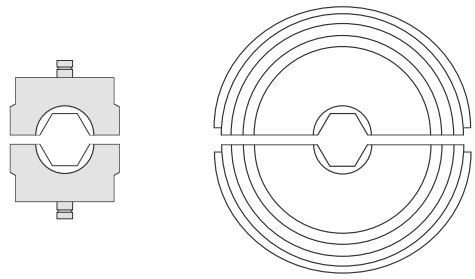
GOOD PRACTICE - CRIMPING GUIDE

TOOLING

First, select the correct crimping tool from our comprehensive range of tooling. The range includes heavy duty, ratchet and hydraulic options. Then select the correct die.

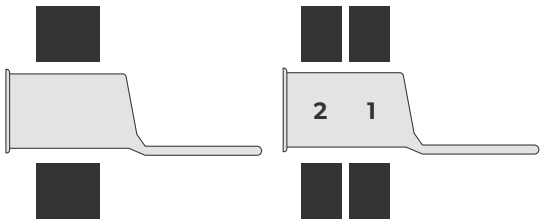
Use only matched die marked with terminal wire size. Fit the die to the tool ensuring that both die have the same size crimp cavities.



ASSEMBLY

Insert wire into terminal - with hand tools it may be convenient to grip the terminal lightly while doing so.

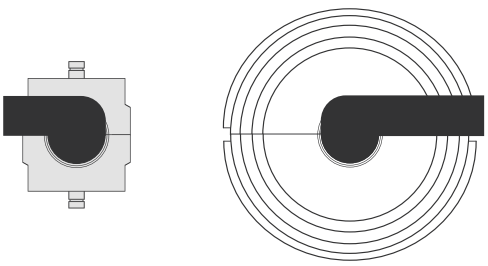
Check tool instructions for whether one or two crimps are required and position the terminal between die as shown. For double crimps - crimp in order 1,2, etc.



CRIMP

Operate the tool fully until full crimp pressure is achieved. This will be shown by operation of the pressure release valve and closure of the die faces. Refer to the tool manual for more details.

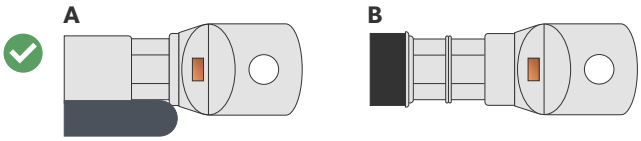
Operate the pressure release valve and remove the crimped terminal. Repeat the process if two or more crimps are required.



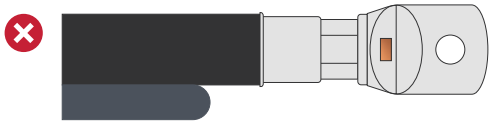
INSPECTION

The completed crimp should look like these examples.

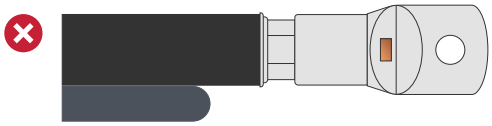
A - Wire seen in correct position through site hole.
B - Correct die reference embossed upon crimp area relates to terminal reference and wire size.



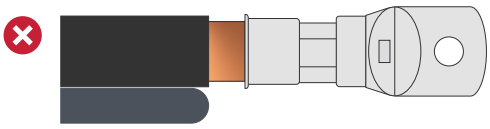
The following are examples of bad practice:



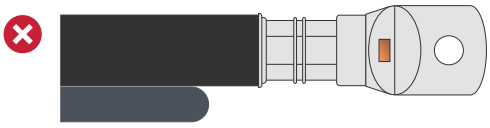
Crimped too near the palm



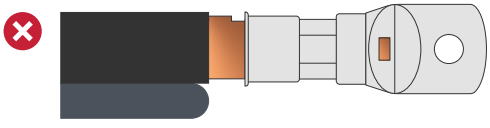
Crimped too far from the palm



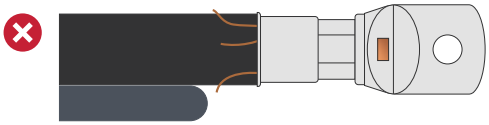
Conductor not fully inserted



Two crimps overlapping



Conductor damaged



Loose strands not crimped

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