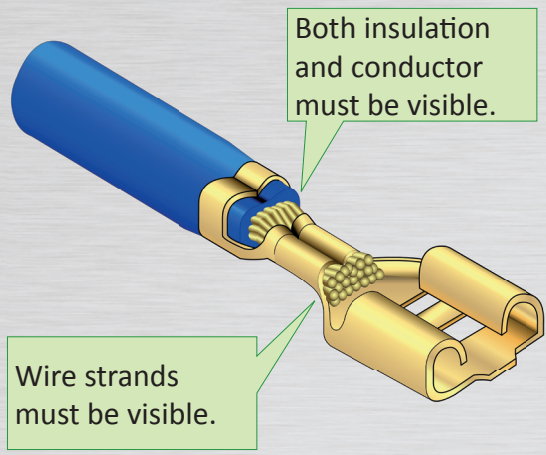
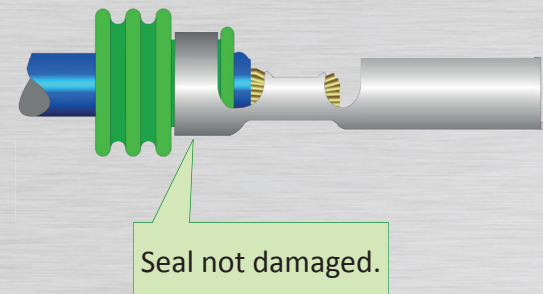
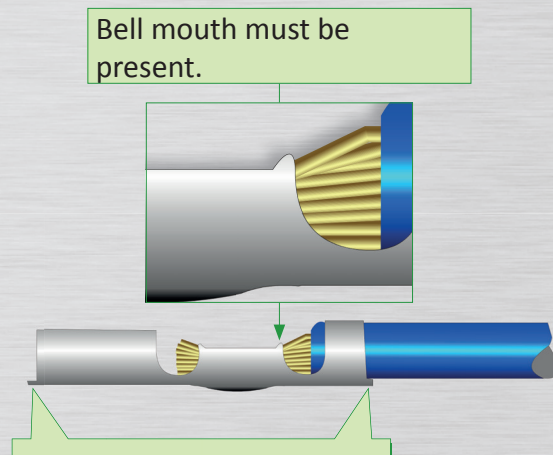


QUALITY CRIMPING GUIDELINES (VISUAL INSPECTION)

