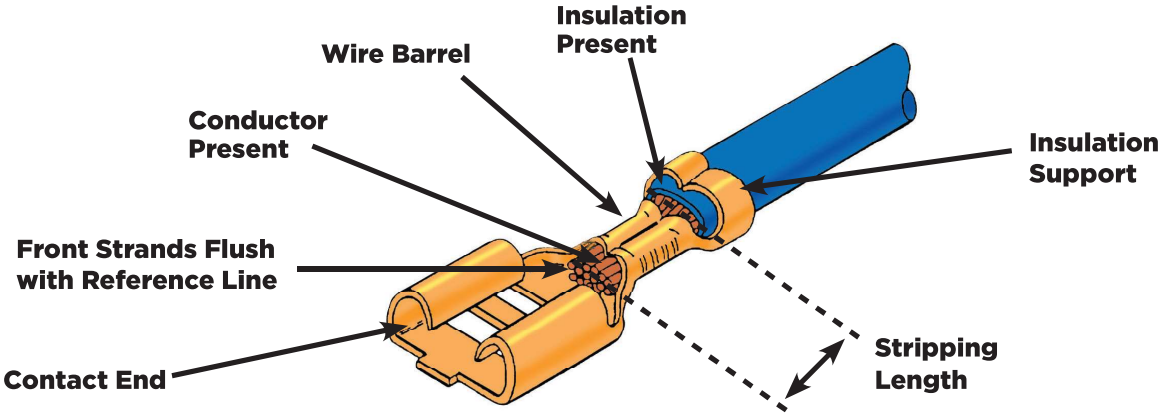
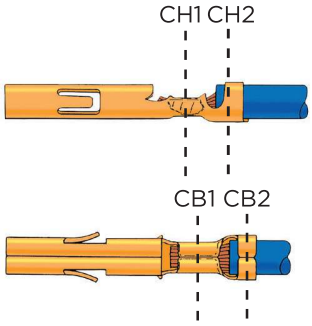
The Secret to a Successful Crimp

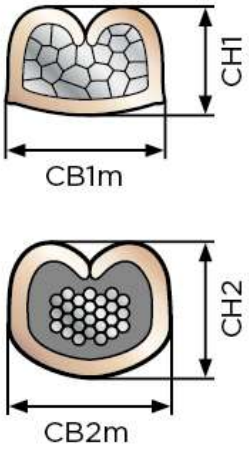
Wire Prep - In order to properly place a wire in a terminal, the wire insulation must first be stripped to the proper length based on the terminal specifications. If the insulation is cut too short or too long, the wire will not be seated properly into the wire barrel, causing terminal separations or shorting.

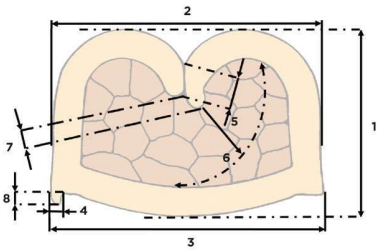


Crimp Specifications - To ensure a proper crimp for a TE connector or terminal you should be using a TE Connectivity tooling solution that is specifically engineered to the proper Crimp Height, Width, and Crimp Geometry of the selected terminal or contact.



CH2: Insulation crimp height
CH1: Conductor crimp height
CB2m: Insulation crimp width
CB1m: Condutor crimp width





Dimensions of a conductor crimp

Selecting the Right Tool Based on Production Level - Are you in the prototype phase of your project? Will you soon be ramping up production? Do your tools need to be mobile, or is a bench top unit more applicable? Are you producing 100's - 1,000's of crimps per day?

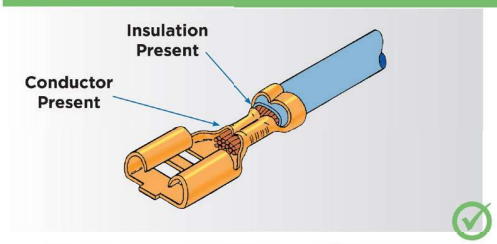
Once you know the answers to these questions, selecting the right TE Connectivity tool to meet your needs is simple. (**Please refer to pages 4-5 for tooling options.**)

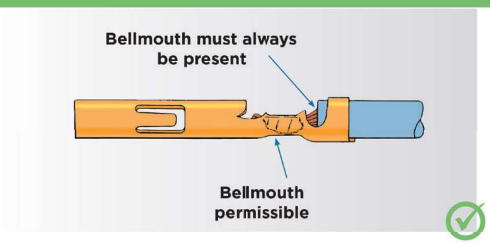
www.tooling.te.com

CRIMP QUALITY GUIDELINES

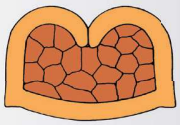
Good Crimp Quality

WIRE CRIMP

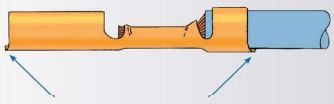


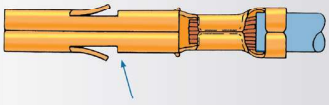


Correct selection of wire, terminal and applicator

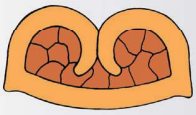


Crimp barrel is closed, legs support each other. All strands are equally distributed and deformed.





