molex

CRIMP SPECIFICATION

LANGUAGE
JAPANESE
ENGLISH

【１．適用範囲 SCOPE】

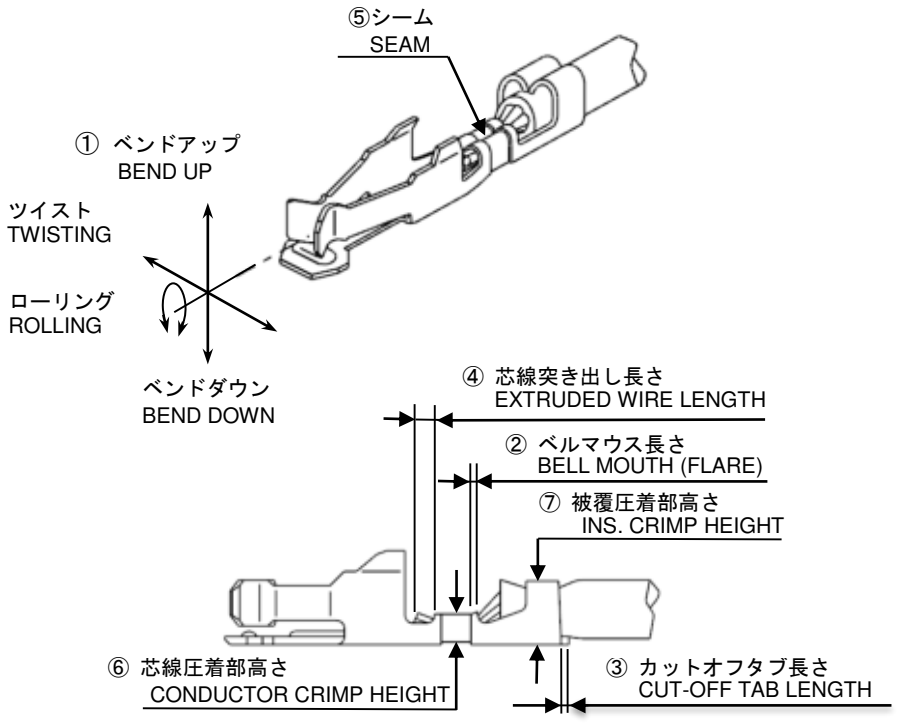
本仕様書は、＿＿＿＿＿＿＿＿＿＿＿＿＿＿殿　に納入する
2.0mm PITCH GRID WIRE TO BOARD CONN. CRIMP TERM の圧着に伴う諸元について規定する。
THIS STANDARD SPECIFIES THE DIMENSIONS AFTER CRIMPING OF THE 2.0mm PITCH GRID WIRE TO BOARD CONNECTOR TERMINAL.

【２．適用端子／電線　APPLICABLE TERMINAL／WIRE】

端　子　型　番 Part Number	適用電線　WIRE SIZE		絶縁被覆外径 INSULATION DIAMETER
	AWG	mm²	
５０３９４－８＊＊＊　撚り線 (STRAND WIRE)	＃２４～＃３０	0.049～0.22	φ0.8 - φ1.4 mm

【３．各部の名称　DEFINITION】

第1図
FIG.1



REV.	A					
SHEET	1-4					
REVISE ON PC ONLY		TITLE: 2.0mm GRID WIRE TO BOARD CONN. CRIMP TERMINAL 圧着仕様書				
A	新規作成 RELEASED 177772 06/06/2018 GSHARMA					
REV.	DESCRIPTION	THIS DOCUMENT CONTAINS INFORMATION THAT IS PROPRIETARY TO MOLEX ELECTRONIC TECHNOLOGIES, LLC AND SHOULD NOT BE USED WITHOUT WRITTEN PERMISSION				
DESIGN CONTROL J	STATUS	WRITTEN BY: M.YAGI	CHECKED BY: Y.ITO	APPROVED BY: H.IKESUGI	DATE: 1993/06/09	
DOCUMENT NUMBER CS-50394		DOC. TYPE PSD	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	４°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　ROLLING	４°以下　/ MAX.
②	ベルマウス（参考値） BELL MOUTH (REF.)	０.０５～０.３５mm
③	カットオフタブ長さ CUT OFF TAB LENGTH	０ ～０.１５ mm以下 / MAX.
④	芯線突き出し長さ EXTRUDED WIRE LENGTH	０～０.５mm
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.
≠	絶縁被覆むき長さ（参考値） WIRE STRIP LENGTH (REF.)	１.３～１.８mm

【５．圧着条件（⑥及び⑦）CONDITIONS】

電線(UL1007相当品)を圧着した際の要件は下記による。
AFTER CRIMPING THE STRAND WIRE (EQUIVALENT TO UL1007), THE CRIMPED AREAS SHOULD BE AS FOLLOWS.

