

Crimp Quality Guidelines



Correct

WIRE CRIMP

Correct selection of wire, terminal and applicator

Bellmouth must always be present

Bellmouth Permissible

Crimp barrel is closed, legs support each other

Sufficient gap between legs and bottom of crimp

All strands are equally distributed and deformed

Insulation Present

Conductor Present

Cut off tabs present

Locking lances and terminal body not deformed

Incorrect

Terminal damaged

Cut off tab too long

Crimp barrel distorted

Terminal twisted

Cut off tab deformed

Crimp height too tight

Insulation inside the wire crimp

Conductor Brush protruding into terminal body

Bellmouth on wrong end

Terminal bend

Test

WIRE CRIMP

Crimp height measurement

Crimp heights and tolerances

For crimp height tolerances for any given contact, please refer to the relevant application specification.

Contact	P/N	Wire Range	Tolerance	Application Spec.
MQS	962885	0.20 - 0.50 mm ²	± 0.03 mm	114-18025
	962886			
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

Digital crimp height micrometer (0.001mm increments) according to DIN ISO 9001 Part Number 547203-1

INSULATION CRIMP

Correct Insulation Diameter, Applicator and Terminal.

F-CRIMP

Insulation is securely held Crimp barrel closed

OVERLAP CRIMP

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

Insulation is securely held Legs overlap

WRAP OVER CRIMP

Insulation securely held Legs must pass each other

INSULATION CRIMP

Insulation is pierced and could damage conductor

Insulation legs are not closed

Insulation material is pierced

Insulation is not securely held Legs do not overlap

Insulation is not securely held

Insulation is over crimped

WIRE CRIMP

Incorrect applicator adjustment

Asymmetric crimp

Unacceptable formation excessive flash and/or cracks

Terminal feed incorrectly adjusted

Anvil and crimper not aligned or worn

Incorrect terminal / wire selection

Wire size to large

Wire size to small

Crimp barrel does not close

Legs too close to bottom of crimp.

Insufficient deformation of strands, showing voids.

Incorrect crimp height adjustment

Crimp height too loose

Crimp height too tight

Insufficient deformation, showing voids

Flash at under side of crimp, due to over crimping

INSULATION CRIMP

Wire crimp without conductor

Insulation must be securely held after bend test

Training & Services

Please contact our service hotline for information.

Tel: 1-800-722-1111

Tyco Electronics has tooling to meet your crimping needs.

Crimp Quantities



Low Volume

High Volume

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