

【1. 適用範囲 SCOPE】

本仕様書は、\_\_\_\_\_殿 に納入する

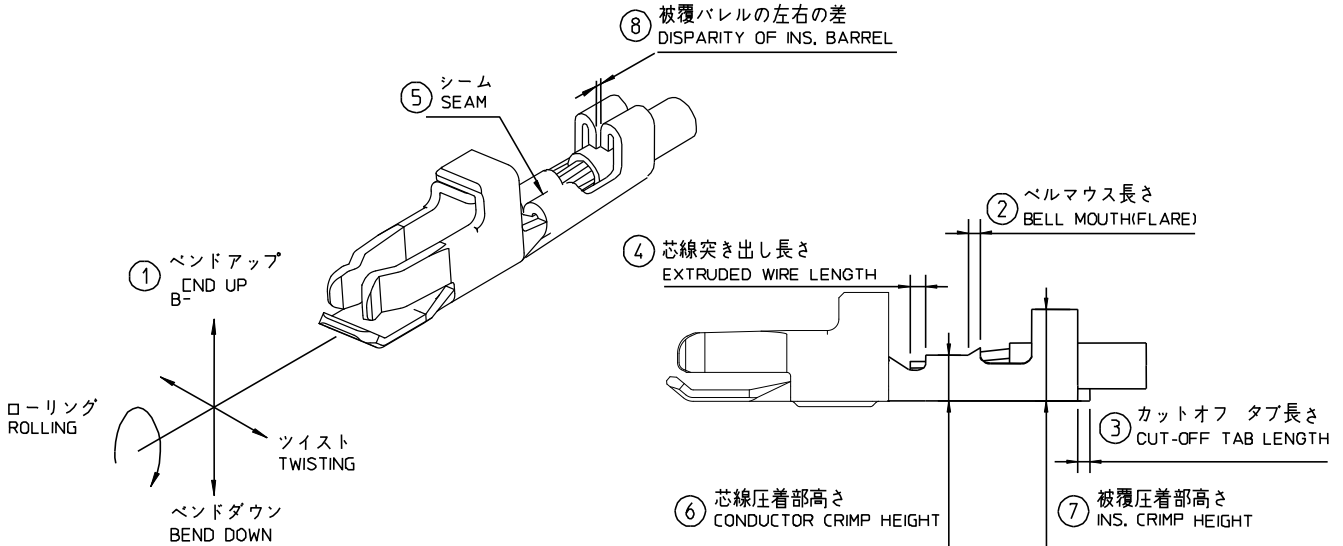
1.25mm PITCH WIRE TO BOARD CONN. RECPTACLE CRIMP TERM の圧着に伴う諸元について規定する。

This standard specifies the dimensions after crimping of the 1.25mm pitch wire to board connector Rec. terminal.

【2. 適用端子／電線 APPLICABLE TERMINAL／WIRE】

端子型番 Part Number	めっき Plating	適用電線 WIRE SIZE		絶縁被覆外径 INSULATION DIAMETER
		AWG	mm <sup>2</sup>	
5 0 5 4 3 1 1 0 0 0	錫めっき TIN Plating	# 2 6 ~ # 3 0	0.049~0.136	φ0.78 ~ φ1.02
5 0 5 4 3 1 1 1 0 0	金めっき Au Plating	# 2 6 ~ # 3 0	0.049~0.136	φ0.78 ~ φ1.02

【3. 各部の名称 DEFINITION】



REV.	E																
SHEET	1-4																
REVISE ON PC ONLY							TITLE:										
E	変更 REVISED 602847 '19/04/17 T.AKAIKE						Micro-Lock PLUS 1.25 W/B CONNECTOR RECEPTACLE CRIMP TERMINAL 圧着仕様書										
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REV.	DESCRIPTION																
DESIGN CONTROL J				STATUS				WRITTEN BY: SSATO02	CHECKED BY: KASAKAWA	APPROVED BY: NUKITA	DATE: 2015/12/01						
DOCUMENT NUMBER CS-505431-001							DOC. TYPE PS	DOC. PART 001	CUSTOMER GENERAL MARKET						SHEET 1 OF 4		