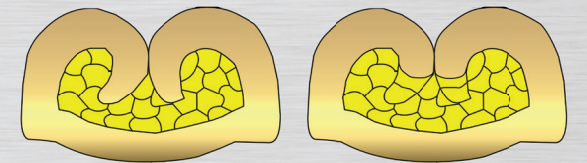
CORRECT



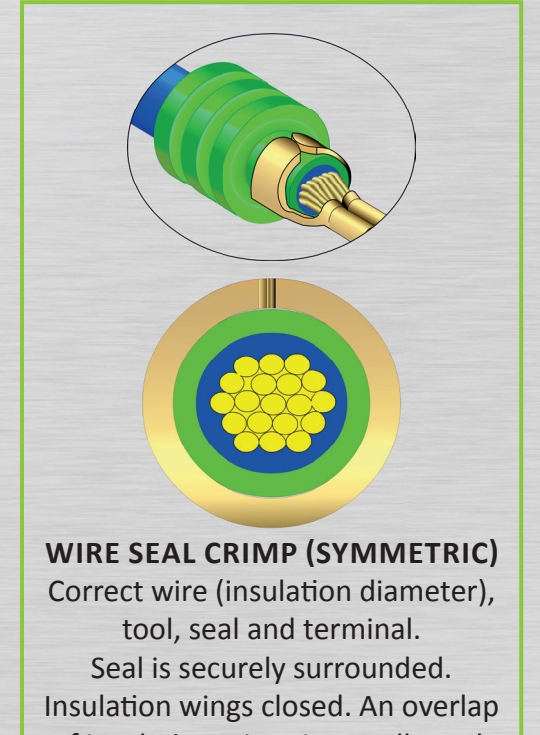
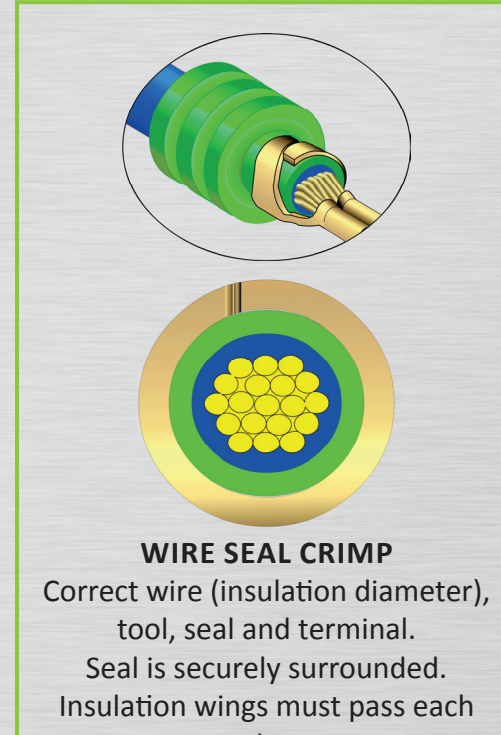
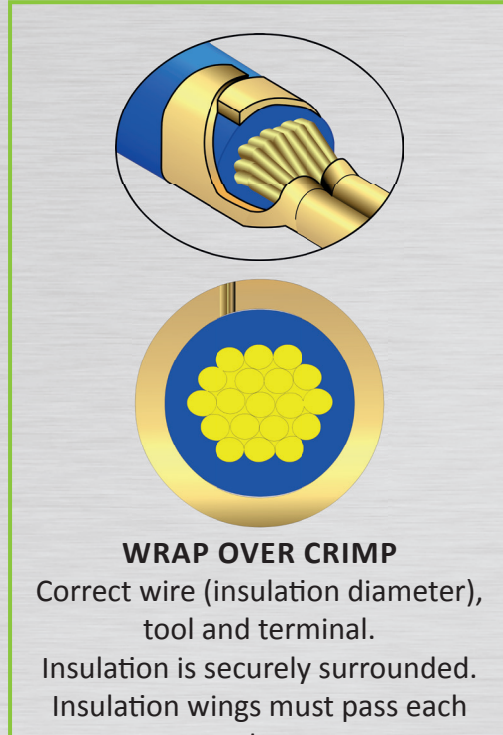
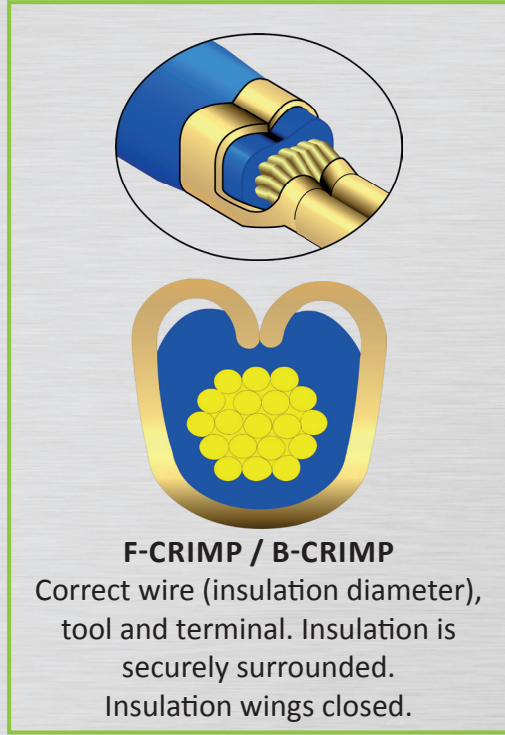
Terminal body not deformed.



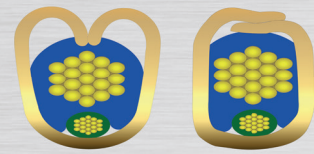
Wire Crimp
Correct selection of wire, terminal and tool.



