

Econoseal J Series Connectors

1. Scope :

This specification covers the requirements for crimping Econoseal J Series Connectors
<Mark II(+)> .070 Series Contact

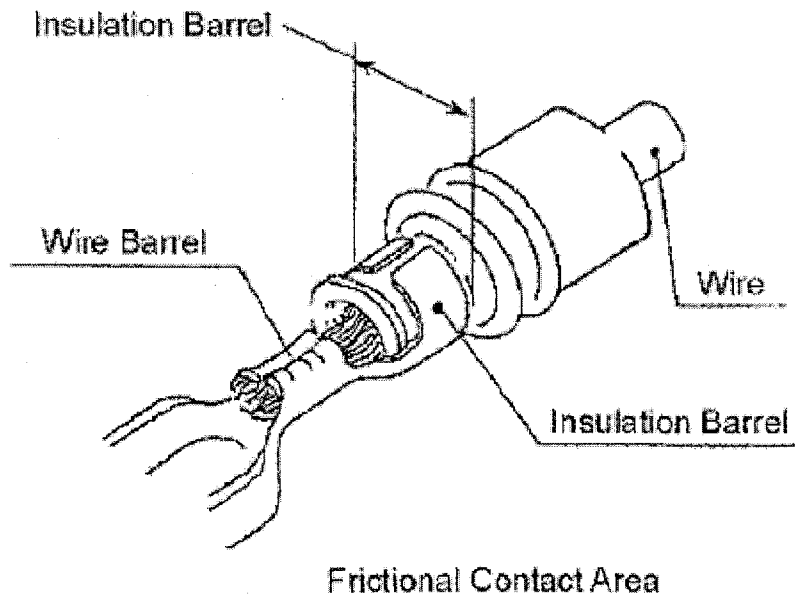
2. Application Contacts

Para	Contact Part Nos.	Wire Sizes mm2 (AWG)
.070 Series Tab	1897641	(AWG#20 ~ AWG #18) 0.5 ~ 0.75

3. Application Rubber Plug

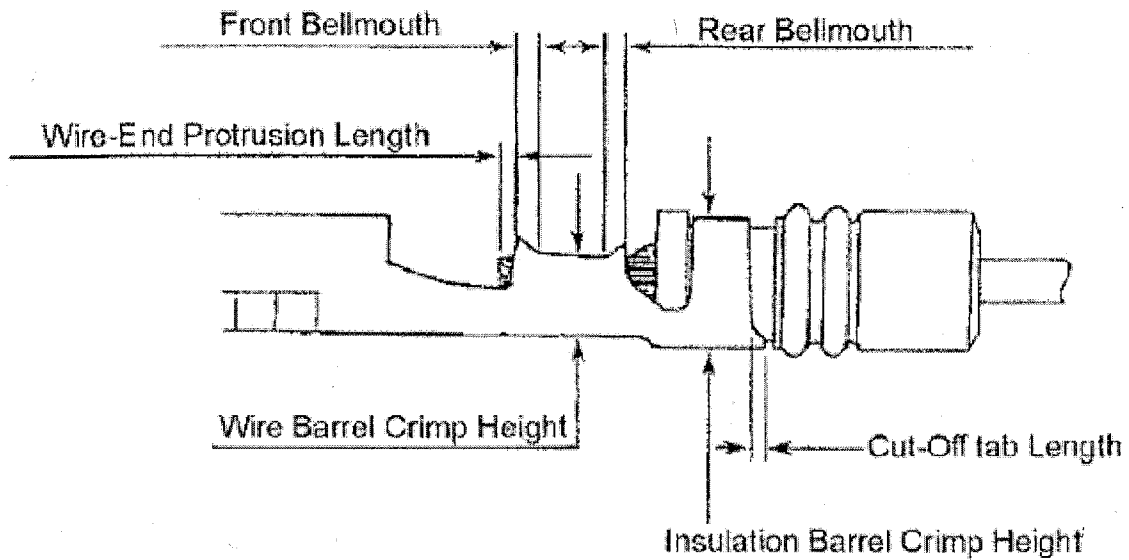
Para	Contact Part Nos.	Insulation Dia (mm)
.070 Rubber Plug	172746	Ø 1.4 ~ 1.9

4. Nomenclature and Crimping Features :





Cut-Off tab Length



5. Crimping conditions and Crimp Data :

5.1 Crimping Conditions :

Tab (Conatac Part Nos.) 1897641

No.	Checking items		Requirements
1.	Allowable Deviation after Crimping	Bend-up	1° Max.
		Bend-down	3° Max.
		Twisting	5° Max.
		Rolling	5° Max.
2.	Cut-off Tab length		0.5mm Max
3.	Bellmouth	Front	0.3mm Max
		Rear	0.2 ~ 0.9mm Max.
4.	Wire-End Protrusion Length		Wire-end must protrude Beyond the front edge of Wire varrel, but shall not Exceed 1.5mm.
5.	Insulation Stripping length	One-wire Crimp	4 ~ 4.5mm

