Check-points for correct Crimping

Be sure to check the following points, before beginning work each day.

Correct crimping

- Bell-mouth
- Wire barrel
- Insulation barrel
- Protruded wire conductors
- Protruded insulation
- Mating part

Incorrect crimping

- Appearance defect
- Cross section at crimped part of wire barrel
- Cross section at crimped part of insulation barrel

Cross section at crimped part

- Wire barrel: Seam must be closed.
- Insulation barrel: Wire must be securely held.

Crimp height measurement

- Insulation barrel
- Wire barrel
- Crimp height
- Micrometer
- Center

Check of insulation part

- Cut off only wire insulation barrel, remove wire insulation and check wire conductors for damage.
- As a guide of crimped insulation, insulation must not be easily loosened due to upside-down bending of wire.
- Cut insulation barrel.
- Remove insulation.
- Check the conductors for damage.

Wire conductors protruding length

- Conductor protrudes excessively.
- Conductor do not protrude enough.

Wire insulation protruding length

- 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