The performance of applicable product is guaranteed only when processed by proper application tooling and condition described in this specification and/or TE recognized ones. No product is guaranteed when processed with the other tool or condition.

## 1. Scope

This specification covers the requirements for crimping of .025 Receptacle Contact.

## 2. Applicable Contacts

| TE Part Numbers | | Finish | Applicable Wires |
|---|---|---|---|
| Strip Form | Loose Piece | | |
| 1123343-1 | 1318143-1 | Pre-Tin | AVSS/AVSSH/AESSX 0.3-0.5<br>CAVUS/ CAVS 0.22-0.5<br>TWP 0.35-0.5 |
| 1123343-2 | 1318143-2 | Selective Gold | |

## 3. Nomenclature

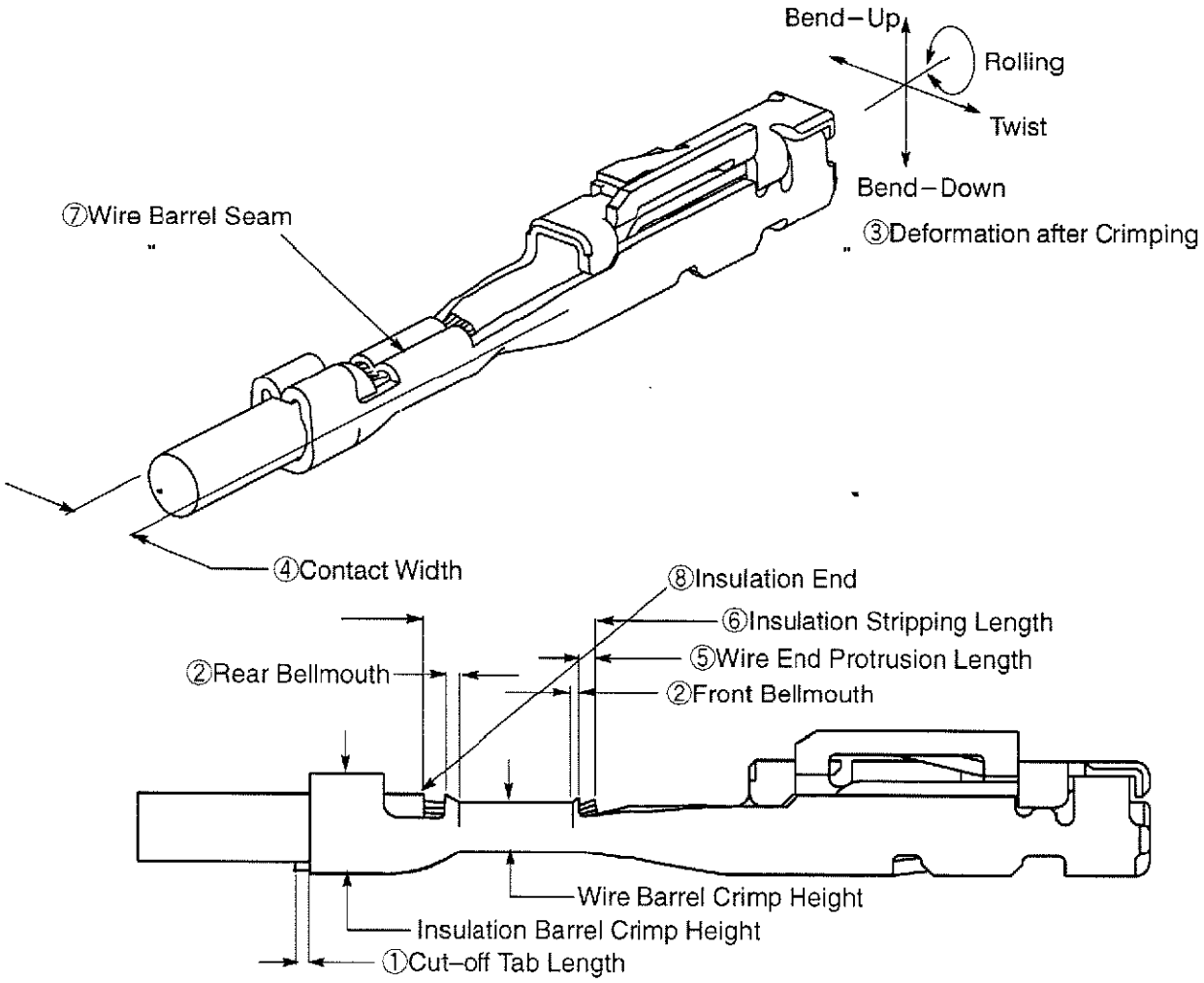



**Fig.1**



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*：商標 Trademark

## 4. Crimping Condition

### 4.1 Applicator Crimp

| Check Items | | | AVSS/AVSSH/AESSX 0.3<br>CAVUS 0.22-0.5<br>CAVS 0.22-0.3<br>TWP 0.35 | AVSS/CAVS/AVSSH/<br>AESSX 0.5<br>TWP 0.5 | Remarks |
|---|---|---|---|---|---|
| 1 | Cut-off Tab Length | | 0.1-0.5mm | | Fig.1-① |
| 2 | Bellmouth | Front | 0.2mm Max. | | Fig.1-② |
| | | Rear | 0.1-0.4mm | | |
| 3 | Deformation after Crimping | Bend | -1° , + 2°Max. | | Fig.1-③ |
| | | Twist | ±4°Max. | | |
| | | Rolling | ±10°Max. | | |
| 4 | Contact Width after Crimping | | 1.6mm Max. | 1.8mm Max. | Fig.1-④ |
| 5 | Wire End Protrusion Length | | 0-1mm | | Fig.1-⑤ |
| 6 | Insulation Stripping Length | | 3.0-3.5mm ( Before Crimping ) | | Fig.1-⑥ |
| 7 | Wire Barrel Seam | | Seam must be closed<br>(No strand looses out of the seam) | | Fig.1-⑦ |
| 8 | Insulation End | | Insulation End must be between Wire Barrel and Insulation Barrel | | Fig.1-⑧ |

