

Econoseal J Series Connectors

1.Scope:

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

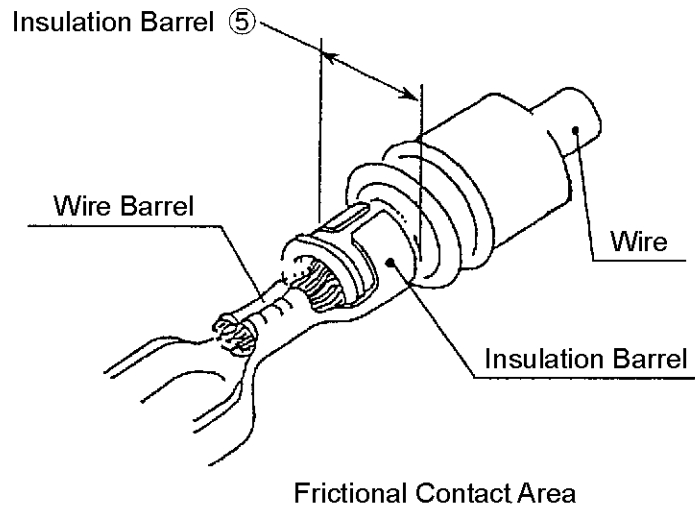
2.Application Contacts

Para.	Contact Part Nos.	Wire Sizes mm ² (AWG)
.070 Series Receptacle	171630	(AWG#24~#20) 0.2~0.5
	171662	(AWG#20~#16) 0.5~1.29
.070 Series Tab	171631	(AWG#24~#20) 0.2~0.5
	171661	(AWG#20~#16) 0.5~1.29

3. Application Rubber Plug

Para.	Part Nos.	Insulation Dia (mm)
.070 RUBBER PLUG (S)	900324	Φ 1.4~ Φ 1.9
.070 RUBBER PLUG (M)	900325	Φ 2.0~ Φ 2.3

4. Nomenclature and Crimping Features:



Cut-Off tab Length

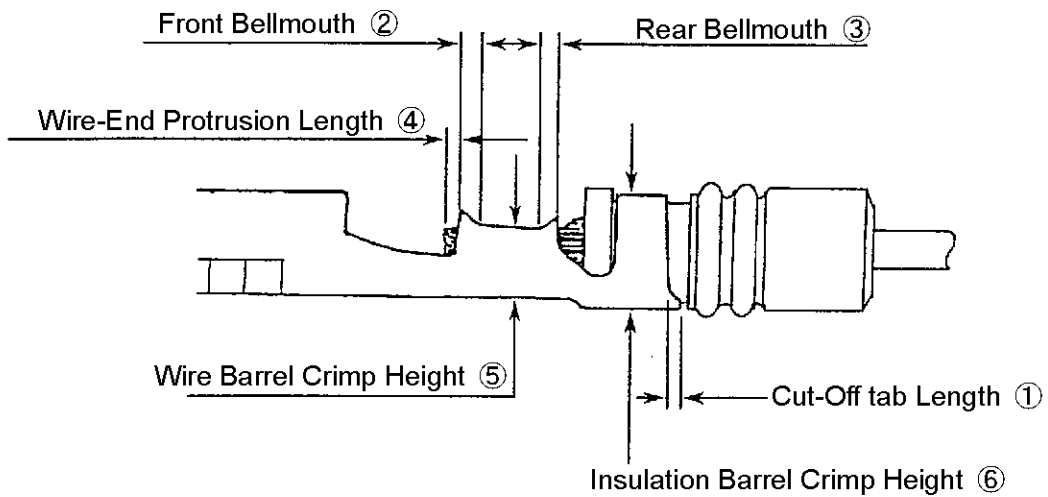


Fig 1

5. Crimping conditions and Crimp Data:

5.1 Crimping Conditions:

Rec (Contact Part Nos.) 171662,171630

No.	Checking Items		Requirements	Remarks
1.	Allowable Deviation after Crimping	Bend-up	3° Max.	Fig.2①
		Bend-up	3° Max.	Fig.2②
		Twisting	5° Max.	Fig.2③
		Rolling	5° Max.	Fig.2④
2.	Cut-Off Tab Length		0.5mm Max.	Fig.1①
3.	Bellmouth	Front	0.5mm Max.	Fig.1②
		Rear	0.2~0.9mm Max.	Fig.1③
4.	Wire-End Protrusion Length		Wire-end must protrude beyond the front edge of wire barrel, but shall not exceed 1.5mm.	Fig.1④
5.	Insulation Stripping Length	One-wire Crimp	4~4.5mm	