ターミナル番号 TERMINAL NO.	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	高さ HEIGHT (mm)	工具マーク TOOL MARK	参考高さ HEIGHT (REF.) (mm)	
５０３９４－８＊＊＊	＃２４ (*1)	５７３１５－３０００	C	0.60 ～0.65	6	1.35	29.4{3.0}以上 / MIN.
	＃２６		C	0.59 ～0.64	6	1.35	19.6{2.0}以上 / MIN.
	＃２８		B	0.56 ～0.61	6	1.30	9.8{1.0}以上 / MIN.
	＃３０		A	0.53 ～0.58	5	1.30	4.9{0.5}以上 / MIN.

注) *1　UL1061相当品を圧着した際の条件
NOTE.　AFTER CRIMPING WIRE (EQUIVALENT TO UL1061), THE CRIMPED AREA SHOULD BE AS FOLLOWS.

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【6. 消耗部品一覧表 PERISHABLE PARTS LIST】

部品名称 PART NAME		部品番号 PART NO.
アンビル	ANVIL	57175-2101
芯線クリンプパンチ	COND. PUNCH	57175-2102
被覆クリンプパンチ	INS. PUNCH	57175-2103
フロントフローティングシェア	FRONT FLOATING SHEAR	57067-2006
フロントホルダー	FRONT HOLDER	57067-2005

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REV.	REV. RECORD	DATE	EC NO.	WRITTEN BY :	CHECKED BY :
0	RELEASED	09/06/93	T30267	M.YAGI	--
D	REDRAWN & RELEASED	06/06/18	177772	G.SHARMA	A.TEZUKA