### 4.2 Hand Tool Crimp

| Check Item | | | AVSS/CAVS 0.3<br>AVSSH/AESSX 0.3<br>CAVUS 0.3-0.5 | AVSS/CAVS/<br>AVSSH/AESSX 0.5 | Remarks |
|---|---|---|---|---|---|
| 1 | Cut-off Tab Length | | 0.1-0.5mm | | Fig.1-① |
| 2 | Bellmouth | Front | 0.2mm Max. | | Fig.1-② |
| | | Rear | 0.1-0.4mm | | |
| 3 | Deformation after Crimping | Bend | ±4°Max. | | Fig.1-③ |
| | | Twist | ±4°Max. | | |
| | | Rolling | ±10°Max. | | |
| 4 | Contact Width after Crimping(1) | | 1.6mm Max. | 1.8mm Max. | Fig.1-④ |
| 5 | Wire End Protrusion Length | | 0-1mm | | Fig.1-⑤ |
| 6 | Insulation Stripping Length | | 3.0-3.5mm ( Before Crimping ) | | Fig.1-⑥ |
| 7 | Wire Barrel Seam | | Seam must be closed<br>(No strand looses out of the seam) | | Fig.1-⑦ |
| 8 | Insulation End | | Insulation End must be between Wire Barrel and Insulation Barrel | | Fig.1-⑧ |

**NOTE** (1); Dimensions after crimping vary by skill of operators.
Make sure that flashes on the bottom of wire barrel are 0.25 mm max, and the contacts can be inserted into housing smoothly.

## 5. Crimp Data

### 5.1 Applicator Crimp

| Contact Part Number (Strip Form) | Wire Size (Nominal) | Applicator Part Number | Wire Barrel Crimp | | | Insulation Barrel Crimp | | | Crimp Tensile Strength (N) |
|---|---|---|---|---|---|---|---|---|---|
| | | | Width(2) (mm) | Height(1) (mm) | Disk Ltr. | Width(2) (mm) | Height (mm) | Disk Ltr. | |
| 1123343-1<br>1123343-2 | 0.22 | 937767-2 | 1.4<br>" F " | 0.84 | C | 1.4<br>" F " | See Para. 6 | | 39 Min. (3) |
| | 0.3<br>0.3f | | | 0.96 | B | | | | 70 Min. (3) |
| | 0.5<br>0.5f | | | 1.06 | A | | | | 90 Min. |
| | TWP<br>0.35 | | | 0.76 | C | | | | 70 Min. (3) |
| | TWP<br>0.5 | | | 0.91 | B | | | | 90 Min. |

