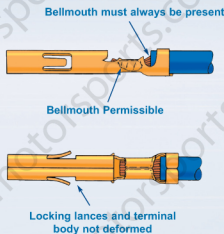
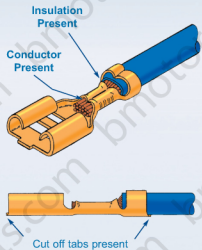


## Correct



### WIRE CRIMP

Correct selection of wire, terminal and applicator



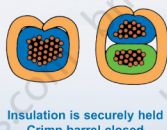
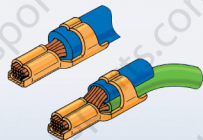
Crimp barrel is closed, legs support each other

Sufficient gap between legs and bottom of crimp

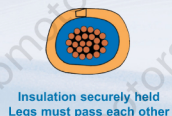
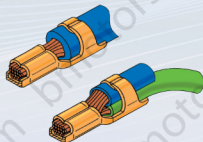
All strands are equally distributed and deformed

### INSULATION CRIMP

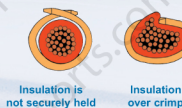
Correct Insulation Diameter, Applicator and Terminal.



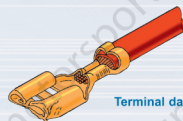
For double wire applications with different size wires always place wire with smallest outer diameter in the bottom.



### INSULATION CRIMP



## Incorrect

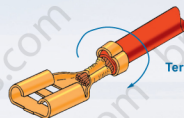


Terminal damaged

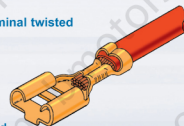


Crimp barrel distorted

Cut off tab too long



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



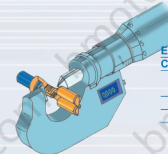
Terminal bend

## 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	0,20 - 0,50 mm²	± 0,03 mm	114-18025
	962886			
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

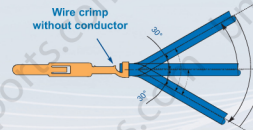


Insufficient deformation, showing voids

Flash at under side of crimp, due to over crimping

### INSULATION CRIMP

Wire crimp without conductor



Insulation must be securely held after bend test

## Training & Services