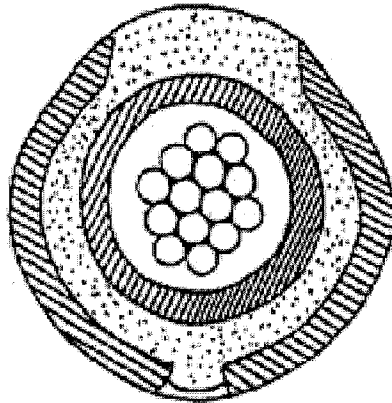
5.2 Crimp Data :

Application Crimp :

Contact Part No.	Wire Size	Applicator Number	Wire Barrel Crimp			Insulation Barrel Crimp		Crimp Tensile Strength (N min)
			Width	Height	Disc Letter	Width	Disc Letter	
1897641	PTFE 0.5	1528872-1	1.78"F"	1.18	C7	3.4"O"	6	75

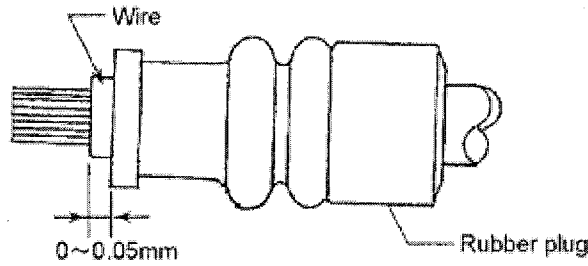
Note : Wire barrel tolerance to be within ± 0.05

Insulation Barrel Crimp's shape should be the following figure.



6. Rubber Plug Insulation




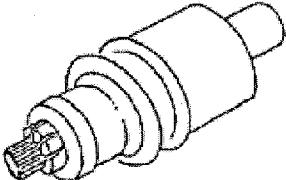
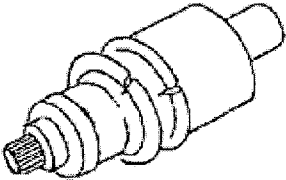

The length of the wire insulation protruding beyond the end of the rubber plug, assembled to the wire, shall be within 0.5mm for all the .070 series receptacles and tabs. (Refer to the following illustration.)



7. Notes

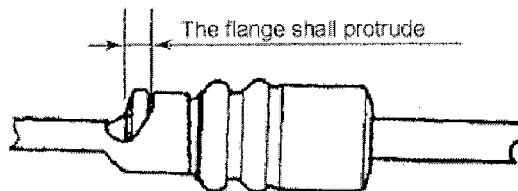
Wires and rubber plugs as illustrated below shall be reworked or replaced because they are detrimental to the required performance.

(Before Crimping)

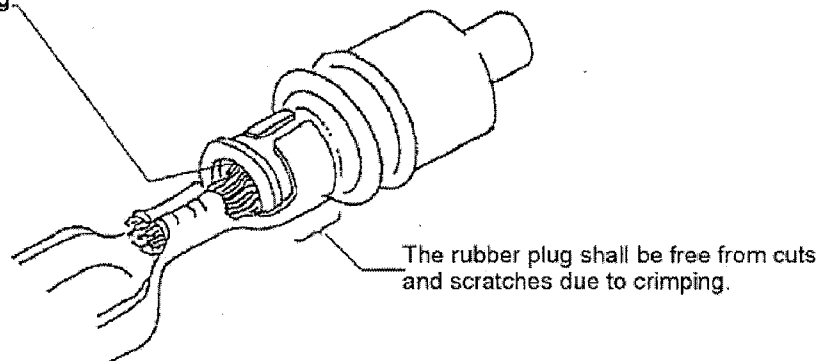
 <p>The strands shall not be frayed.</p>	 <p>The strands shall be free from nick and breakage.</p>	 <p>The insulation shall be round without scratches and dents.</p>
 <p>The strand shall not be frayed.</p>	 <p>The rubber plug shall be free from scratches.</p>	 <p>The rubber plug shall not be crooked.</p>

(After Crimping)

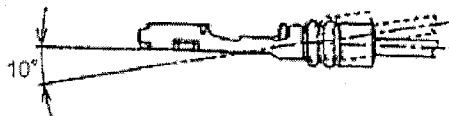
(1) The wire barrel shall not cut into the rubber plug.



(2) The wire insulation shall remain as crimped or shall be capable of being checked by turning up the end of the rubber plug.



The rubber plug shall not be crooked more than 10°



8. Applicable Wires

Nominal Size (PTFE)	Number of Strands / Diameter of strand (mm ²)	Calculated Cross Section Area (mm ²)	Overall Outside Diameter (Standard) (mm)
0.5	19 / 0.203	0.61	1.7 ± 0.07
0.75	19 / 0.254	0.96	2.05 ± 0.1

9. REVISION HISTORY

Current Revision	New Revision	Changes	Reason for Change	EC No.
-	A	-	RELEASED	

10. SPECIFICATION APPROVAL

Prepared by,

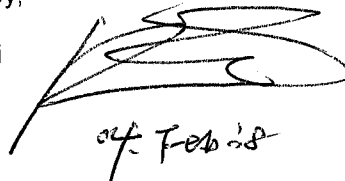
B. S. Yoo



Product Engineer

Checked By,

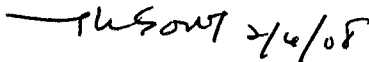
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Senior Product Engineer

Approved by,

J. K. Song



Product Engineering Manager