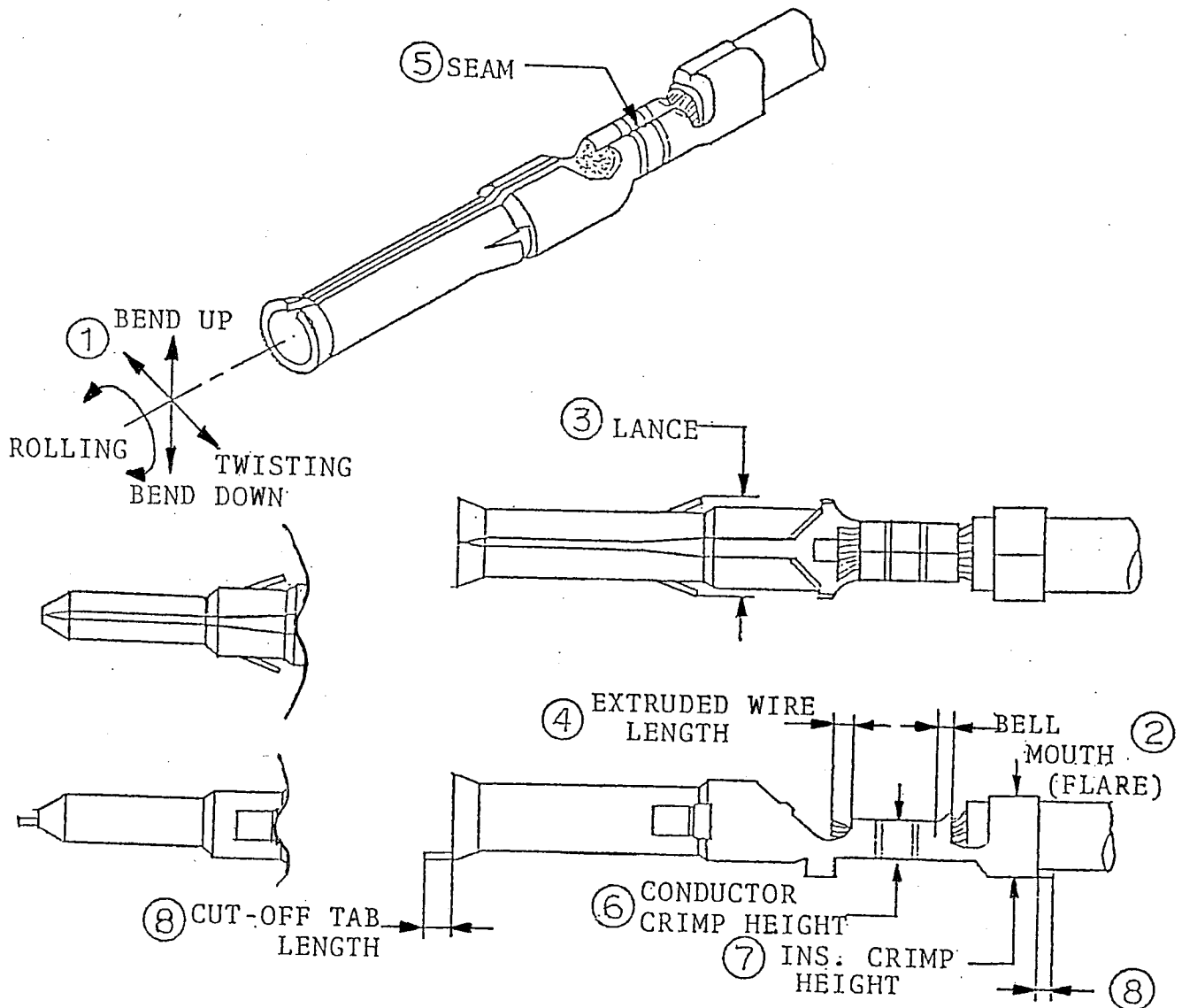


FIG 1

| | | | | | |
|------------------------------------|------------------|-----------|-----------|--------------------------------------|-------------------------------------|
| 作成 (PREPARED BY) A. Aso 10/1/87 | | | | MOLEX-JAPAN CO., LTD. 日本モレックス株式会社 | |
| REVISED | ECN NO. 4122 | 5/2/85 | H.H. | 確認 (CHECKED BY) A. Aso 11/9/89 | 名称 (NAME) Crimping Specification |
| REVISED | ECN NO. 1840 | 12/4/80 | K.H. | 承認 (APPROVED BY) K. H. Sano | 規格番号 (NO.) CS - 1560 / 1561 |
| RELEASE | | 11/7/89 | K.H. | | PAGE 1/3 |
| 記号 (LTR) | 変更内容 (REVISIONS) | 日付 (DATE) | 担当 (NAME) | | REV. D |

3. SPECIFICATION

| NO.OF FIG.1 | ITEM | REQUIREMENT |
|-------------|----------------------|------------------------------------------------------------------------|
| ① | BEND UP | 3° MAX. |
| | BEND DOWN | 3° MAX. |
| | TWISTING | 4° MAX. |
| | ROLLING | 8° MAX. |
| ② | BELL MOUTH (FLARE) | 0.2 ~ 0.5 mm (REF.) |
| ③ | LANCE | 3.01 ± 0.17 mm |
| ④ | EXTRUDED WIRE LENGTH | 0 ~ 1 mm |
| ⑤ | SEAM | Seam shall not be opened and no wire allowed out of crimping the area. |
| — # — | INS. CRIMP HEIGHT | 2.8 ~ 3.4 mm (REF.) |
| ⑧ | CUT-OFF TAB LENGTH | 0 ~ 0.5 mm |

4. CONDITIONS. (⑥ and ⑦ of FIG.1)

After crimping the wire(equivalent to UL1007),the crimped areas should be as follows.


| WIRE SIZE (AWG) | CRIMP DIE MODEL NO. | TERM.PART NO. | ⑥ CONDUCTOR(mm) | | ⑦ INSULATION(mm) | | CRIMP STRENGTH (kg) |