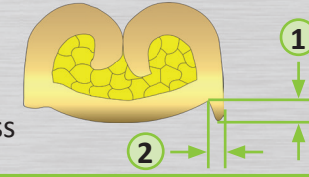
It is important that crimp barrel is closed, wings support each other and that there is a sufficient gap between wings and bottom of the crimp. (All strands needs to be deformed)



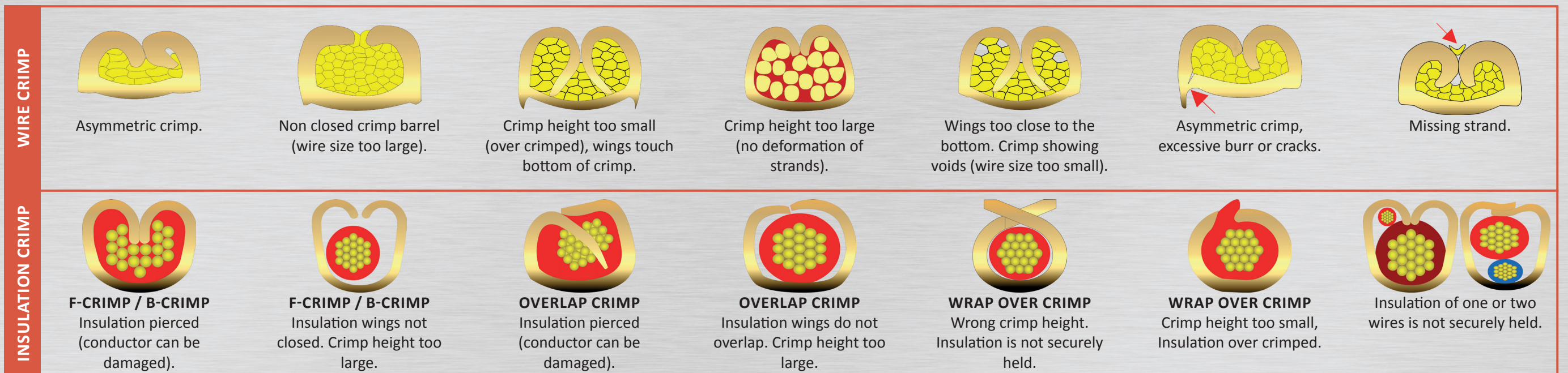
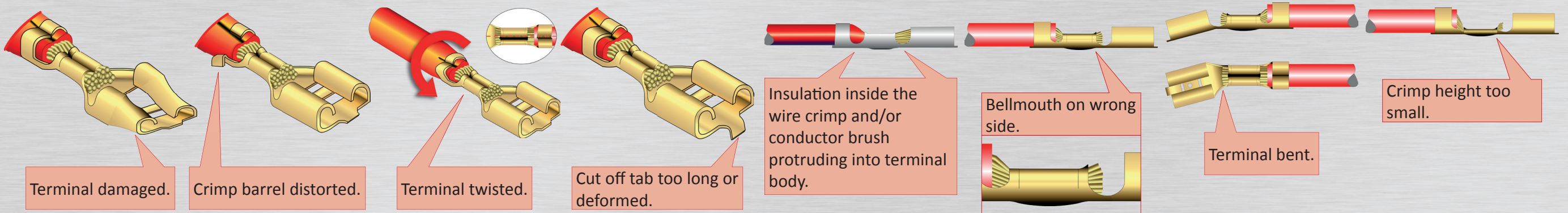
For double wire applications with different size wires always place wire with smallest outer diameter in the bottom.



