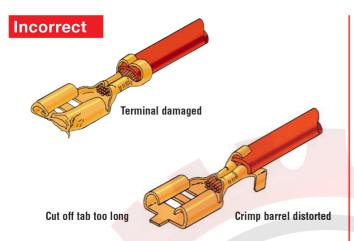
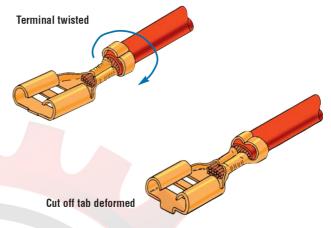
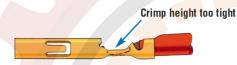
Quality Guidelines







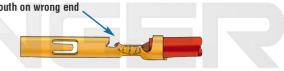
Insulation inside the wire crimp



Conductor Brush protruding into terminal body







INSULATION CRIMP









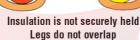


Insulation is over securely held crimped





Insulation legs are not closed



WIRE CRIMP

Incorrect applicator adjustment

Asymmetric crimp

Unacceptable formation excessive



Terminal feed incorrectly adjusted flash and/or cracks



Anvil and crimper not aligned or worn

Incorrect terminal/wire selection

Wire size too large



Crimp barrel does not close

Wire size too small



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

Incorrect crimp height adjustment

Crimp height too loose



Insufficient deformation, showing voids





Flash at under side of crimp, due to over crimping

Quality Guidelines

WIRE CRIMP Correct Bellmouth must always be present **Insulation Present Conductor Present Bellmouth Permissible** Locking lances and terminal Cut off tabs present body not deformed

Correct selection of wire, terminal and applicator





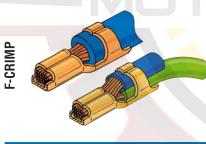
Crimp barrel is closed, legs support each other

Sufficient gap between legs and bottom of crimp

All strands are equally distributed and deformed

INSULATION CRIMP

Correct Insulation Diameter, Applicator and Terminal







Insulation is securely held Crimp barrel closed

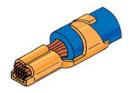
For double wire applications with different size wires always place wire with smallest outer diameter in the bottom







Insulation is securely held Legs overlap



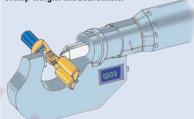


Insulation securely held Legs must pass each other

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:

| Con- tact | Part No. | Wire Range | Toler- ance | Appli- cation |
|--------------|-------------|---------------|----------------|------------------|
| | | (mm²) | (mm) | Spec. |
| MQS | 962885 | 0.2-0.5 | ±0.03 | 114-18025 |
| | 962886 | | | |
| JPT | 927775 | 0.5-1.0 | ±0.05 | 114-18050 |
| JPT | 927773 | 1.5-2.5 | ±0.05 | 114-18050 |

Digital Crimp Height Micrometer (0.001 mm increments) acc. to DIN ISO 9001 Part No. 547203-1



INSULATION CRIMP

