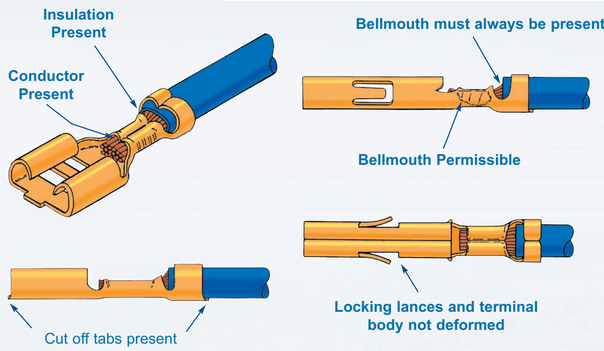
Crimp Quality Guidelines

TE connectivity APPLICATION TOOLING

Correct

WIRE CRIMP



Correct selection of wire, terminal and applicator

Crimp barrel is closed, legs support each other

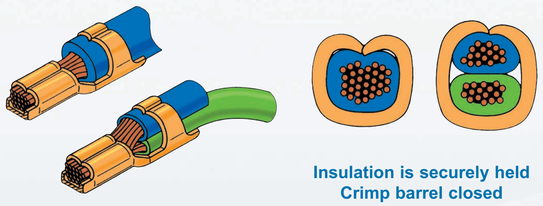
Sufficient gap between legs and bottom of crimp

All strands are equally distributed and deformed

INSULATION CRIMP

Correct Insulation Diameter, Applicator and Terminal.

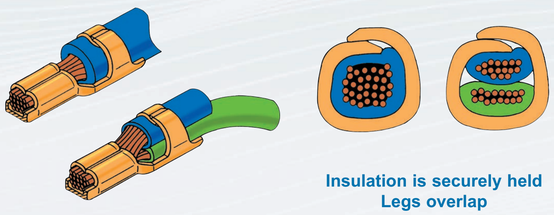
F-CRIMP



Insulation is securely held
Crimp barrel closed

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

OVERLAP CRIMP

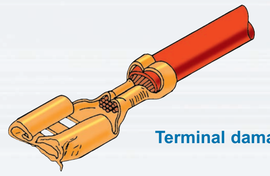


Insulation is securely held
Legs overlap

WRAP OVER CRIMP

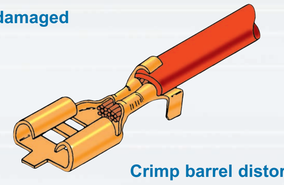
Insulation securely held
Legs must pass each other

Incorrect

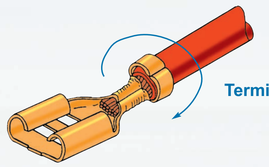


Terminal damaged

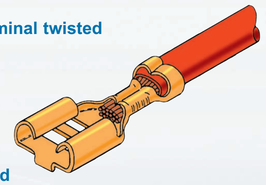
Cut off tab too long



Crimp barrel distorted

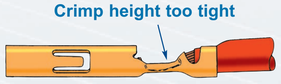


Terminal twisted

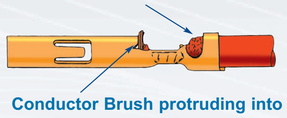


Cut off tab deformed

Crimp height too tight

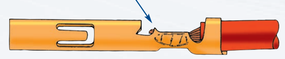


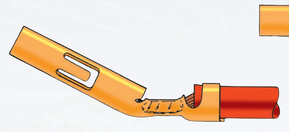
Insulation inside the wire crimp



Conductor Brush protruding into terminal body

Bellmouth on wrong end

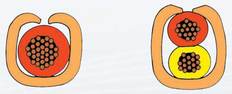




Terminal bend

INSULATION CRIMP

Insulation is pierced and could damage conductor

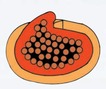


Insulation legs are not closed

Insulation material is pierced

Insulation is not securely held
Legs do not overlap

Insulation is not securely held

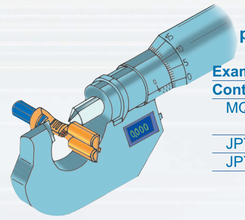


Insulation is over crimped

Test

WIRE CRIMP

Crimp height measurement



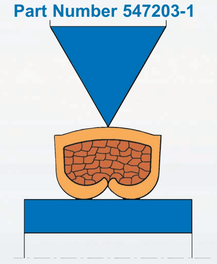
Crimp heights and tolerances

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 mm²	± 0,03 mm	114-18025
JPT	927775	0,50 - 1,00 mm²	± 0,05 mm	114-18050
JPT	927773	1,50 - 2,50 mm²	± 0,05 mm	114-18050

Digital crimp height micrometer (0.001mm increments) according to DIN ISO 9001
Part Number 547203-1



WIRE CRIMP

Incorrect applicator adjustment

Asymmetric crimp

Unacceptable formation excessive flash and/or cracks

Terminal feed incorrectly adjusted

Anvil and crimper not aligned or worn

Incorrect terminal / wire selection

Wire size to large

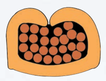
Wire size to small

Crimp barrel does not close

Legs too close to bottom of crimp. Insufficient deformation of strands, showing voids.

Incorrect crimp height adjustment

Crimp height too loose

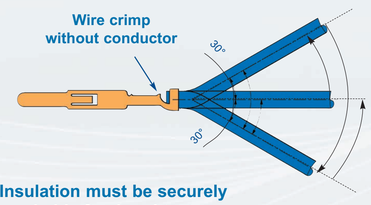


Crimp height too tight

Insufficient deformation, showing voids

Flash at under side of crimp, due to over crimping

INSULATION CRIMP



Insulation must be securely held after bend test

Training & Services

Please contact our service hotline for information.

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