Burr is acceptable as long as:
1) Burr height less than terminal material thickness
2) Burr width less than half of terminal material thickness

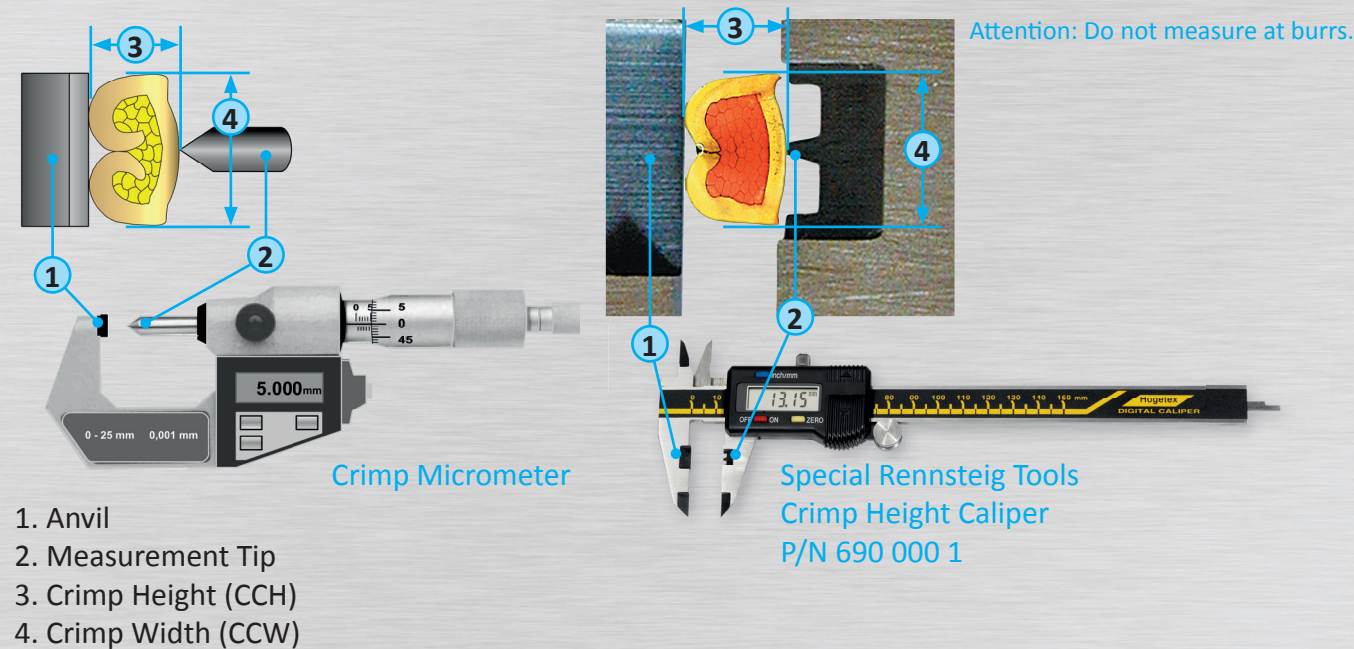


INCORRECT



CONTROL

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.

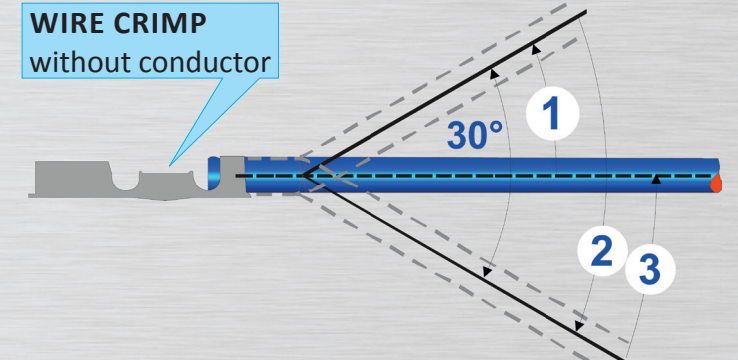


Test Values for PULLOUT TEST (Pull Force has only a minimum specification)

Conductor Size	Pullout Force	
	UL486A (N)	DIN EN60352 (N)
30	6.7	6
28	8.9	11
26	13.4	15
24	22.3	28
22	35.6	40
20	57.9	60
18	89	90
16	133.5	135
14	222.6	200
12	311.5	275
10	356	355
8	400.5	370

This summary is for reference only. Be sure to consult individual specifications before adopting these criteria.

WIRE CRIMP without conductor



The test takes place without tension. Insulation must be securely held after bent testing.



www.rennsteig.us