CRIMP QUALITY GUIDELINES

Good Crimp Quality

WIRE CRIMP
- Correct selection of wire, terminal and applicator
- Bellmouth must always be present
- Conductor present
- Insulation present
- Insulation is securely held. Crimp barrel closed.
- All strands are equally distributed and deformed.
- Sufficient gap between legs and bottom of crimp.

INSULATION CRIMP ‘F’
- Correct selection of wire, terminal and applicator
- Insulation present
- Insulation is securely held. Legs overlap.

INSULATION CRIMP ‘OVERLAP’
- Correct selection of wire, terminal and applicator
- Insulation present
- Insulation is securely held. Legs must pass each other.

INSULATION CRIMP ‘WRAP OVER’
- For double wire applications with different size wires: always place wire with smallest outer diameter in the bottom
- Insulation material is pierced

Incorrect Crimp Quality

WIRE CRIMP
- Incorrect crimp height
- Insulation is pierced and could damage conductor
- Incorrect selection of wire, terminal and applicator
- Incorrect applicator adjustment
- Asymmetric crimp
- Unacceptable formation
- Excessive flash and/or cracks
- Wire size too large
- Wire size too small
- Insuffi cient deformation, showing voids
- Crimp barrel is not closed
- Anvil and crimper not aligned or worn
- Leg is too close to bottom of crimp, insufficient deformation of strands, showing voids
- Insuffi cient deformation, showing voids
- Flash at underside of crimp, due to over crimping

INSULATION CRIMP ‘F’
- Insulation is not securely held.
- Insulation legs are not closed

INSULATION CRIMP ‘OVERLAP’
- Insulation is not securely held.
- Insulation material is pierced

INSULATION CRIMP ‘WRAP OVER’
- Insulation is not securely held.
- Insulation legs are not closed

All figures are schematic depictions. In every case, relevant product and application specification take precedence.

The above images of crimp failures are only shown as examples and are by no means exhaustive of all possible failures. In every case, relevant product and application specification take precedence.