QUALITY CRIMPING GUIDELINES (VISUAL INSPECTION)

CORRECT

Wire Crimp
Correct selection of wire, terminal and tool. It is important that crimp barrel is closed, wings support each other and that there is a sufficient gap between wings and bottom of the crimp. (All strands needs to be deformed)

Terminal body not deformed.
Cut off tabs (Carrier cut off).

F-CRIMP / B-CRIMP
Correct wire (insulation diameter), tool and terminal. Insulation is securely surrounded. Insulation wings closed.

WRAP OVER CRIMP
Correct wire (insulation diameter), tool and terminal. Insulation wings must pass each other. Insulation wings too large. Insulation pierced (conductor can be damaged).

WRAP OVER CRIMP
Wrong crimp height. Insulation is not securely held. Insulation wings must pass each other.

WRAP OVER CRIMP
Insulation wings do not overlap. Crimp height too large.

WRAP OVER CRIMP
Insulation not securely held. Crimp height too large. Insulation pierced (conductor can be damaged).

OVERLAP CRIMP
Correct wire (insulation diameter), tool and terminal. Insulation wings overlap.

OVERLAP CRIMP
Insulation pierced (conductor can be damaged). Insulation wings not closed. Crimp height too large.

OVERLAP CRIMP
Insulation wings not closed. Crimp height too large. Insulation is securely surrounded. Insulation wings closed.

OVERLAP CRIMP
Insulation wings must pass each other. Insulation wings not deformed. Insulation is securely surrounded.

F-CRIMP / B-CRIMP
Correct wire (insulation diameter), tool and terminal. Insulation is securely surrounded. Insulation wings closed.

INSULATION CRIMP
Insulation wings not closed. Crimp height too large. Wings too close to the bottom. Crimp showing voids (wire size too small).

INSULATION CRIMP
Insulation wings closed. An overlap of insulation wings is not allowed. Insulation of one or two wires is not securely held.

WRAP OVER CRIMP
Insulation is not securely held. Crimp height too large. Crimp barrel distorted. Terminal twisted.

WIRE CRIMP

TANGLED CRIMP
Terminal damaged. Crimp barrel distorted. Terminal twisted. Insulation is not securely held.

WRAP OVER CRIMP
Insulation is not securely held. Crimp height too large.

WRAP OVER CRIMP
Insulation pierced (conductor can be damaged). Insulation wings closed. Insulation is securely surrounded.

WRAP OVER CRIMP
Insulation of one or two wires is not securely held. Insulation wings not closed. Crimp height too large.

WRAP OVER CRIMP
Insulation of one or two wires is not securely held. Insulation wings closed. An overlap of insulation wings is not allowed. Insulation wings not deformed. Insulation is securely surrounded.

WRAP OVER CRIMP
Insulation wings closed. An overlap of insulation wings is not allowed. Insulation wings not deformed. Insulation is securely surrounded.

WRAP OVER CRIMP
Insulation of one or two wires is not securely held. Insulation wings closed. An overlap of insulation wings is not allowed. Insulation wings not deformed. Insulation is securely surrounded.

CONTROL

1. Anvil
2. Measurement Tip
3. Crimp Height (CCH)
4. Crimp Width (CCW)

Consult individual specifications of each terminal type for crimp height and tolerances. CRIMP HEIGHT TESTING is a preferred testing method as it is quick, nondestructive and is critical for the termination’s electrical and mechanical reliability.

Test Values for PULLOUT TEST (Pull Force has only a minimum specification)

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<thead>
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<th>Conductor Size</th>
<th>Pull Force</th>
<th>UL486A</th>
<th>DIN EN60352</th>
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<td>(N)</td>
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Attention: Do not measure at burrs.

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