

Correct		Incorrect		Test																					
<h3>WIRE CRIMP</h3> <p>Correct selection of wire, terminal and applicator</p> <p>Bellmouth must always be present</p> <p>Bellmouth Permissible</p> <p>Crimp barrel is closed, legs support each other</p> <p>Sufficient gap between legs and bottom of crimp</p> <p>All strands are equally distributed and deformed</p> <p>Insulation Present</p> <p>Conductor Present</p> <p>Cut off tabs present</p> <p>Locking lances and terminal body not deformed</p>		<h3>WIRE CRIMP</h3> <p>Terminal damaged</p> <p>Cut off tab too long</p> <p>Crimp barrel distorted</p> <p>Terminal twisted</p> <p>Cut off tab deformed</p> <p>Crimp height too tight</p> <p>Insulation inside the wire crimp</p> <p>Conductor Brush protruding into terminal body</p> <p>Bellmouth on wrong end</p> <p>Terminal bend</p>		<h3>WIRE CRIMP</h3> <p>Crimp height measurement</p> <p>Crimp heights and tolerances</p> <p>For crimp height tolerances for any given contact, please refer to the relevant application specification.</p> <p>Examples:</p> <table border="1"> <thead> <tr> <th>Contact</th> <th>P/N</th> <th>Wire Range</th> <th>Tolerance</th> <th>Application Spec.</th> </tr> </thead> <tbody> <tr> <td>MQS</td> <td>962885</td> <td>0,20 - 0,50 mm²</td> <td>± 0,03 mm</td> <td>114-18025</td> </tr> <tr> <td>JPT</td> <td>927775</td> <td>0,50 - 1,00 mm²</td> <td>± 0,05 mm</td> <td>114-18050</td> </tr> <tr> <td>JPT</td> <td>927773</td> <td>1,50 - 2,50 mm²</td> <td>± 0,05 mm</td> <td>114-18050</td> </tr> </tbody> </table> <p>Digital crimp height micrometer (0.001mm increments) according to DIN ISO 9001 Part Number 547203-1</p>		Contact	P/N	Wire Range	Tolerance	Application Spec.	MQS	962885	0,20 - 0,50 mm ²	± 0,03 mm	114-18025	JPT	927775	0,50 - 1,00 mm ²	± 0,05 mm	114-18050	JPT	927773	1,50 - 2,50 mm ²	± 0,05 mm	114-18050
Contact	P/N	Wire Range	Tolerance	Application Spec.																					
MQS	962885	0,20 - 0,50 mm ²	± 0,03 mm	114-18025																					
JPT	927775	0,50 - 1,00 mm ²	± 0,05 mm	114-18050																					
JPT	927773	1,50 - 2,50 mm ²	± 0,05 mm	114-18050																					
<h3>INSULATION CRIMP</h3> <p>Correct Insulation Diameter, Applicator and Terminal.</p> <p>F-CRIMP</p> <p>Insulation is securely held</p> <p>Crimp barrel closed</p>		<h3>INSULATION CRIMP</h3> <p>Insulation is pierced and could damage conductor</p> <p>Insulation legs are not closed</p>		<h3>INSULATION CRIMP</h3> <p>Asymmetric crimp</p> <p>Unacceptable formation excessive flash and/or cracks</p> <p>Terminal feed incorrectly adjusted</p> <p>Anvil and crimper not aligned or worn</p>																					
<h3>OVERLAP CRIMP</h3> <p>For double wire applications with different size wires always place wire with smallest outer diameter in the bottom.</p> <p>Insulation is securely held</p> <p>Legs overlap</p>		<h3>INSULATION CRIMP</h3> <p>Insulation material is pierced</p> <p>Insulation is not securely held</p> <p>Legs do not overlap</p>		<h3>INSULATION CRIMP</h3> <p>Wire crimp without conductor</p> <p>Insulation must be securely held after bend test</p>																					
<h3>WRAP OVER CRIMP</h3> <p>Insulation securely held</p> <p>Legs must pass each other</p>		<h3>INSULATION CRIMP</h3> <p>Insulation is not securely held</p> <p>Insulation is over crimped</p>		<h3>WIRE CRIMP</h3> <p>Incorrect terminal / wire selection</p> <p>Wire size to large</p> <p>Wire size to small</p> <p>Crimp barrel does not close</p> <p>Legs too close to bottom of crimp. Insufficient deformation of strands, showing voids.</p> <p>Incorrect crimp height adjustment</p> <p>Crimp height too loose</p> <p>Crimp height too tight</p> <p>Insufficient deformation, showing voids</p> <p>Flash at under side of crimp, due to over crimping</p>																					
<h3>Training & Services</h3> <p>Please contact our service hotline for information.</p> <p>Tel: 1-800-722-1111</p>																									