

ECONOSEAL Tab Contact

1. SCOPE

This specification covers the requirements for application of TERMINAL 1.8 ECONOSEAL “J” SRS. MARK II+ TAB (PNs 881593-1 / 881593-2), for wire and insulation ranges requirements. These requirements are applicable to TE contacts when crimped with TE crimping tools and machines.

1. NOMENCLATURE

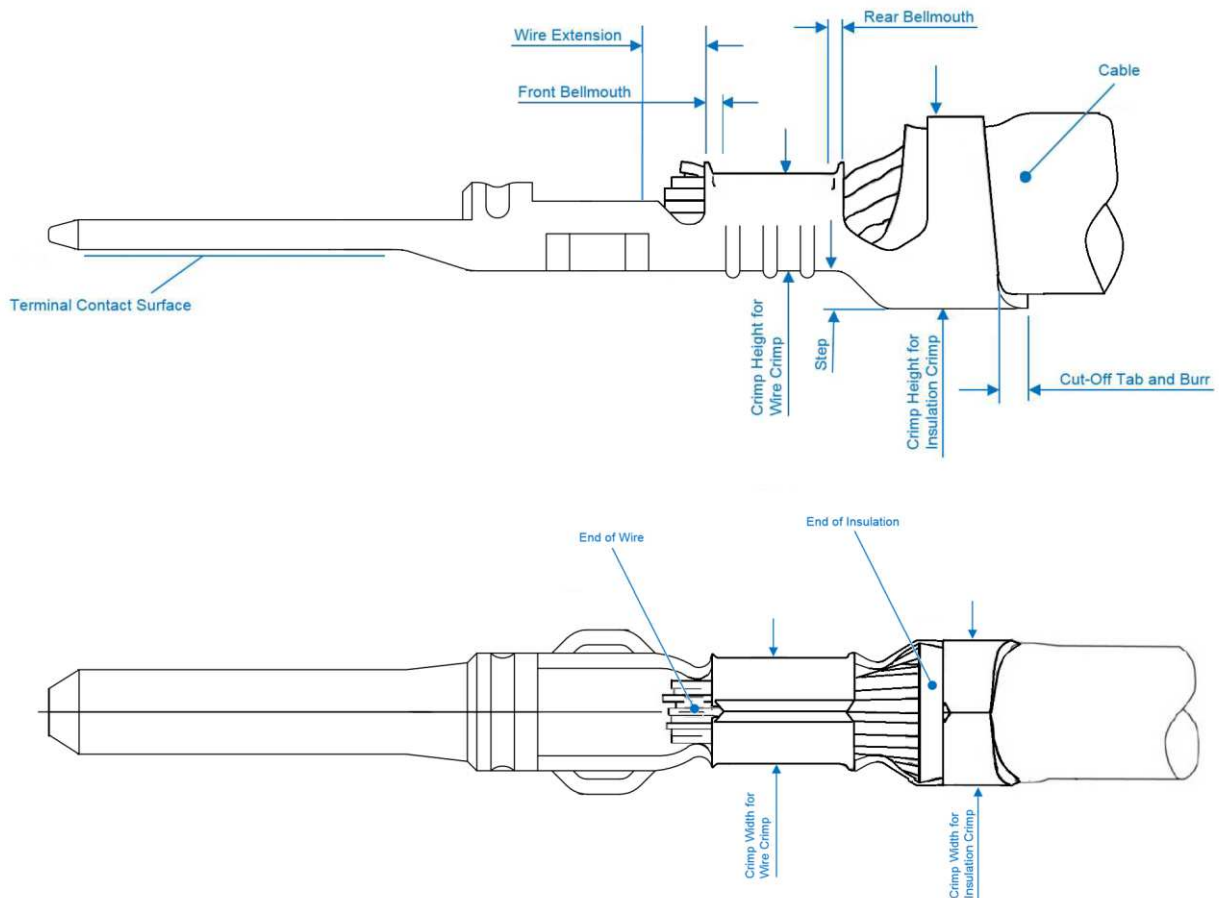


Fig.1

2. APPLICABLE DOCUMENTS

- Applicator log PN 2151828.
- Application Specification: 114-5082.

3. CRIMP AND DIMENSIONAL REQUIREMENTS

3.1 Wire preparation

A. Strip length

Insulation shall be stripped as indicated in fig. 5.

B. Workmanship

Reasonable care shall be taken not to nick, scrape or cut any strands during the stripping operation.

3.2 Carrier cut off TAB and burr

A. Cut of TAB

Cut Off TAB shall not exceed 0.3mm MAX.

B. Burr

Burr on cut off shall not exceed 0.15mm MAX.

3.3 Wire barrel crimp

A. Crimp dimensions and type

Crimp height, width and type shall be as shown in fig. 5.

B. Wire barrel flash

Wire barrel flash shall not exceed 0.15mm MAX.

C. Wire barrel seam

Wire barrel seam shall be completely closed and there shall be no evidence of loose wire strands or wire strands visible in the seam.

D. Bellmouth

(1) Rear bellmouth length shall be 0.4mm x 45°.

(2) Front bellmouth length shall be 0.15mm x 45°.

E. Conductor location

(1) End of the wire shall be flush with the front end of the wire barrel or extend 0.8mm MAX after crimping.

(2) Both insulation and conductor shall be visible between the insulation barrel and wire barrel.

