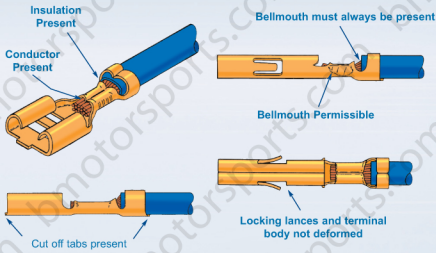


Correct



WIRE CRIMP

Correct selection of wire, terminal and applicator

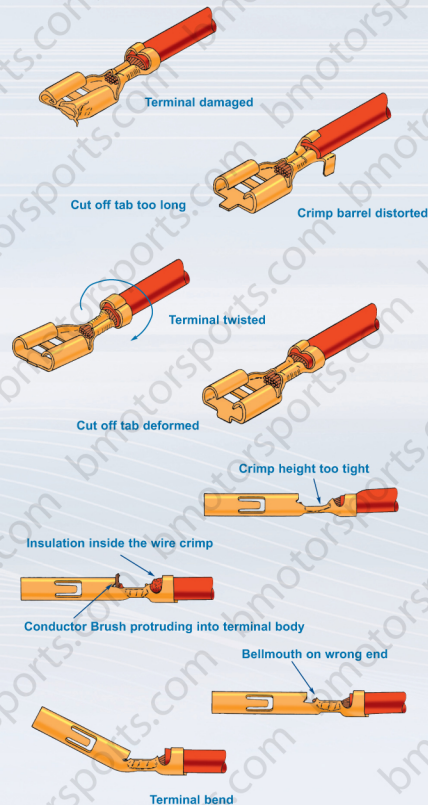


Crimp barrel is closed, legs support each other

Sufficient gap between legs and bottom of crimp

All strands are equally distributed and deformed

Incorrect



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