

The performance of applicable product is guaranteed only when processed by proper application tooling and condition described in this specification and/or TE recognized ones.  
 No product is guaranteed when processed with the other tool or condition

**1. Scope**

This specification covers the requirements for crimping of Sealed 1.0 Receptacle Contact.

**2. Applicable Contacts**

| TE Part numbers * | Name                       | Applicable Wires  | Finish  |
|-------------------|----------------------------|---|---------|
| 1554723           | 1.0 Receptacle Contact (S) | AVSS /AVSSH / AESSX<br>0.5~0.75 mm <sup>2</sup><br>AVSS 0.85mm <sup>2</sup> | Pre-Tin |

**NOTE** \* Note: Parts number is consisted from listed base number and 1 digit numeric prefix and suffix with dash. Refer to catalog or customer drawing for specific part numbers for each base number. When prefix is zero, zero and dash are omitted.

**3. Nomenclature**

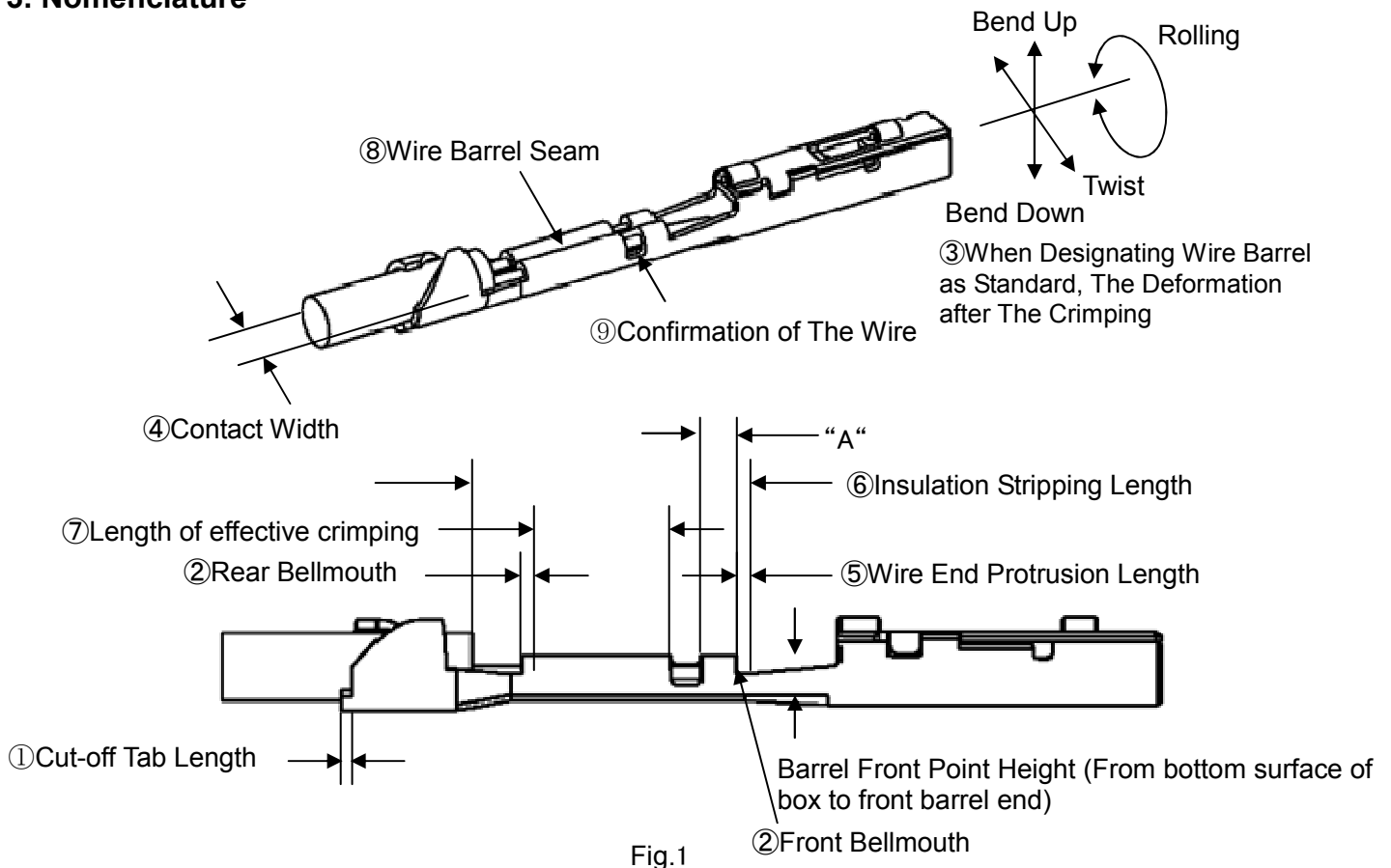


Fig.1

**4. Crimping Condition**  
**Applicator Crimp**

| Applicable Contacts |  | 1.0 Receptacle Contact   |           | Remarks |
|---------------------|--|--|-----------|---------|
|                     |  | 1554723  |           |         |
| 1                   | Cut-off Tab Length   | 0.25mm Max.  |           | Fig.1-① |
| 2                   | Bellmouth  | Front  | 0mm Max.  | Fig.1-② |
|                     |  | Rear   | 0.2~0.8mm |         |
| 3                   | When Designating Wire Barrel as Standard, The Deformation after The Crimping | Bend   | ±3° Max.  | Fig.1-③ |
|                     |  | Twist  | ±4° Max.  |         |
|                     |  | Rolling  | ±10° Max. |         |
| 4                   | Contact Width after Crimping   | 2.35mm Max.  |           | Fig.1-④ |
| 5                   | Wire End Protrusion Length   | Thing that 0mm or less and wire end is put in "A" area of Fig.1. |           | Fig.1-⑤ |
| 6                   | Insulation Stripping Length (Before the Crimping) <sup>(2)</sup>             | 4.8~5.3mm  |           | Fig.1-⑥ |
| 7                   | Length of effective crimping <sup>(1)</sup>                                  | 2.0mm  |           | Fig.1-⑦ |
| 8                   | Wire Barrel Seam   | Seam must be closed.<br>(No strand looses out of the seam)       |           | Fig.1-⑧ |
| 9                   | Insulated coating advanced position  | You can verify the wire with visual inspection the wire barrel.  |           | Fig.1-⑨ |

**NOTE**

- (1) Crimping height has gone into standard in the designated range
- (2) Insulation coating of the wire which you use is smooth. When crimping do not use any which have the damage and deformation on the insulated coating surface

**5. Crimp Data**  
**Applicator Crimp**

| Contact Part Number | Wire Size (Nominal) | Applicator Part Number | Wire Barrel Crimp (mm) |                     |                           |           | Insulation Barrel Crimp (mm) |                    | Crimp Tensile Strength (N)Min. <sup>(3)</sup> |   |   |
|---------------------|---------------------|------------------------|------------------------|---------------------|---------------------------|-----------|------------------------------|--------------------|---|---|---|
