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**WATER-SEALED ECU CONNECTOR**

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**1. PURPOSE**

This crimping specification shall specify the crimping of receptacle contact for Water-Sealed ECU Connector.

**2. CRIMPING SPECIFICATIONS****2-1 Applicable receptacle contacts**

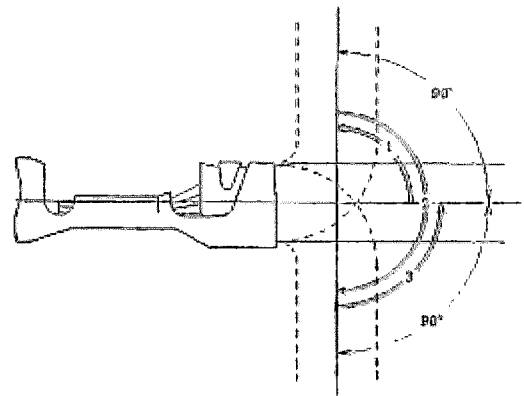
Part No. (Old Part No)	Plating	Barrel Type
8-1447232-7 (942600)	Gold	Standard
5-1437285-7 (942300)	Tin	Standard
8-1447232-8 (942610)	Gold	Small Type
1437278-2 (942320)	Tin	Small Type

2-2 Crimping Specification 1

Contact		Applicable Wire Size			Required Crimping Size at Wire Barrel		Required Crimping Size at Insulation Barrel (*1)		Tensile Strength at Crimping Part	
Barrel Type	Part No.	Core Wire	Covered Wire (mm)	Wire Type	Width (mm)	Height (mm)	Width (mm)	Height (mm)		
Standard	8-1447232-7 (942600)	0.5mm <sup>2</sup>	φ 2.2~φ 2.4	AVO. 5	1.8±0.1	1.0±0.05	2.8±0.1	2.7 max.	88.2N	
		(AWG 20)	φ 2.0~φ 2.1	AVSO. 5			2.4±0.1	2.4 max.		
	5-1437285-7 (942300)	0.85mm <sup>2</sup>	φ 2.4~φ 2.6	AVO. 85	1.8±0.1	1.1±0.05	2.8±0.1	2.9 max.	127.4N	
		(AWG 18)	φ 2.2~φ 2.3	AVSO. 85			2.4±0.1	2.6 max.		
	1.25mm <sup>2</sup>	(AWG 16)	φ 2.7~φ 2.9	AV1. 25	1.8±0.1	1.2±0.05	3.0±0.1	3.2 max.	176.4N	
			φ 2.5~φ 2.6	AVS1. 25			2.6±0.1	2.9 max.		
			φ 2.1~φ 2.2	AVSS1. 25			2.4±0.1	2.5 max.		
	Small Type	8-1447232-8 (942610)	0.3mm <sup>2</sup>	φ 1.8~φ 1.9	AVSO. 3	1.6±0.1	0.8±0.05	2.2±0.1	2.2 max.	58N
		1437278-2 (942320)	0.5mm <sup>2</sup>	φ 2.0~φ 2.1	AVSO. 5	1.6±0.1	0.9±0.051	2.2±0.1	2.4 max.	88.2N
φ 1.6~φ 1.7				AVSSO. 5	2.0 max.					
0.85mm <sup>2</sup>		(AWG 18)	φ 2.2~φ 2.3	AVSO. 85	1.6±0.1	1.1±0.05	2.4±0.1	2.6 max.	127.4N	
			φ 1.8~φ 1.9	AVSSO. 85				2.2±0.1		2.2 max.

\*1 Crimping height of insulation barrel shall not result in the drawing from the barrel part by excessive crimping height or drawing from the barrel part by the broken over in the bending test as shown in Fig. 1.

Fig. 2

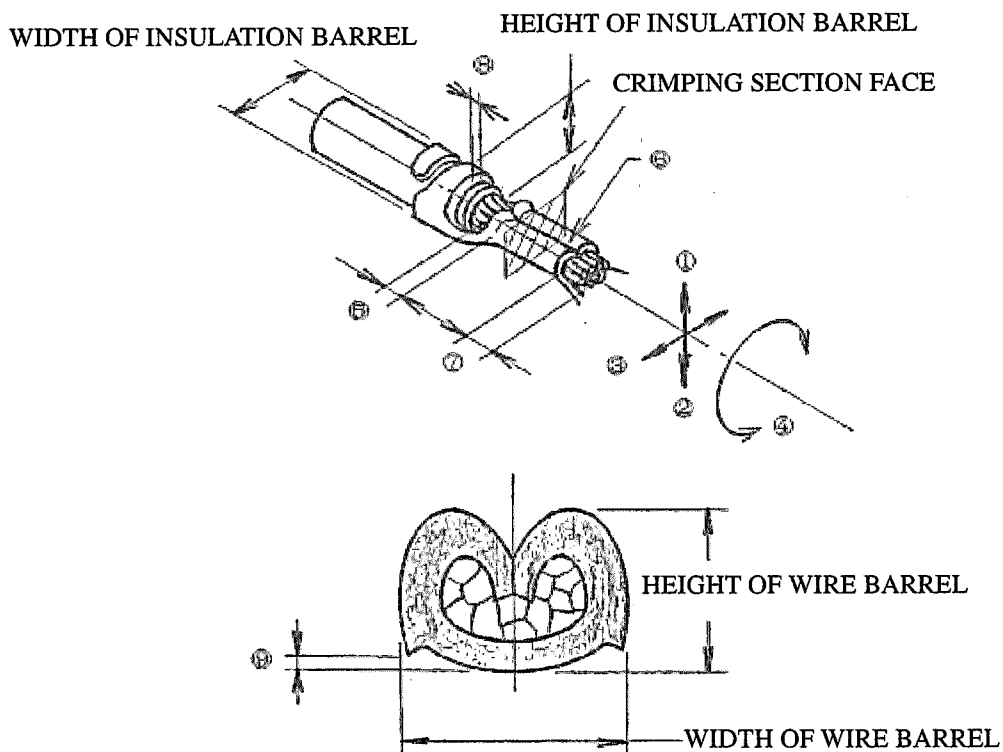


2-3 Crimping Specification 2

Table 3

Position of Fig. 2	Item	Specification
①	Bent up	3° or less
②	Bent down	3° or less
③	Twist	4° or less
④	Rolling	6° or less
⑤	Bell mouse	0.2~0.4mm
⑥	Seam	It shall be closed and core wire shall not be projected.
⑦	Wire projecting length	0.3~0.8mm
⑧	Insulation projecting length	Over 0.5mm, whereas, core wire shall be seen from top side.
⑨	Interval between burrand bottom	0 or more
⑩	stripped wire length (reference value)	$3.5 \begin{smallmatrix} +1 \\ 0 \end{smallmatrix}$ mm (*2)

Fig. 3



\*2: During operating of stripping the isolator and crimping, make sure that harmful crack, scar and deformity on the insulation do not occur.