Crimping 070 Series, Tab Contact for Thin Wall Wires

1. Scope

This specification covers the requirements for crimping .070 Series, Tab Contacts for thin wall wires.

2. Applicable Contacts

175207 Tab Contact (S Type, Strip Form)

175208 Tab Contact (M Type, Strip Form)

175210 Tab Contact (L Type, Strip Form)

3. Nomenclature

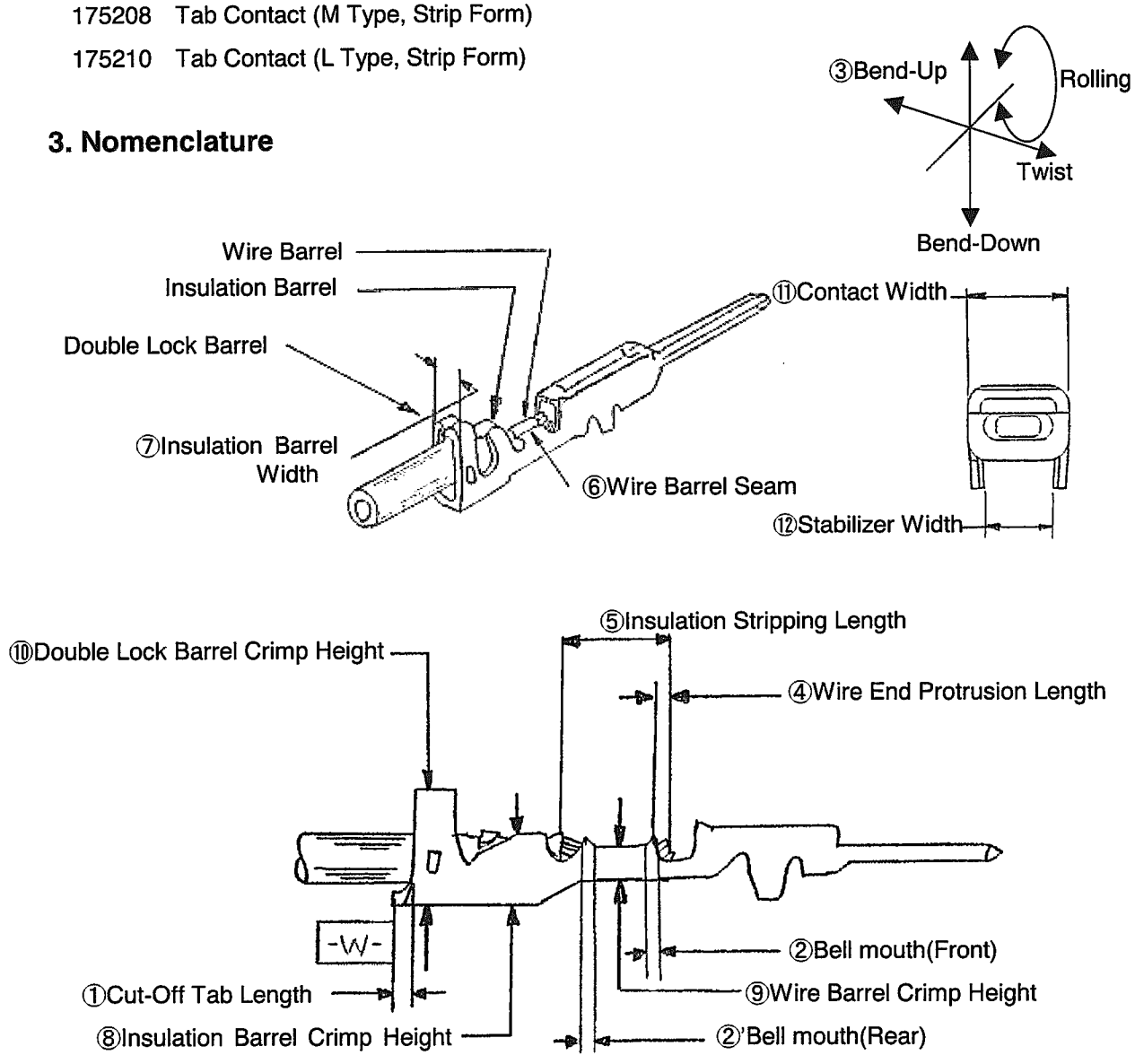

Fig.1

4. Crimping Requirements

No.	Check Items		Crimping Requirements	Remarks
1	Cut-off Tab Length		0.25 mm Max.	Fig.1-①
2	Bell mouth	Front	0.4 mm Max.	Fig.1-②
		Rear	0.15~0.8 mm	Fig.1-②'
3	Deformation After Crimping	Bending	±3° Max.	Fig.1-③
		Twisting	±3° Max.	
		Rolling	±5° Max.	
		Contact Width	2.5 ±0.1	Fig.1-⑪
		Stabilizer Width	1.7 $^{+0}_{-0.1}$	Fig.1-⑫
4	Wire End Protrusion Length		0~0.5 mm	Fig.1-④
5	Insulation Stripping Length	175207	2.5~3 mm	Fig.1-⑤
		175208 175210	2.8~3.3 mm	
6	Wire Barrel Seam		Conductors shall be not visible in the seam	Fig.1-⑥
7	Insulation Barrel Width (Within 2.8mm frontward from the Surface "W")	175207 175208	2.5~2.65 mm	Fig.1-⑦
		175210	3.4 ±0.1	

5. Crimp Data

Part number		175207	175208	175210
Applicator Part Number		915772-2	915515-2	
Barrel Crimp(mm)	Wire Barrel	1.78 "F"	2.29 "F"	2.29 "F"