|                     |                     |                        | Width <sup>(2)</sup>   | Height              | Barrel Front Point Height | Disk Ltr. | Width <sup>(2)</sup>         | Height             |   |   |   |
| 1554723             | 0.5                 | 2088668-2              | 1.57 "F"               | 1.03 <sup>(1)</sup> | 1.45 MAX                  | D         | 1.78 "O"                     | Refer to Section 6 | 80  |   |   |
|                     | 0.5f                |                        |                        | 1.05 <sup>(1)</sup> |                           |           |                              |                    |   | C |   |
|                     | 0.75f               |                        |                        | 1.16 <sup>(1)</sup> |                           |           |                              |                    |   |   | B |
|                     | 0.85                |                        |                        | 1.19 <sup>(1)</sup> |                           |           |                              |                    |   |   |   |

**NOTE**

- (1) Wire Barrel Crimp Height to be within ±0.05mm.
- (2) Crimp Width dimensions are not the product width after crimping, but given by the width of crimper slot for reference.
- (3) The wire grip of insulation barrel crimp.

## 6. Crimp Data of Insulation Barrel

| Contact Part Number | Wire Size (Nominal) | AVSSH/AESSX                | AVSS                       |
|---------------------|---------------------|----------------------------|----------------------------|
|                     |                     | Height (mm) <sup>(1)</sup> | Height (mm) <sup>(1)</sup> |
| 1554723             | 0.5                 | —                          | 2.0                        |
|                     | 0.5f                | 2.0                        | 2.0                        |
|                     | 0.75f               | 2.15                       | 2.15                       |
|                     | 0.85                | —                          | 2.15                       |

**NOTE** (1) Insulation Barrel Crimp Height to be within  $\pm 0.1$ mm

## 7. Applicable Wire Data

| Wire Size |                      | Number /Diameter (mm) of Conductor (mm) | Calculated Cross sectional Area (mm <sup>2</sup> ) | Insulation Diameter (mm) |      |
|-----------|----------------------|---|--|--------------------------|------|
| Nominal   | Classification       |   |  | STD.                     | Max. |
| 0.5       | AVSS                 | 7/0.32                                  | 0.5629   | 1.6                      | 1.7  |
| 0.5f      | AVSS/<br>AVSSH/AESSX | 19/0.19                                 | 0.5387   | 1.6                      | 1.7  |
| 0.75f     | AVSS/<br>AVSSH/AESSX | 19/0.23                                 | 0.7894   | 1.8                      | 1.9  |
| 0.85      | AVSS                 | 19/0.24                                 | 0.8595   | 1.8                      | 1.9  |

**NOTE** (1) Because there are times when the application applicable wire is restricted by the connector which is used, follow the specification of each connector or the indication of the instruction manual.