

RT冲压端子铆压说明

RT stamping terminal crimping instructions

第一步：按照下表要求剥绝缘皮。

Step 1: Strip the insulation according to the following table.



Fig 1



Fig 2

端子型号 Contact type	料号 Contact P/N	电线规格 Wire section range	剥线长度 mm (+/-0.5) Wire stripping length (mm) (+/-0.5)
12	SP12A1*-10 SS12A1*-10	4.0mm ²	5.00
	SP12A1* SS12A1*	12AWG 14AWG	5.00
16	SP14M1*、SP14M2* SS14M1*、SS14M2*	14AWG 16AWG	4.50
	SP16M1*、SP16M2* SS16M1*、SS16M2*	16AWG 18AWG	4.50
	SP20M1*、SP20M2* SS20M1*、SS20M2*	20AWG 22AWG	4.00
	SP24M1*、SP24M2* SS24M1*、SS24M2*	24AWG 26AWG	4.00
20	SP20W1*、SP20W2* SS20W1*、SS20W2*	20AWG 22AWG	4.20
	SP24W1*、SP24W2* SS24W1*、SS24W2*	24AWG 26AWG	4.20

注：* 代表不同电镀。 Note: * represents different plating

第二步: 端子铆压注意事项.

Step 2: Terminal crimping pressure matters needing attention.

导体铆压区
Conductor crimp area

绝缘铆压区
Insulated crimp pressing area

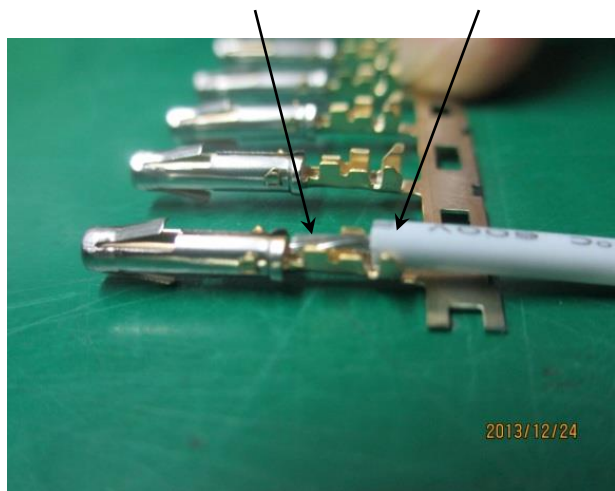


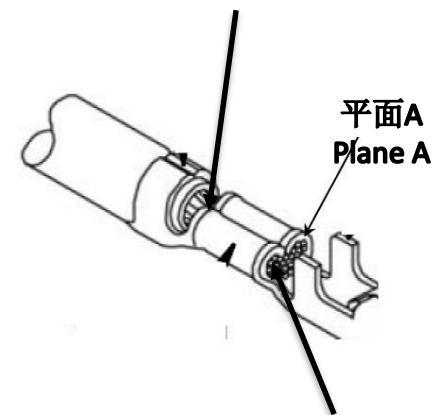
Fig 3

铆压设备
crimp pressure
equipment



Fig 4

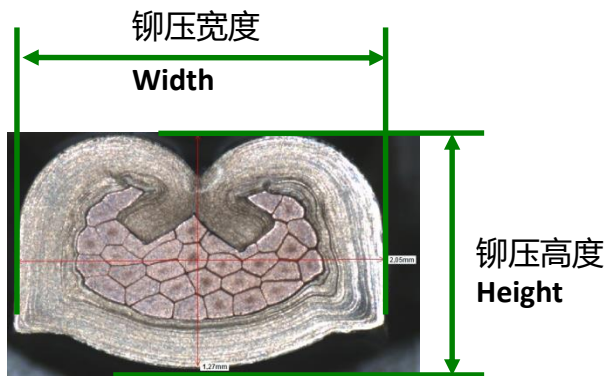
绝缘不能进入导体铆压区域
Insulating skin shall not enter the
crimping area of the conductor



导体必须伸出平面A且不得进入端子配合区域
The conductor must extend out of
plane A and not enter the terminal
mating region

第三步：铆压最大高度和宽度要求。

Step 3: Requirements for maximum height and width of crimping.



- 目视检查**
- 绝缘皮没损失
 - 导体全部被铆压
- Visual inspection**
- No loss of insulation
 - The conductors are all riveted

端子型号 Contact type	料号 Contact P/N	电线规格 Wire section range	铆压高度 (mm) (+/-0.12) Height (mm) (+/-0.12)	铆压宽度 (mm) (+/-0.18) Width (mm) (+/-0.18)
12	SP12A1*-10 SS12A1*-10	4.0mm ²	2.55	2.95
	SP12A1* SS12A1*	12AWG	2.09	2.90
		14AWG	1.81	2.86
16	SP14M1*、SP14M2* SS14M1*、SS14M2*	14AWG	1.89	2.50
		16AWG	1.51	2.45
	SP16M1*、SP16M2* SS16M1*、SS16M2*	16AWG	1.47	2.43
		18AWG	1.30	2.43
	SP20M1*、SP20M2* SS20M1*、SS20M2*	20AWG	1.21	1.81
		22AWG	1.03	1.79
		24AWG	0.87	1.53
20	SP24M1*、SP24M2* SS24M1*、SS24M2*	26AWG	0.78	1.53
		20AWG	1.00	1.59
	SP20W1*、SP20W2* SS20W1*、SS20W2*	22AWG	0.89	1.59
		24AWG	0.78	1.53
		26AWG	0.68	1.48

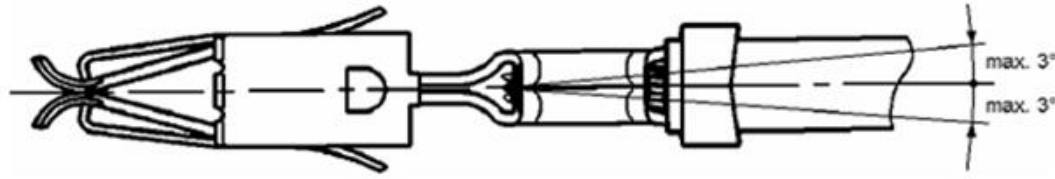
注：* 代表不同电镀。 Note: * represents different plating

第四步：铆压外观要求。

Step 4: Crimping appearance requirements.

