

CRIMP QUALITY GUIDELINES

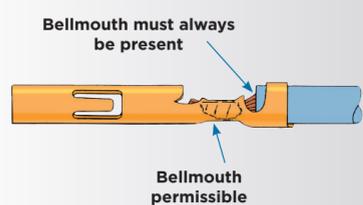
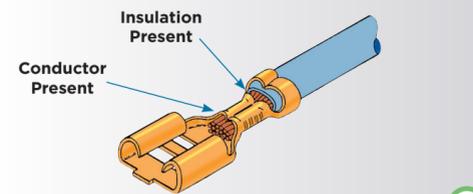
Good Crimp Quality

Incorrect Crimp Quality

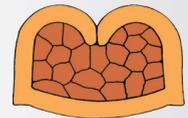
WIRE CRIMP

WIRE CRIMP

TEST - WIRE CRIMP

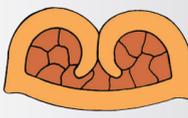


Correct selection of wire, terminal and applicator

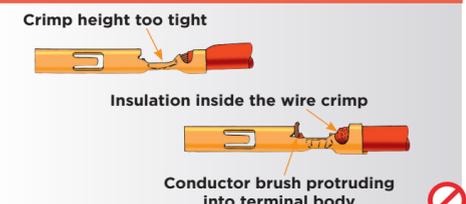
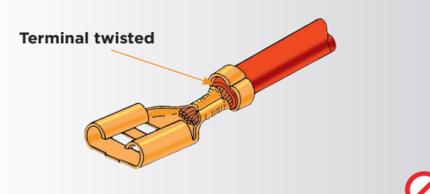
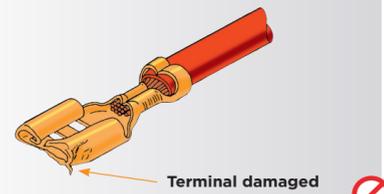
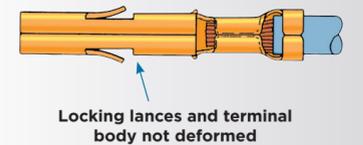
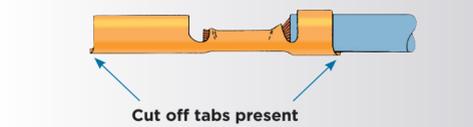


Crimp barrel is closed, legs support each other. All strands are equally distributed and deformed.

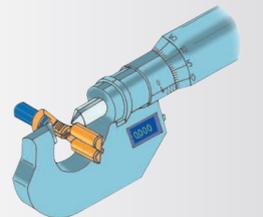
Correct selection of wire, terminal and applicator



Sufficient gap between legs and bottom of crimp. All strands are equally distributed and deformed.



Crimp height measurement



Crimp height and tolerances

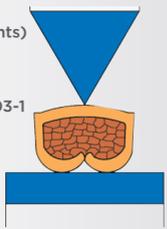
For crimp height tolerances for any given contact, please refer to the relevant application specification.

Examples

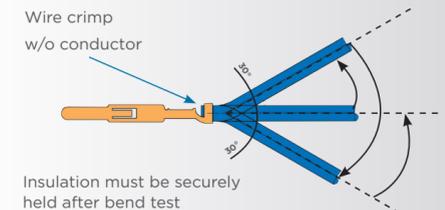
Contact	P/N	Wire Range	Tolerance	Application Spec.
MQS	962885 962886	0,20 - 0,50 mm ²	±0,03 mm	114-18025
JPT	97775	0,50 - 1,00 mm ²	±0,05 mm	114-18050
JPT	97773	1,50 - 2,50 mm ²	±0,05 mm	114-18050

Digital crimp height micrometer

(0.001mm increments) according to DIN ISO 9001 Part Number 547203-1



Insulation Crimp



INSULATION CRIMP 'F'

INSULATION CRIMP 'OVERLAP'

INSULATION CRIMP 'CLOSED BARREL'

INSULATION CRIMP 'CLOSED BARREL'

INSULATION CRIMP 'F'

INSULATION CRIMP 'OVERLAP'