Tab (Contact Part Nos.) 171661,171631

No.	Checking Items		Requirements	Remarks
1.	Allowable Deviation after Crimping	Bend-up	1° Max.	Fig.2①
		Bend-up	3° Max.	Fig.2②
		Twisting	5° Max.	Fig.2③
		Rolling	5° Max.	Fig.2④
2.	Cut-Off Tab Length		0.5mm Max.	Fig.1①
3.	Bellmouth	Front	0.3mm Max.	Fig.1②
		Rear	0.2~0.9mm Max.	Fig.1③
4.	Wire-End Protrusion Length		Wire-end must protrude beyond the front edge of wire barrel, but shall not exceed 1.5mm.	Fig.1④
5.	Insulation Stripping Length	One-wire Crimp	4~4.5mm	

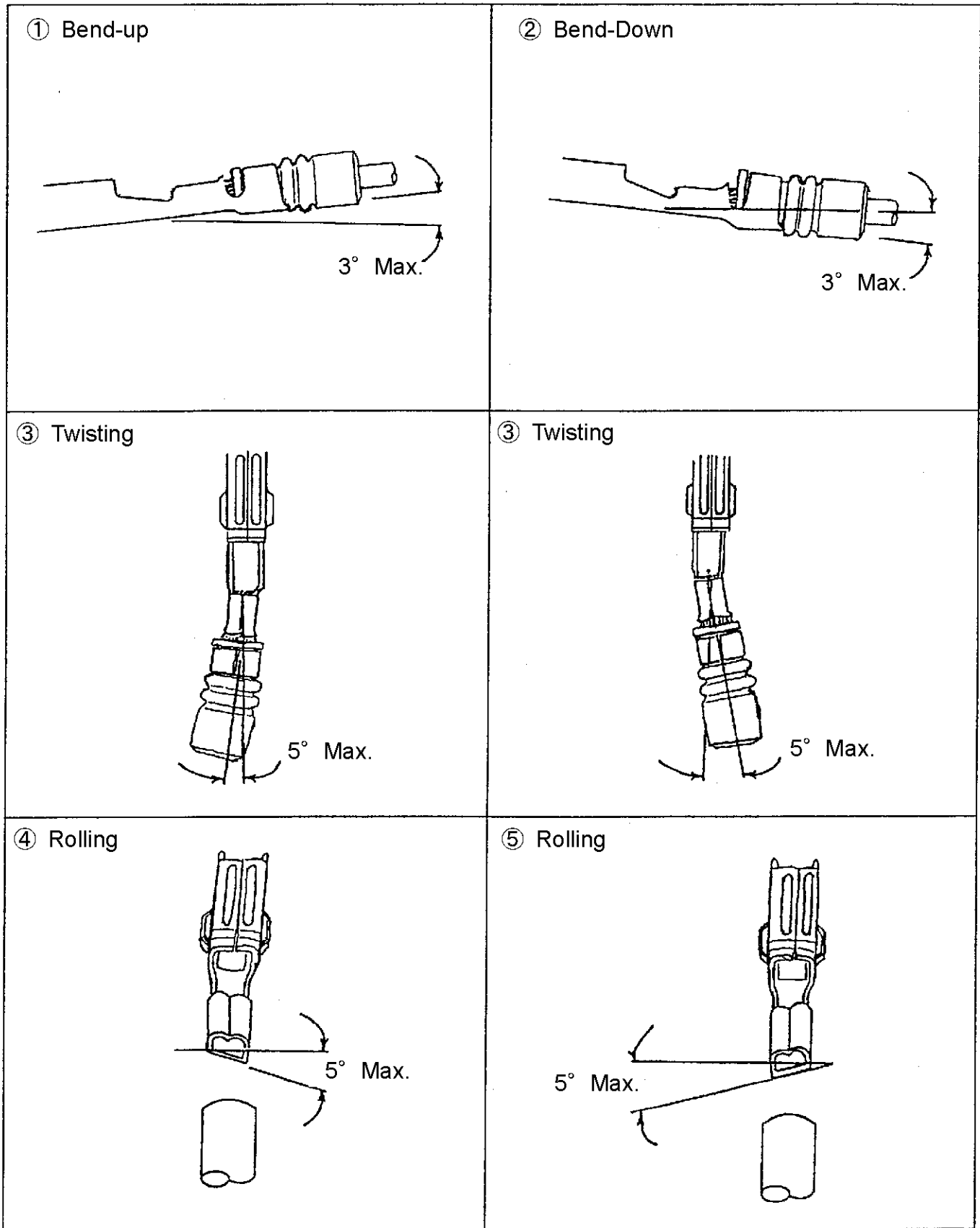


Fig.2

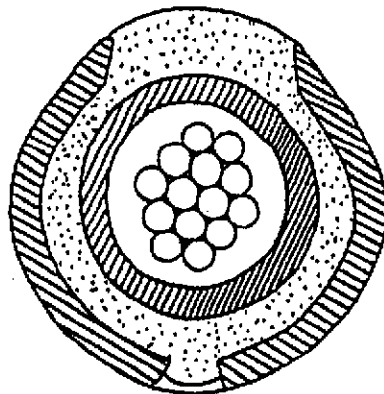
5.2 Crimp Data:

Application Crimp:

Size of Rubber Plug	Contact Part No.	Wire Size	Applicator Number	Wire Barrel Crimp			Insulation Barrel Crimp			Crimp Tensile Strength (N min)		
				Width (mm)	Height Fig.1-⑤ (mm)	Disc Letter	Width (mm)	Height Fig.1-⑥ (mm)	Disc Letter			
