Check-points for correct Crimping

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

**Correct crimping**
- Bell-mouth
- Wire barrel
- Protruded wire conductors
- Insulation barrel
- Mating part
- Protruded insulation
- Insulation must be visible.
- Wire conductors must be visible.
- Contact lance
- Cut-off tab length:
  - Not too much cut-off tab length.

**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
- Note: Set crimp height at wire conductor part within the range of specified value.
  - Crimp height at insulation part is a reference value.
  - Check it according to the following method.

**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.

**Incorrect crimping**
- Appearance defect
- Cross section at crimped part of wire barrel
  - Bend up
  - Deformation of contact lance
  - Large burr
  - Opening of seam
- Cross section at crimped part of insulation barrel
  - One-sided burr
  - Protruding of wire conductor
  - 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.
- Wire insulation is cramped at the wire barrel.
- Wire insulation protruding length
- Conductors do not protrude enough.
- Wire insulation is incompletely cramped at the insulation barrel.

**Cut-off tab length**
- No cut-off tab length
- Too much cut-off tab length