Correct selection of wire, terminal and applicator

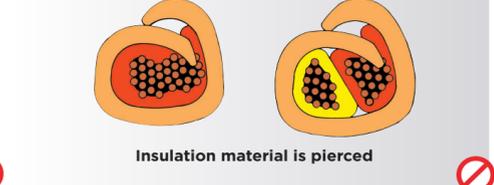
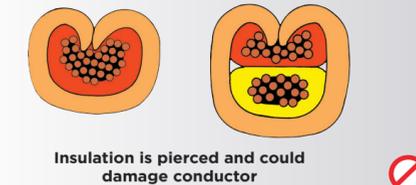
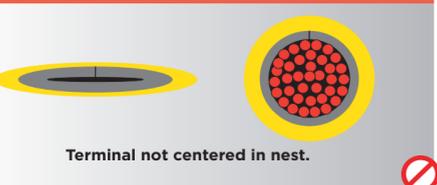
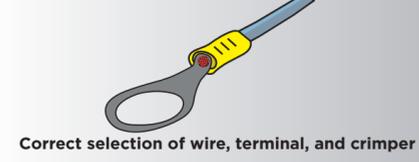
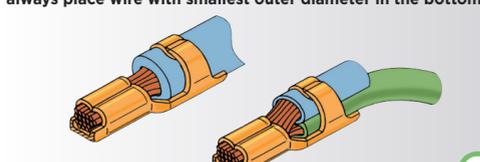
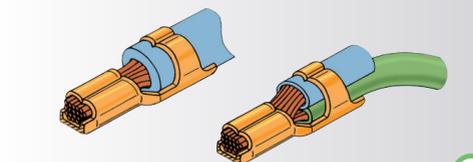
For double wire applications with different size wires always place wire with smallest outer diameter in the bottom

Correct selection of wire, terminal, and crimper

Terminal not centered in nest.

Insulation is pierced and could damage conductor

Insulation material is pierced



Insulation is securely held. Crimp barrel closed.

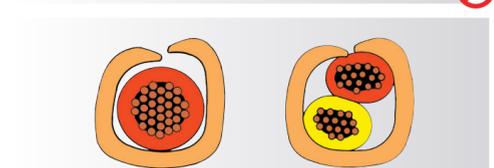
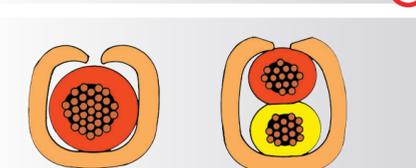
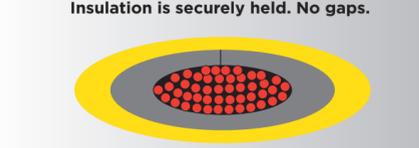
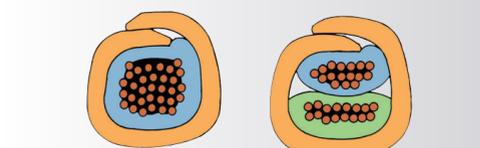
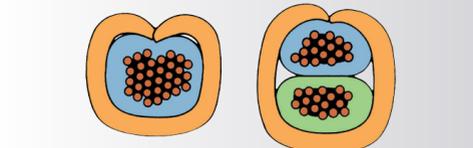
Insulation is securely held. Legs overlap.

Insulation is securely held. No gaps.

Insulation is pierced and could damage conductor

Insulation is pierced and could damage conductor

Insulation material is pierced

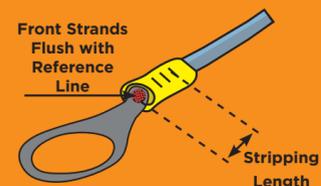


Insulation legs are not closed

Insulation legs are not closed

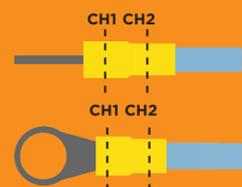
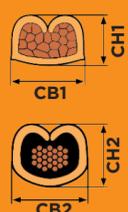
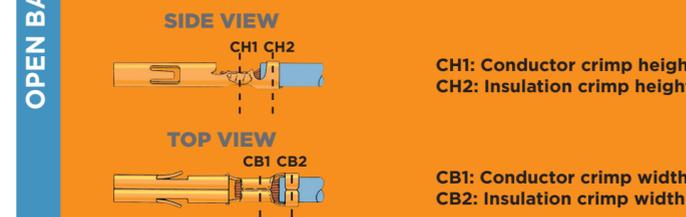
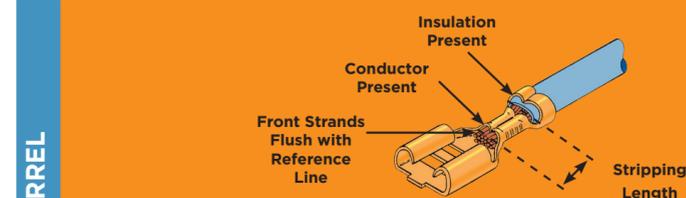
Insulation is not securely held. Legs do not overlap.

CRIMP CROSS SECTION CHARACTERISTICS



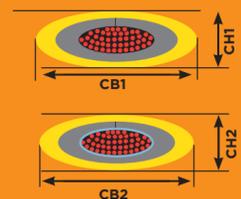
OPEN BARREL

CLOSED BARREL



CH1: Conductor crimp height
CH2: Insulation crimp height

CB1: Conductor crimp width
CB2: Insulation crimp width



The above images of crimp failures are only shown as examples and are by no means exhaustive of all possible failures. In every case, relevant product and application specification take precedence.

All figures are schematic depictions. In every case, relevant product and application specification take precedence.



Scan to watch our Crimp Quality Video.



To learn more about our tooling solutions please call us at 717-810-2082 or email us at Toolingsales@te.com

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