S	171630	AVSS0.3	753954-1	1.57 "F"	1.06	B	3.4 "O"	3.40	5	78.4		
		CAVS0.3						753954-2			1.09	A
		AVS0.3	753979-2		2.29"F"	1.37						
		CAVS0.5						88.2				
	171662	CAVS0.85	753979-2	2.29"F"	1.37	B	3.7"O"	3.55		127.4		
	171631	AVSS0.3	753955-1	1.57 "F"	1.06	B	3.4 "O"	3.40		78.4		
		CAVS0.3						753954-2		1.09	A	3.45
		AVS0.3	753979-2		2.29"F"	1.37						
		CAVS0.5						88.2				
	171661	CAVS0.85	753979-2	2.29"F"	1.37	B	3.7"O"	3.55		127.4		
M	171662	AVS0.5	753979-2	2.29 "F"	1.24	C	3.7 "O"	3.45	88.2			
		AVS0.85			1.37	B		3.50	127.4			
		AVSS1.25			1.52	A		3.60	176.4			
		CAVS1.25			1.24	C		3.45	88.2			
	171661	AVS0.5	753978-2		1.37	B		3.50	127.4			
		AVS0.85			1.52	A		3.60	176.4			
		AVSS1.25			1.24	C		3.45	88.2			
		CAVS1.25			1.37	B		3.50	127.4			

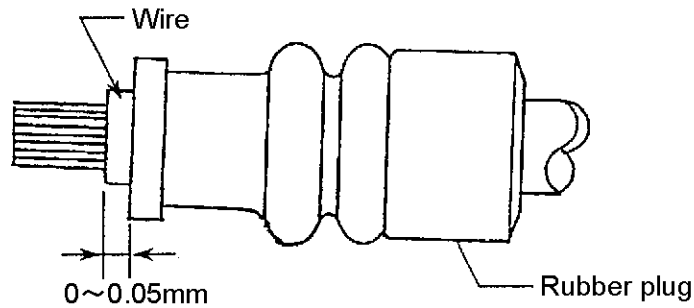
NOTE: Wire barrel tolerance to be within ±0.05mm.