Care shall be taken not allow insulation to be crimped in the wire barrel.

3.4 Insulation barrel crimp

A. Crimp dimensions and type

Crimp height, width and type shall be as shown on table 1 (item 4 / Crimping Information).

B. Workmanship

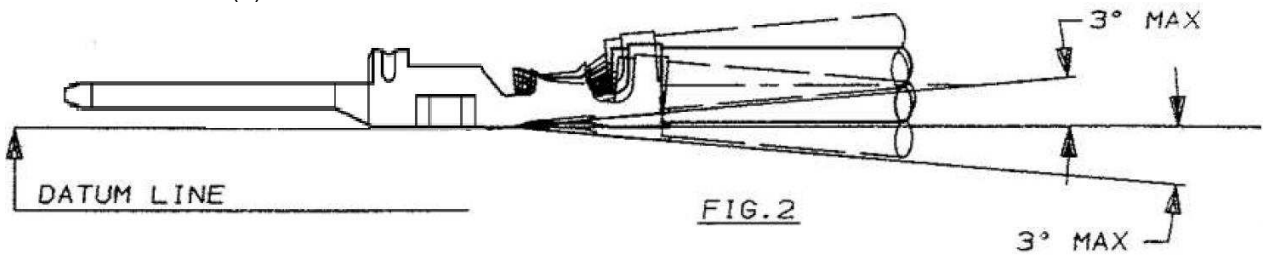
Reasonable care shall be taken not to cut or break the insulation during the crimping operation.

3.5 Alignment

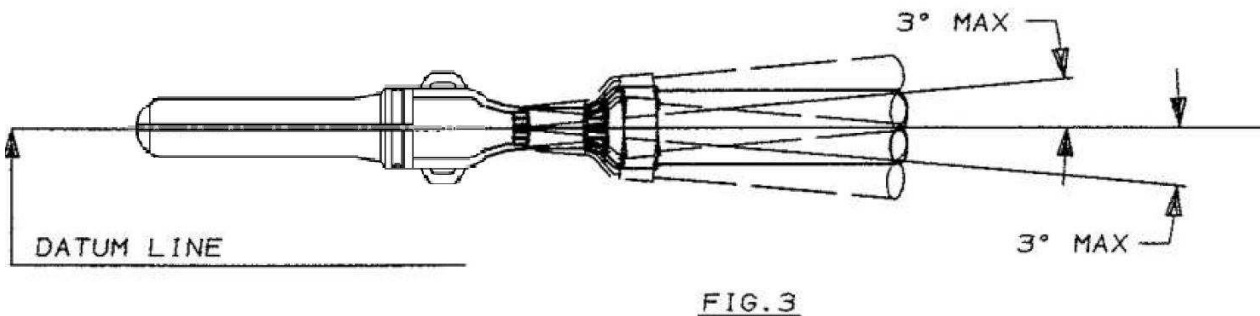
A. Straightness

(1) The contact, including the cut off TAB and burr, after crimping shall not be bent above or below the datum line more than the amount shown in fig. 2.

(2)

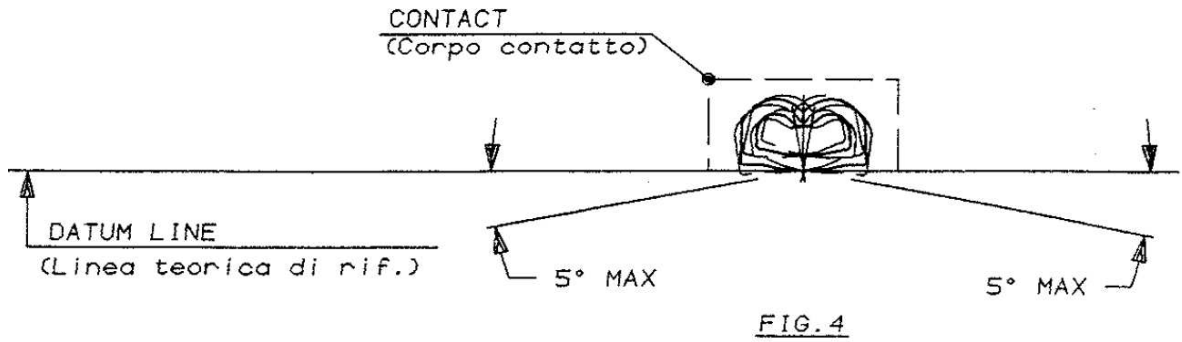


(3) The side to side bending of the contact, after crimping, shall not exceed the limits specified in fig. 3.



B. Twist or roll

Twist or roll of the crimped contact shall not exceed the limits specified in fig. 4.



4. CRIMPING INFORMATION

TABLE 1

WIRE SIZE	Ø INSULATION	STRIP LENGTH	WIRE BARREL			INSULATION BARREL	
			WCH	WCW	TYPE	ICW ±0.10	TYPE
0.50 mm ²	1.40~1.60 mm	3.90 ±0.30mm	1.27±0.05 mm	1.78 mm	F	3.30 mm	O
0.75 mm ²	1.70~1.90 mm		1.37±0.05 mm				
1.00 mm ²	2.00~2.40 mm		1.47±0.05 mm				

Histórico de Revisões					
Rev.	Data	Descrição	Editado	Checado	Aprovado
A	12-Sep-2018	Initial release	Mello.J	Cavallaro.A	Cavallaro.A