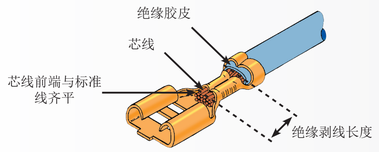
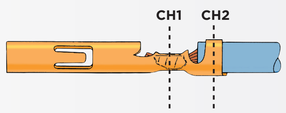
压接质量指导图

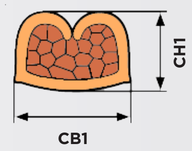
压接剖面图特征

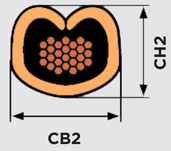


侧面图



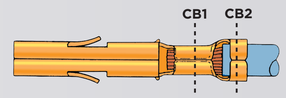
CH1: 芯线压接高度
CH2: 绝缘压接高度





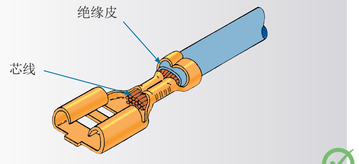
CB1: 芯线压接宽度
CB2: 绝缘压接宽度

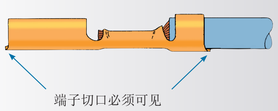
俯视图

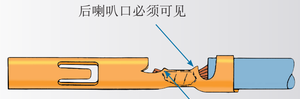


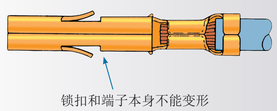
压接质量良好

线束压接

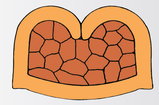




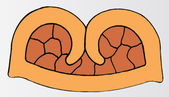




选择正确的线束、端子和压接模具



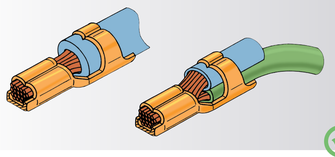
端子包脚闭合并且相互支撑
所有芯线均匀分布并完全变形。



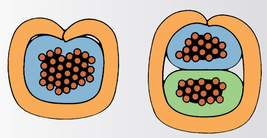
端子包脚不触底，所有芯线均匀分布并且完全变形。

绝缘压接 ‘F’

选择正确的线束、端子和压接模具

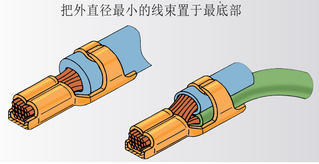


绝缘胶皮被牢固地紧扣，包脚两端完全闭合。

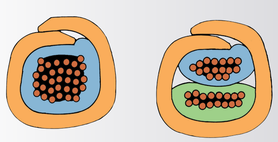


绝缘压接 ‘0V’

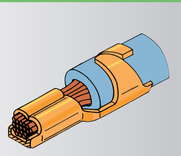
同时压接不同大小的两根电线，必须把外直径最小的线束置于最底部



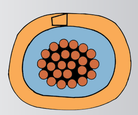
绝缘胶皮被牢固地紧扣，包脚两端覆盖重叠。



绝缘压接 ‘0’



绝缘胶皮被牢固地紧扣，包脚两端互相交叉

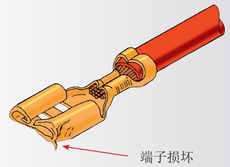


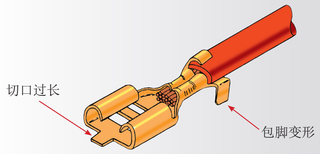
以上所有图解仅作为原理描述，请根据不同条件以及实际的相关产品和压接规范分析压接质量是否合格。

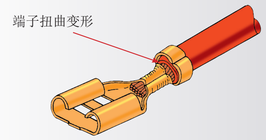
正确　　错误

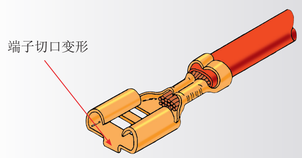
压接质量不合格

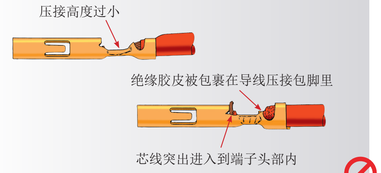
线束压接

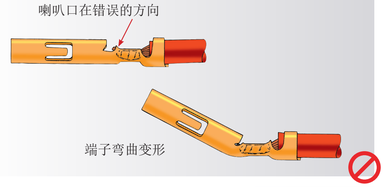










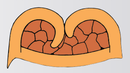


压接模具调试不到位

压接不对称

端子供给设置不正确

不合格的压接造成端子变形导致底部开裂或出现批锋



上刀和下刀没有对中或已磨损

选择了错误的端子 / 线束

线径过大

端子包脚无法闭合

线径过小

端子包脚过于靠近端子底部，芯线未完全变形并在端子里出现空洞。

压接模具调试

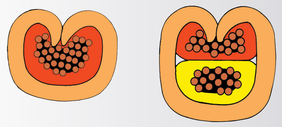
压接高度过大

芯线未完全变形，端子内部呈现空洞

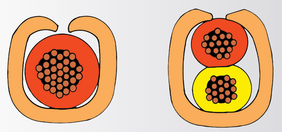
压接高度过小

端子被过度压接以至于变形，端子底部出现批锋

绝缘压接 ‘F’

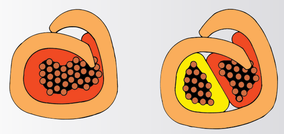


绝缘胶皮被刺破并且芯线受损

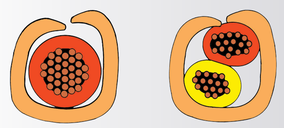


绝缘包脚没有闭合

绝缘压接 ‘0V’

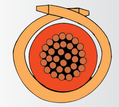


绝缘胶皮被刺破

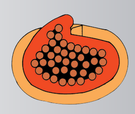


绝缘胶皮没有被牢固地紧扣，压接管两端没有交互紧扣。

绝缘压接 ‘0’



绝缘胶皮没有被牢固地紧扣



绝缘胶皮被过度压接

以上不合格压接质量图片仅作为参考例子，并不包括所有的不合格压接案例，请根据不同条件以及实际的相关产品和压接规范分析压接质量是否合格。

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