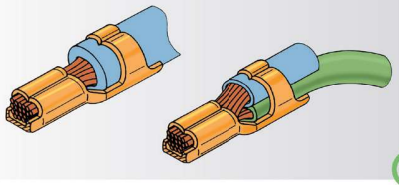
Correct selection of wire, terminal and applicator



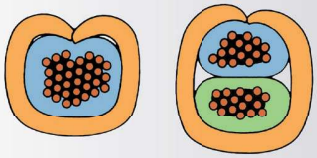
Sufficient gap between legs and bottom of crimp. All strands are equally distributed and deformed.

INSULATION CRIMP 'F'

Correct selection of wire, terminal and applicator

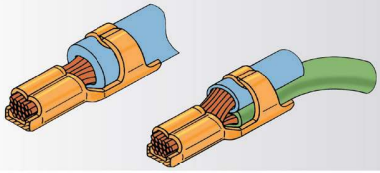


Insulation is securely held. Crimp barrel closed.

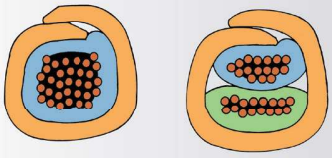


INSULATION CRIMP 'OVERLAP'

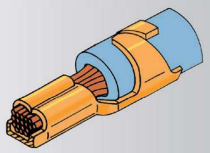
For double wire applications with different size wires always place wire *with smallest* outer diameter in the bottom



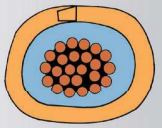
Insulation is securely held. Legs overlap.



INSULATION CRIMP 'WRAP OVER'



Insulation is securely held. Legs must pass each other.

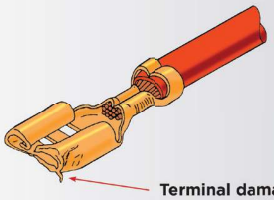


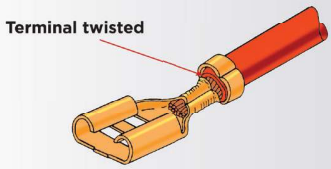
Correct

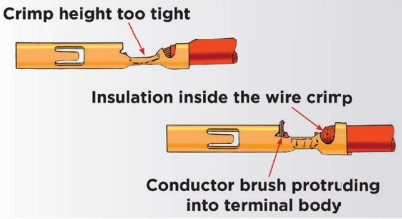
Incorrect

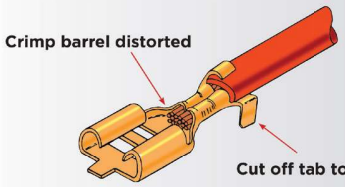
Incorrect Crimp Quality

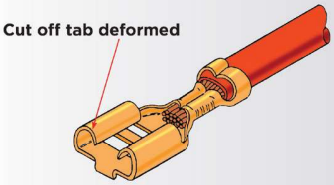
WIRE CRIMP

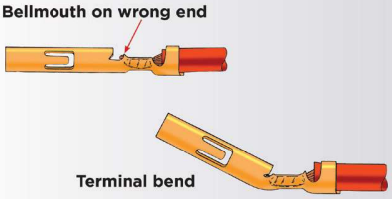


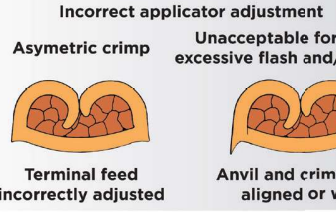


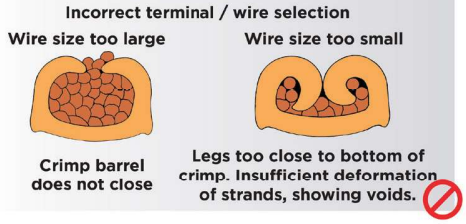


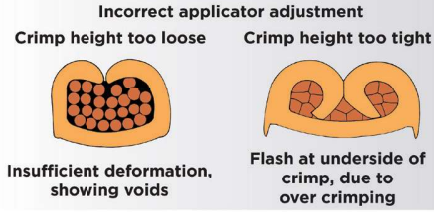




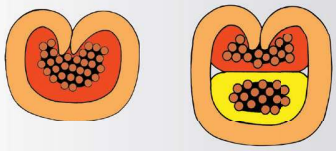


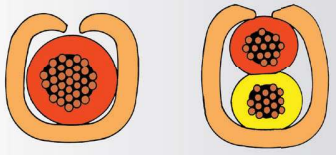




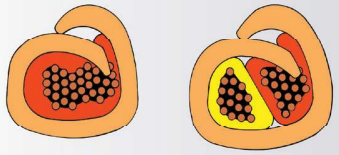


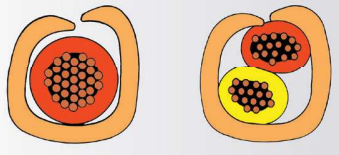
INSULATION CRIMP 'F'



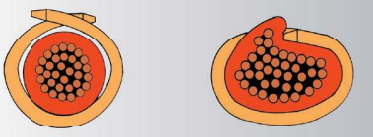


INSULATION CRIMP 'OVERLAP'





INSULATION CRIMP 'WRAP OVER'



Training & Service

Please contact our service hotline for information.
Tel: 1.800.722.1111

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.

Dangers of Improperly Crimped Terminals

From wasted time & scrap all the way up to product recalls and possible litigation, the cost of poor crimp quality can be expensive. If customers are not using the proper crimp tooling, ie. incorrectly matching the terminal to the crimp tooling, the end results can be dramatic.