## 【4. 仕様 SPECIFICATION】

番号 NUMBER	項目 ITEM	仕様 REQUIREMENT
①	ベンドアップ BEND UP	2° 以下 / MAX.
	ベンドダウン BEND DOWN	3° 以下 / MAX.
	ツイスト TWISTING	3° 以下 / MAX.
	ローリング ROOLING	4° 以下 / MAX.
②	ベルマウス (参考値) BELL MOUTH (REF.)	0. 1 ~ 0. 3 mm
③	カットオフタブ長さ CUT OFF TAB LENGTH	0. 1 mm以下 / MAX.
④	芯線突き出し長さ EXTRUDED WIRE LENGTH	0. 1 ~ 0. 3
⑤	シーム SEAM	シームは閉じていること。但し開きのある場合は芯線の飛び出しなきこと。 SEAM SHALL NOT BE OPENED AND NOT WIRE ALLOWED OUT OF CRIMPING THE AREA.
⑥	芯線圧着部高さ CONDUCTOR CRIMP HEIGHT	第5項参照 REFER TO 5 <sup>TH</sup> TERM
⑦	被覆圧着部高さ INS.CRIMP HEIGHT	第5項参照 REFER TO 5 <sup>TH</sup> TERM
⑧	被覆バレルの左右の差 DISPARITY OF INS. BARREL	0. 2 mm以下 / MAX.
≠	絶縁被覆むき長さ (参考値) WIRE STRIP LENGTH (REF)	1. 4 ~ 1. 6 mm

## 【5. 圧着条件 (⑥及び⑦) CONDITIONS】

### 5-1. AWG#26~#30

電線 (UL1061相当) を圧着した際の要件は下記による。

AFTER CRIMPING THE WIRE (EQUIVALENT TO UL1061), THE CRIMPED AREAS SHOULD BE AS FOLLOWS.

電線サイズ WIRE SIZE (AWG)	圧着ツール番号 CRIMP DIE MODEL NO.	※⑥芯線圧着部高さ CONDUCTOR CRIMP HEIGHT	⑦被覆圧着部 INSULATION		圧着部引張強度 CRIMP STRENGTH (N {Kgf})
			工具マーク TOOL MARK	参考高さ HEIGHT	
# 2 6	5781463410	0.54~0.59	-	1.19~1.28	19.6 {2.0} 以上 / MIN.
# 2 8		0.49~0.54	-	1.18~1.28	9.8 {1.0} 以上 / MIN.
# 3 0		0.46~0.51	-	1.08~1.18	4.9 {0.5} 以上 / MIN.

※芯線圧着部高さは、圧着機で圧着高さを調整して下さい。

Crimp height should be determined by adjustment of the ram position on crimping machine.

REVISE ON PC ONLY		TITLE:			
<b>E</b>	SEE SHEET 1 OF 4	Micro-Lock PLUS 1.25 W/B CONNECTOR RECEPTACLE CRIMP TERMINAL			
		<b>圧着仕様書</b>			
REV. DESCRIPTION		THIS DOCUMENT CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX ELECTRONIC TECHNOLOGIES, LLC AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION			
DOCUMENT NUMBER CS-505431-001		DOC. TYPE PS	DOC. PART 001	CUSTOMER GENERAL MARKET	SHEET 2 OF 4

被覆圧着形状について

本圧着ターミナルはコネクタの小型化のために、被覆圧着部の各寸法がターミナルの板厚に比べ小さい事と、被覆バレルが電線の被覆部を突き破る圧着形状を避けるために、被覆バレル内側にコイニング加工している事で、被覆バレル先端は第1図のように種々の圧着形状が発生します。また、電線の外径が細径の場合、被覆バレルの先端が電線に触れない形状になることもあります。これらの圧着形状は電線、被覆圧着パンチ、ターミナル等のわずかな変化で、変わる場合があります。いずれの圧着形状も被覆圧着部の本来の機能を満たし、しかも悪影響のない事を確認しています。

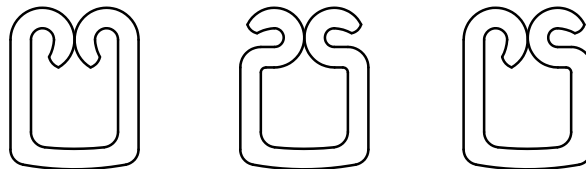
INSULATION CRIMP FORM

This crimp terminal is designed for miniaturization, therefore, each dimension of insulation crimp portion is small as compared with the terminal material thickness, and in order to avoid insulation piercing crimp form by the insulation barrel, coining is provided inside of the insulation barrel, accordingly various crimp forms are occurred at the tip of the insulation crimp barrel, as shown in the fig. 1.

In case of the wire dia. Is small, the tip of crimp barrel may not touch the wire.

These crimp forms may be changed comply with a little change of wire, insulation crimp punch and terminal.

The crimp forms, in any case, are satisfactory for the original function of the insulation crimp portion and it is confirmed that is no bad influence.



第1図  
FIG.1

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