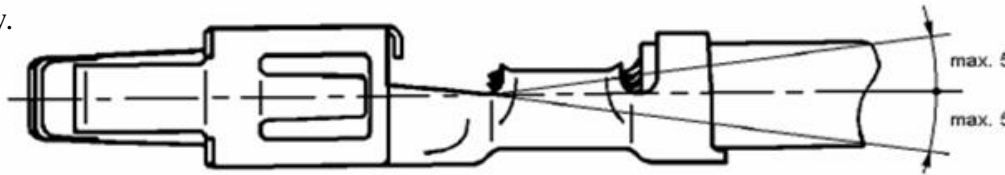
铆压完成后如下图所示方向，从铆压区域开始最大弯曲角度 3° 。

After the crimping is completed, the maximum bending Angle from the crimping area is 3° in the direction shown in the figure bel



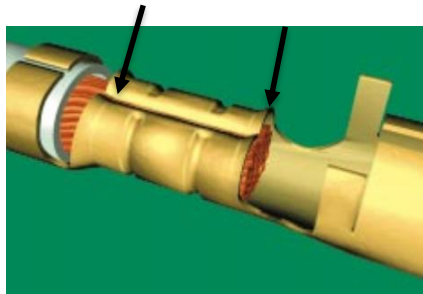
铆压完成后如下图所示方向，从铆压区域开始最大弯曲角度 5° 。

After the crimping is completed, the maximum bending Angle starting from the crimping area is 5° in the direction shown in the figure below.



铆压完成后导体铆压区域必须有喇叭口。

After crimping, the crimping area of the conductor must have a bell mouth.



第四步：铆压拉力要求 (IPC-WHMA-A-620A)。

Step 4: crimping tension requirements (IPC-WHMA-A-620A).



Fig 5



Fig 6

端子型号 Contact type	料号 Contact P/N	电线规格 Wire section range	拉力要求 Tensile straight test (mini)
12	SP12A1*-10 SS12A1*-10	4.0mm ²	≥80 lbf
	SP12A1* SS12A1*	12AWG	≥70 lbf
		14AWG	≥50 lbf
16	SP14M1*、SP14M2* SS14M1*、SS14M2*	14AWG	≥50 lbf
		16AWG	≥30 lbf
	SP16M1*、SP16M2* SS16M1*、SS16M2*	16AWG	≥30 lbf
		18AWG	≥20 lbf
	SP20M1*、SP20M2* SS20M1*、SS20M2*	20AWG	≥13 lbf
		22AWG	≥8 lbf
20	SP24M1*、SP24M2* SS24M1*、SS24M2*	24AWG	≥5 lbf
		26AWG	≥3 lbf
	SP20W1*、SP20W2* SS20W1*、SS20W2*	20AWG	≥13 lbf
		22AWG	≥8 lbf
SP24W1*、SP24W2* SS24W1*、SS24W2*	24AWG	≥5 lbf	
	26AWG	≥3 lbf	

注: * 代表不同电镀。 Note: * represents different plating

铆压刀片展示 Rivet tools display

绝缘铆压刀片
Insulation area
crimping tool



导体铆压刀片
Conductor area
crimping tool



铆压完成后图示
Picture after finishing the crimping



参数汇总表 Summary table of parameters

端子型号 Contact type	料号 Contact P/N	剥线长度 (mm) (+/-0.5) Wire stripping length (mm) (+/-0.5)	电线规格 Wire section range	拉力要求 Tensile straight test (mini)	铆压高度 (mm) (+/-0.12) Height (mm) (+/-0.12)	铆压宽度 (mm) (+/-0.18) Width (mm) (+/-0.18)
12	SP12A1*-10 SS12A1*-10	5.0	4.0mm	80 lbf	2.55	2.95
	SP12A1* SS12A1*	5.0	12AWG	70 lbf	2.09	2.90
			14AWG	50 lbf	1.81	2.86
	16	SP14M1*、SP14M2* SS14M1*、SS14M2*	4.5	14AWG	50 lbf	1.89
16AWG				30 lbf	1.51	2.45
SP16M1*、SP16M2* SS16M1*、SS16M2*		4.5	16AWG	30 lbf	1.47	2.43
			18AWG	20 lbf	1.30	2.43
SP20M1*、SP20M2* SS20M1*、SS20M2*		4.0	20AWG	13 lbf	1.21	1.81
			22AWG	8 lbf	1.03	1.79
SP24M1*、SP24M2* SS24M1*、SS24M2*		4.0	24AWG	5 lbf	0.87	1.53
			26AWG	3 lbf	0.78	1.53
20	SP20W1*、SP20W2* SS20W1*、SS20W2*	4.2	20AWG	13 lbf	1.00	1.59
			22AWG	8 lbf	0.89	1.59
	SP24W1*、SP24W2* SS24W1*、SS24W2*	4.2	24AWG	5 lbf	0.78	1.53
			26AWG	3 lbf	0.68	1.48

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