

Crimp specification

Type Document	Crimp Specification	Revised /Edition	A1
Date Issued:	2024/03/01	Data Revised:	2024/07/23
Subject: 2554T-HGW01-A 2.54mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Description:

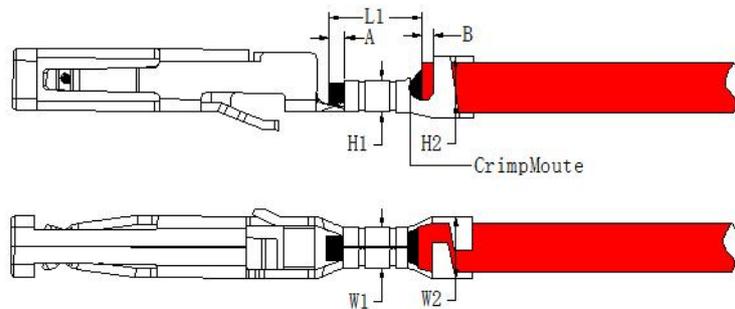
Height and width of conductor crimp core should be set as required.

(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.

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Date Issued:	2024/03/01	Data Revised:	2024/07/23
Subject: 2554T-HGW01-A 2.54mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Requirement:

Subject: FLRYW-A or equivalent type electric wire					
AWG#	Conductor (mm ²)	Insulation Diameter	Insulator skins length (Dim .B) mm	Copper wire leakage size (Dim .A) mm	Dim. L1 (mm) out
#22~#20	0.350mm ² ~0.50mm ²	1.60mm(max)	0.20mm~0.60mm	0.20mm~0.90mm	2.60mm~3.10mm
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
0.35mm ²	1.90±0.03mm	1.07±0.03mm	1.90±0.05mm	1.80±0.05mm	50.0N
0.50mm ²		1.10±0.03mm		1.95±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.

Signature: FX ENG

Dongguan SESO Technology Co.,Ltd

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Date	REV	DESCRIPTION	MODIFY	APPROVAL
2024/03/01	A	Initial Issued	FX	Jack Zhang
2024/07/23	A1	Modified spacing	FX	Jack Zhang

Crimp specification

Type Document	Crimp Specification	Revised /Edition	A1
Date Issued:	2023/05/16	Data Revised:	2023/07/23
Subject: 2554TH-HGW01-A 2.54mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Description:

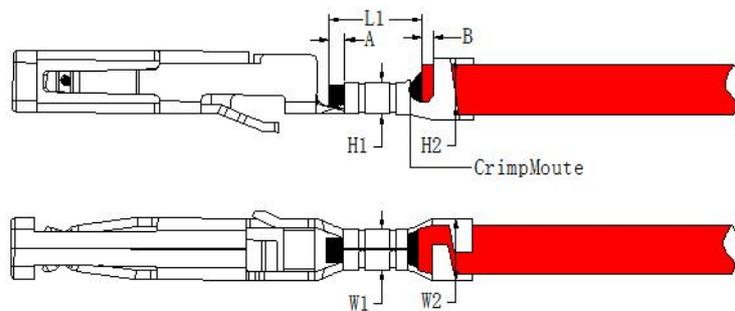
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(conductor crimp height and width of conductor barrel)

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1. Conductor crimp width. W1
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Crimp specification

Type Document	Crimp Specification	Revised /Edition	A1
Date Issued:	2023/05/16	Data Revised:	2023/07/23
Subject: 2554TH-HGW01-A 2.54mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Requirement:

Subject: AVSS or equivalent type electric wire					
AWG#	Conductor (mm ²)	Insulation Diameter	Insulator skins length (Dim .B) mm	Copper wire leakage size (Dim .A) mm	Dim. L1 (mm) out
#18	0.85mm ²	1.80mm(max)	0.20mm~0.60mm	0.20mm~0.90mm	2.60mm~3.10mm
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
0.85mm ²	1.97±0.03mm	1.36±0.03mm	2.03±0.05mm	2.10±0.05mm	100.0N

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Date	REV	DESCRIPTION	MODIFY	APPROVAL
2024/05/16	A	Initial Issued	FX	Jack Zhang
2024/07/23	A1	Modified spacing	FX	Jack Zhang

Crimp specification

Type Document	Crimp Specification	Revised /Edition	A2
Date Issued:	2023/05/16	Data Revised:	2024/07/23
Subject: 2554TL-HGW01-A 2.50mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Description:

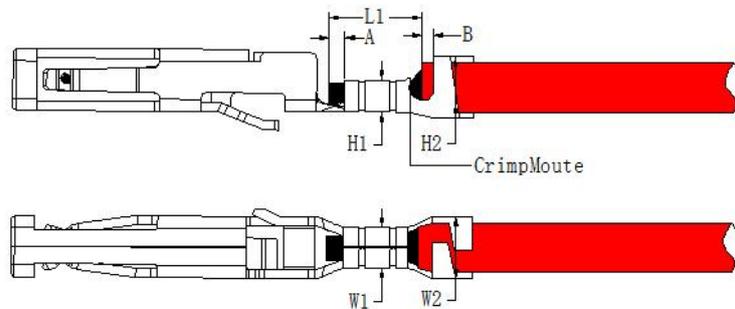
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(conductor crimp height and width of conductor barrel)

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(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.
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Crimp specification

Type Document	Crimp Specification	Revised /Edition	A2
Date Issued:	2023/05/16	Data Revised:	2024/07/23
Subject: 2554TL-HGW01-A 2.50mm Pitch Terminal crimp specification			Issued By: Engineering Dept.

Requirement:

Subject: FLRYW-A or UL1061 equivalent type electric wire					
AWG#	Conductor (mm ²)	Insulation Diameter	Insulator skins length (Dim .B) mm	Copper wire leakage size (Dim .A) mm	Dim. L1 (mm) out
#26~#24	0.13~0.22mm ²	1.30mm(max)	0.20mm~0.60mm	0.20mm~0.90mm	2.60mm~3.10mm
Wire Gauge (AWG#)	Conductor Crimp Area		Insulator Crimp Area		Terminal Tensile Strength
	Width (W1)	Height(H1)	Width (W2)	Height(H2)	
#26	1.45±0.03mm	0.91±0.03mm	1.50±0.05mm	1.40±0.05mm	13.7N
0.22mm ²	1.50±0.03mm	0.98±0.03mm		1.45±0.05mm	40.0N

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Date	REV	DESCRIPTION	MODIFY	APPROVAL
2023/05/16	A	Initial Issued	FX	Jack Zhang
2024/06/18	A1	Change the cross-sectional area of 26AWG	FX	Jack Zhang
2024/07/23	A2	Modified spacing	FX	Jack Zhang