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



6. Rubber Plug Installation

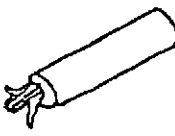
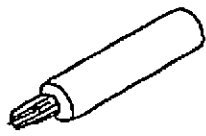
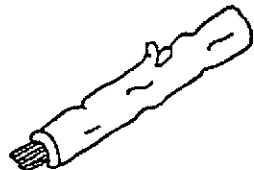
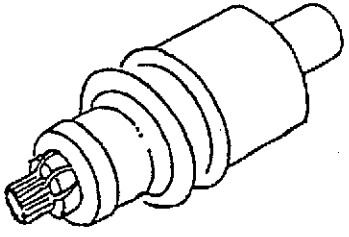
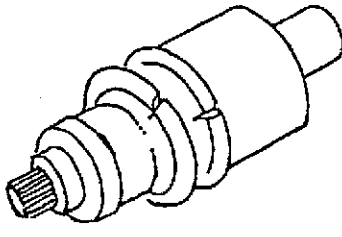
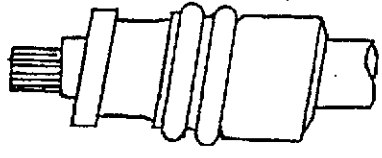
The length of the wire insulation protruding beyond the end of the rubber plug, assembled to the wire, shall be within 0.5mm for all the .070 series receptacles and tabs. (Refer to the following illustration.)



7. Notes

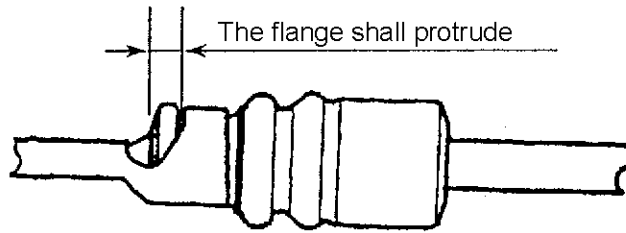
Wires and rubber plugs as illustrated below shall be reworked or replaced because they are detrimental to the required performance.

(Before Crimping)

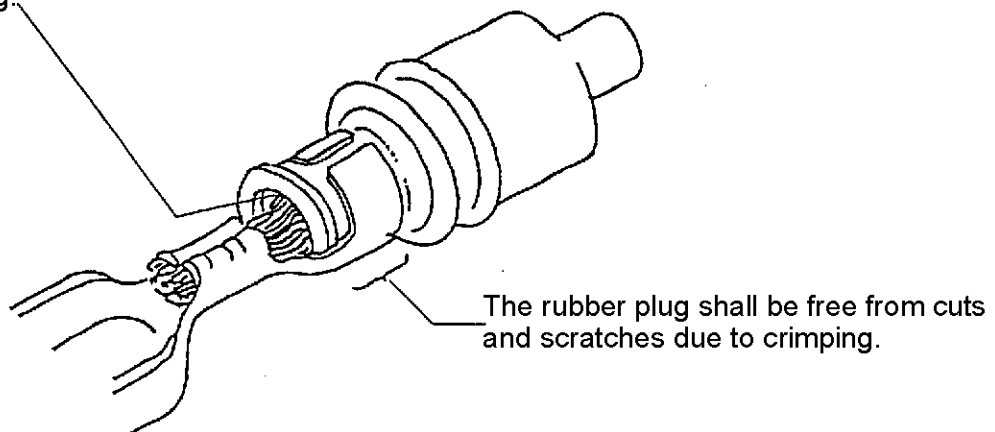
 <p>The strands shall not be frayed.</p>	 <p>The strands shall be free from nick and breakage.</p>	 <p>The insulation shall be round without scratches and dents.</p>
 <p>The strand shall not be frayed.</p>	 <p>The rubber plug shall be free from scratches.</p>	 <p>The rubber plug shall not be crooked.</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	Number of Strands/ Diameter of Stand (mm ²)	Calculated Cross Section Area (mm ²)	Overall Outside Diameter (Standard) (mm)	
			AVS	CAVS
0.3	7/0.26	0.37	1.8	1.4
0.5	7/0.32	0.56	2	1.6
0.85	16/0.26	0.84	2.2	—
	11/0.32	0.88	—	1.8
1.25	16/0.32	1.29	—	2.1