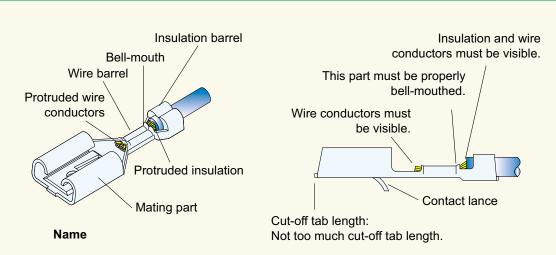


Check-points for correct Crimping







Cross section at crimped part

Wire barrel

Seam must be closed.





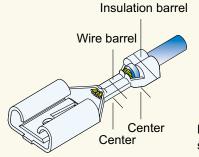
Insulation barrel

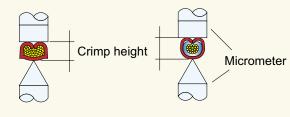


Wire must be securely held.



Crimp height measurement

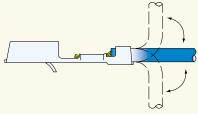




Note: Set crimp height at wire conductor part within the range of

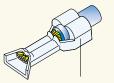
Crimp height at insulation part is a reference value. Check it according to the following method.

Check of insulation part

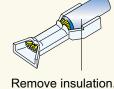


As a guide of crimped insulation, insulation must not be easily loosened due to upside-down bending of wire.

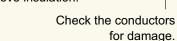
Cut off only wire insulation barrel, remove wire insulation and check wire conductors for damage.





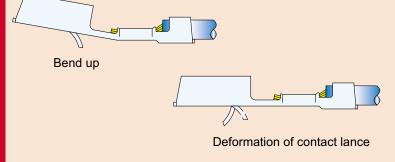






Incorrec t crimping

Appearance defect

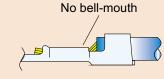


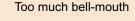


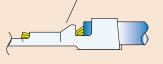
Bend down











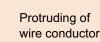
Cross section at crimped part of wire barrel



Opening of seam

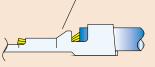






Bell-mouth





Cross section at crimped part of insulation barrel







Insufficient crimping Insulation is not securely held. Insulation barrel length is short.







Excessive crimping

Insulation is excessively pressed. Wire conductors have damage or deformation.

Wire conductors protruding length

Conductors protrude excessively.



Conductors do not protrude enough.

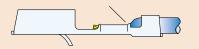
Uncrimped conductor



Wire insulation protruding length

Deformation of mating part

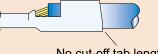
Wire insulation is crimped at the wire barrel.



Wire insulation is incompletely crimped at the insulation barrel.



Cut-off tab length



No cut-off tab length



Too much cut-off tab length