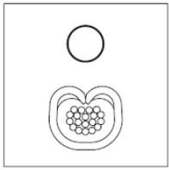
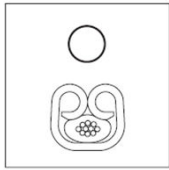
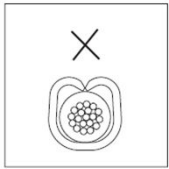
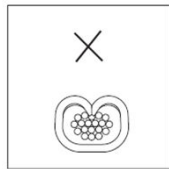
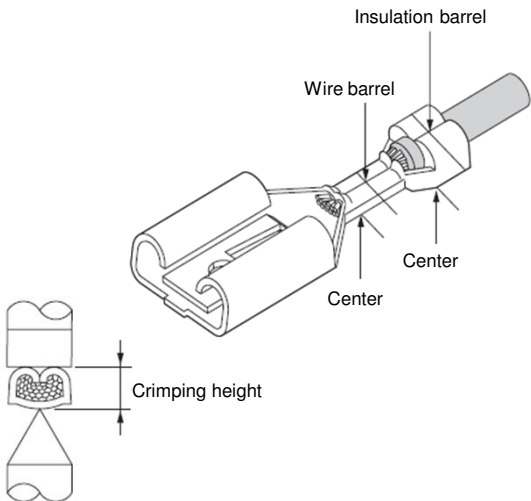


The Right Crimp

Insulation

	
• Good	• Good
	
<ul style="list-style-type: none"> • Insufficient crimping • Wire insulation is easily pulled from the terminal when applying tension to the wire 	<ul style="list-style-type: none"> • Excessive crimping • The barrel edges cut into the wire & damage the conductors


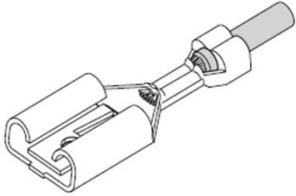

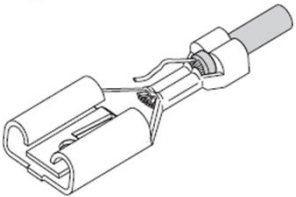
Measuring Points



Labels in diagram: Insulation barrel, Wire barrel, Center, Center, Crimping height.


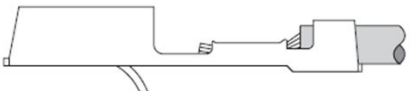

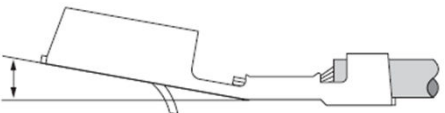

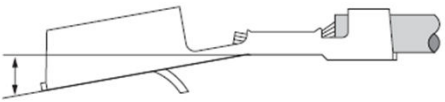
Uncrimped Conductor

Check that there are no uncrimped conductors at the wire barrel.

 Good	
 Uncrimped conductor	


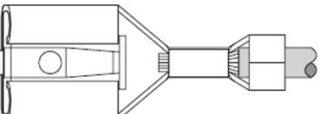

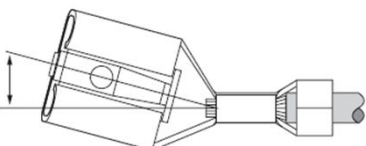

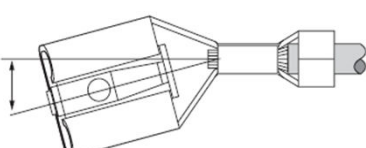
Bend Up & Bend Down

Check the angle of bend up or bend down at the wire barrel.

 Good	
 Bend up	
 Bend down	


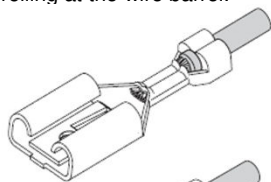

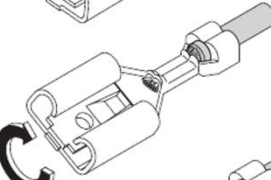

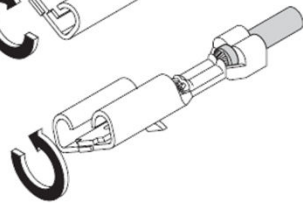
Twist

Check the angle of twist at the wire barrel.

 Good	
 Twist	
 Twist	

Rolling

Check the angle of rolling at the wire barrel.

 Good	
 Rolling	
 Rolling	

The Right Crimp

Bell-mouth

Check bell-mouth size.

Good

No bell-mouth

Too much bell-mouth

Cut-off Length

Check cut-off length.

Good

No cut-off length

Too much cut-off length

Wire Conductor Protruding Length

Conductor protruding length

Good

Conductors protrude excessively

Conductors do not protrude enough

Wire Insulation Protruding Length

Wire insulation protruding Position approx. 50/50

Good

Wire insulation is crimped at the wire barrel

Wire insulation is incompletely crimped at the insulation barrel