	Insulation Barrel	2.03 "F"	2.6 "O"	2.78 "F"
	Double Lock Barrel	2.03 "F"	2.6 "F"	2.78 "F"

Part Number	Wire Size (Nominal)	Wire Barrel Crimp (mm)		Double Lock Barrel (mm)		Insulation Diameter (mm) A +0.1 -0	Insulation Barrel Crimp (mm)		Crimp Tensile Strength (N) (Min.)
		Height ⑨ ±0.05	Disk Ltr. (Ref.)	Height ⑩ ±0.1	Disk Ltr. (Ref.)		Height ⑧ ±0.15	Adjust Rod (Ref.)	
175207	0.3	1.09	B	3.8	3	1.1	1.8		78.4
						1.4	2.0		78.4
	0.5	1.17	A			1.3	1.9		88.2
175208	0.5	1.25	C	3.8	3	1.3	2.0	A	88.2
					4	1.6	2.1	B	
	0.85	1.37	B	3.8	4	1.5	2.1	A	117.6
					4	1.8	2.2	B	
	1.25	1.52	A	3.8	6	1.8	2.2	A	166.6
					5	2.1	2.3	B	
175210	1.25	1.56	B	5		1.8	2.98		166.6
						2.1	3.1		
						2.5	3.28		

6. Applicable Wire (Ref.)

Cable Type	Wire Size (Nominal)	No. of Conductors/ Diameter of Conductor (mm)	Calculated Cross-sectional Area (mm^2)	Finished Wire Diameter (mm)
CAVS	0.3	7 / 0.26	0.37	1.4
	0.5	7 / 0.32	0.56	1.6
	0.85	11 / 0.32	0.88	1.8
	1.25	16 / 0.32	1.29	2.1
AVSS	0.3	7 / 0.26	0.37	1.4
	0.5	7 / 0.32	0.56	1.6
	0.85	19 / 0.24	0.86	1.8
	1.25	19 / 0.29	1.26	2.1
CAVUS	0.3	7 / 0.26	0.37	1.1
	0.5	7 / 0.32	0.56	1.3
	0.85	11 / 0.32	0.88	1.5
	1.25	16 / 0.32	1.29	1.8