**NOTE**
(1); Wire Barrel Crimp Height to be within ±0.05mm.
(2); Crimp Width dimensions are not the product width after crimping, but given by the width of crimper slot for reference.
(3); Crimp Tensile Strength of 0.22-0.35 wire includes the wire grip of insulation barrel

### 5.2 Hand Tool Crimp

| Contact Part Number (Loose Piece) | Wire Size (Nominal) | Hand Tool Part Number | Insulation Diameter (mm) | Crimp Symbol | | Wire Barrel (1) Crimp Height (mm) | Crimp Tensile Strength (N) |
|---|---|---|---|---|---|---|---|
| | | | | Wire | Insulation | | |
| 1318143-1<br>1318143-2 | 0.3<br>0.3f | 1276652-1<br>1463260-1(3) | 1.1-1.7 | 20-22 | INS | 0.84-1.00 | 50 Min. (2) |
| | 0.5<br>0.5f | | | | | | 63 Min. |

**NOTE**
(1); This tool is for maintenance. The different dimension may be caused according to the ability of operator. Except for the purpose above, you should use the applicator.
(2); Crimp Tensile Strength of 0.3 wire includes the wire grip of insulation barrel crimp.
(3); Common hand tool for receptacle and tab.

## 6. Insulation Barrel Crimp Data

| Contact Part Number (Strip Form) | Wire Size (Nominal) | AVSSH/AVSS | | CAVUS | | CAVS | | AESSX | | TWP | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | | Height (mm) | Disk Ltr. (Ref.) | Height (mm) | Disk Ltr. (Ref.) | Height (mm) | Disk Ltr. (Ref.) | Height (mm) | Disk Ltr. (Ref.) | Height (mm) | Disk Ltr. (Ref.) |
| 1123343-1<br>1123343-2 | 0.22 | - | - | 1.63(1) | 4 | - | | 1.75(1) | 3 | - | - |
| | 0.3<br>0.3f | 1.85(1) | 4 | 1.75(1) | 5 | 1.85(1) | 4 | 1.85(1) | 4 | - | - |
| | 0.35 | - | - | - | - | - | - | - | - | 1.87(1) | 4 |
| | 0.5<br>0.5f | 1.85(2) | 4 | 1.85(2) | 4 | 1.85(2) | 4 | 1.85(2) | 4 | 2.00(2) | 3 |

**NOTE**
(1); Insulation Barrel Crimp Height to be within ±0.1mm.
(2); Insulation Barrel Crimp Height to be within +0.13/-0.10 mm.

**7. Applicable Wire Data**

| Wire Size (Nominal) | Number /Diameter (mm) of Conductor | Calculated Cross sectional Area ($mm^2$) | Insulation Diameter (mm) | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | AVSSH /AVSS | | CAVUS | | CAVS | | AESSX | | TWP | |
| | | | STD. | Max. | STD. | Max. | STD. | Max. | STD. | Max. | STD. | Max. |
| 0.22 | 7/Compressed | 0.2199 | - | - | 0.95 | 1.05 | 1.25 | 1.35 | - | - | - | - |
| 0.3 | 7/0.26 | 0.3716 | 1.4 | 1.5 | 1.1 | 1.2 | 1.4 | 1.5 | - | - | - | - |
| 0.3f | 19/0.16 | 0.3821 | 1.4 | 1.5 | - | - | 1.4 | 1.5 | 1.4 | 1.5 | - | - |
| 0.35 | 7/0.26 | 0.3716 | - | - | - | - | - | - | - | - | 1.55 | 1.63 |
| 0.5 | 7/0.32 | 0.5629 | 1.6 | 1.7 | 1.3 | 1.4 | 1.6 | 1.7 | - | - | - | - |
| | 7/0.31 | 0.5283 | - | - | - | - | - | - | - | - | 1.72 | 1.80 |
| 0.5f | 19/0.19 | 0.5387 | - | - | - | - | - | - | 1.6 | 1.7 | - | - |