|-----------------------|------------------------|------------------|-----------------|-----------------|------------------|-----------------|---------------------------|
| | | | CRIMP WIDTH | CRIMP HEIGHT | CRIMP WIDTH | CRIMP HEIGHT | |
| #18 | CD(J) 1739 | 1560* 1561* | 1.91 | 1.01~1.06 | 2.75 | — # — | 9.0 MIN. |
| #20 | | | | 0.88~0.93 | | — # — | 6.0 MIN. |
| #22 | | | | 0.83~0.88 | | — # — | 4.0 MIN. |
| #24 | | | | 0.77~0.82 | | — # — | 3.0 MIN. |

5. CONDITIONS. (⑥ and ⑦ of FIG.1)

After crimping the wire(equivalent to UL1007),the crimped areas should be as follows.

| WIRE SIZE (AWG) | CRIMP DIE MODEL NO. | TERMINAL PART NO. | ⑥ CONDUCTOR(mm) | | ⑦ INSULATION(mm)(REF.) | | CRIMP STRENGTH (kg) |
|-----------------------|------------------------|----------------------|-----------------|-----------------|------------------------|-----------------|---------------------------|
| | | | TOOL MARK | CRIMP HEIGHT | TOOL MARK | CRIMP HEIGHT | |
| #18 | JM 5867A | 1560* 1561* | D | 1.01~1.06 | 6 | 2.2 | 9.0 MIN. |
| #20 | | | C | 0.88~0.93 | 6 | 2.1 | 6.0 MIN. |
| #22 | | | B | 0.83~0.88 | 6 | 2.0 | 4.0 MIN. |
| #24 | | | A | 0.77~0.82 | 6 | 2.0 | 3.0 MIN. |

In case of using Japanese Modular Crimp Die.

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|----------------------------------------------------------------------------------------------------------------------------|-------------|
|  MOLEX-JAPAN CO., LTD. 日本モレックス株式会社 | |
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