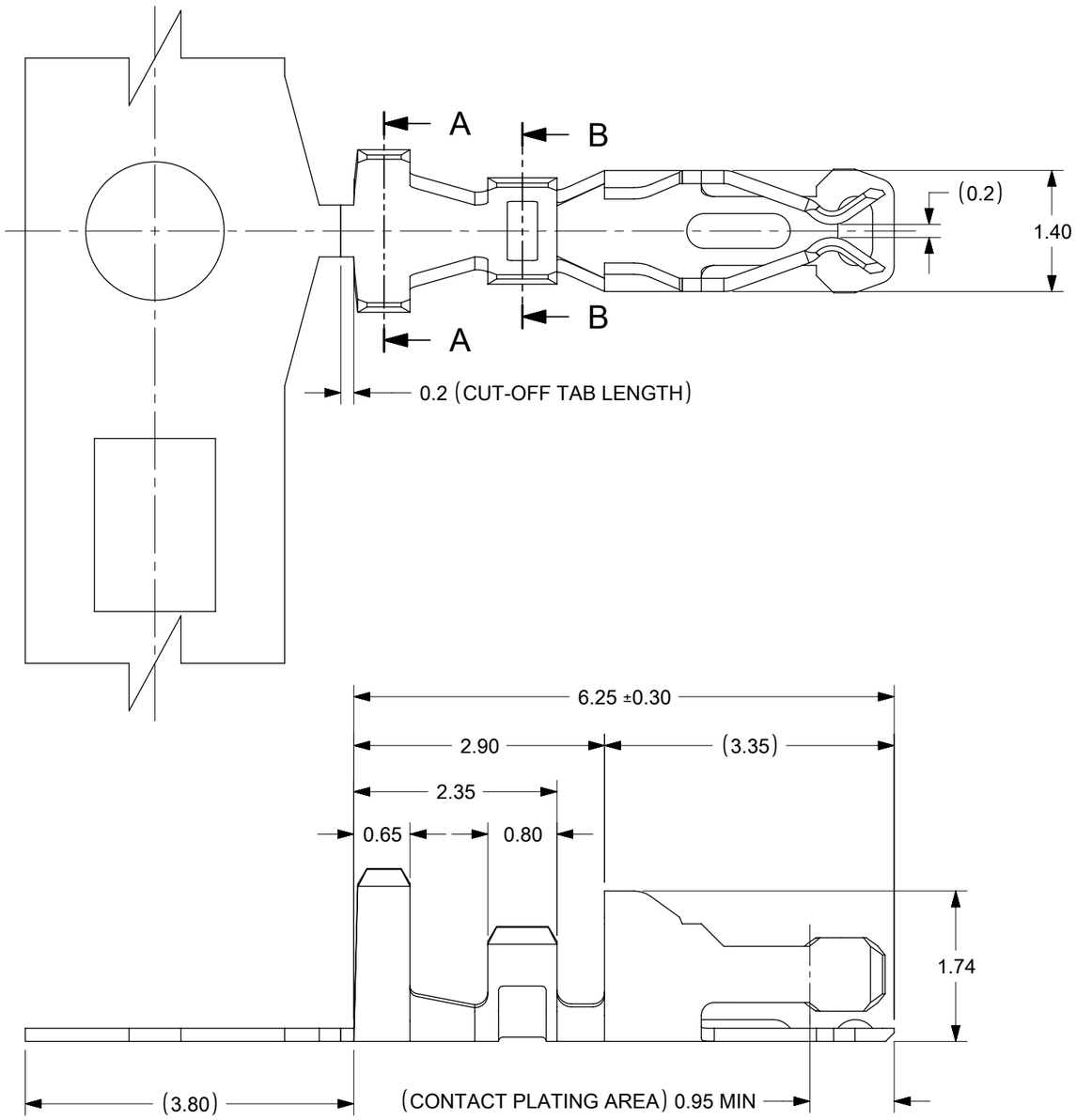
REVISE ON PC ONLY

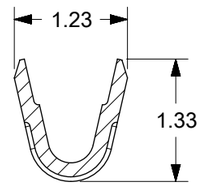
REV.	DESCRIPTION
A	SEE SHEET 1 OF 4

TITLE:
1.25 W/B CONN.
RECEPTACLE CRIMP TERMINAL
圧着仕様書

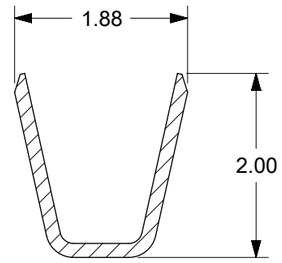
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ENG. P/NS		CONTACT PLATING (NICKEL OVERALL 2-6 µm MIN)
FORM : LOOSE	FORM : CHAIN	
50394-8100	50394-8051	0.38µm GOLD MIN.
50394-8200	50394-8052	0.76µm GOLD MIN.
50394-8400	50394-8054	GOLD FLASH 0.05 - 0.125µm
50394-8500	50394-8055	2.50µm MATTE TIN MIN.

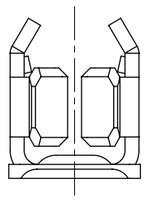




SECTION B-B

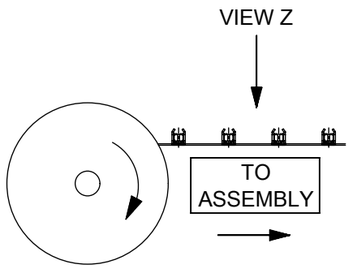


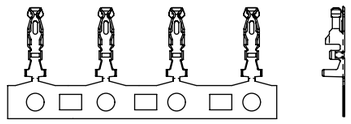
SECTION A-A



NOTES :
1. MATERIAL: COPPER ALLOY
2. APPLICABLE HOUSING : 51110-***1
   : 51110-**5*
   : 151100-00**
3. APPLICABLE WIRE: AWG #24-#30
   WIRE INSULATION OD: 1.40mm MAX.
4. CRIMPING SPECIFICATION: CS-50394

WINDING DIRECTION





VIEW Z

QUALITY SYMBOLS	
EA	= 0
EC	= 0
ED	= 0
	= 0
C	= 0
	= 0
	= 0
C	= 0

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EC NO: 662246 2021/04/28
DRWN: ABABUPS 2021/04/28
CHK'D: MRAMAKRISHNA 2021/04/28
APPR: MRAMAKRISHNA

GENERAL TOLERANCES (UNLESS SPECIFIED)

	MM	INCH
4 PLACES	±	±
3 PLACES	±	±
2 PLACES	± 0.2	±
1 PLACES	±	±
0 PLACES	±	±

ANGULAR TOL ± 3.0

DRAFT WHERE APPLICABLE MUST REMAIN WITHIN DIMENSIONS

REV: C2

DIMENSION UNITS	MM
SCALE	NTS
DRWN BY	S.Q
DATE	1994/04/20
CHK'D BY	EDPOH
DATE	1994/04/27
APPR BY	LBLEE
DATE	2013/11/13
DRAWING SIZE	A3
THIRD ANGLE PROJECTION	

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SALES DRAWING
2.0MM GRID W TO B CONN. CRIMP TERMINAL

PRODUCT CUSTOMER DRAWING

SERIES	MATERIAL NUMBER	CUSTOMER
50394	SEE TABLE	GENERAL MARKET

DOCUMENT NUMBER	DOC TYPE	DOC PART	SHEET NUMBER
SD-50394-8XXX	PSD	000	1 OF 1

RELEASE STATUS		RELEASE DATE	

FORMAT: Met-lega-master-tb-prod-A3
REVISION: C
DATE: 2016/02/04