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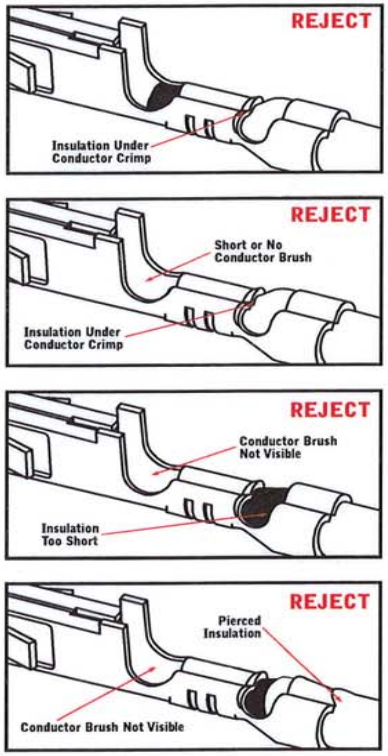
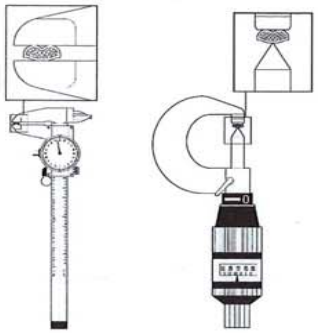
VISUAL INSPECTION OF CRIMPED TERMINALS

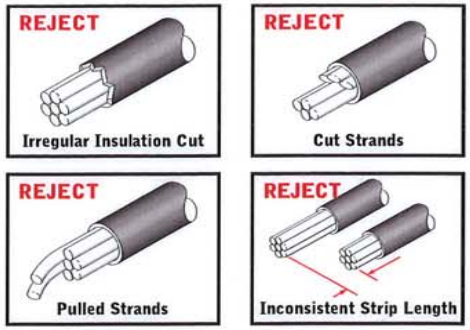
Examples



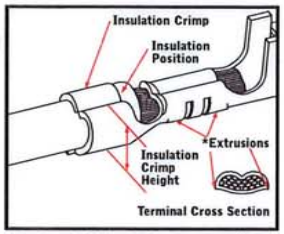
Measurement of Crimp Height



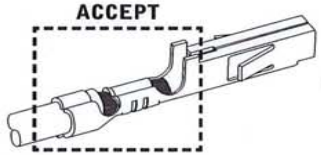
Improper Wire Preparation



Optimal Crimp

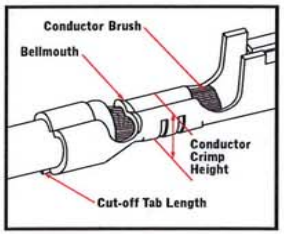


* Extrusions should be minimal or non-existent. When a minimal extrusion exists, it should not exceed below the bottom of the terminal.

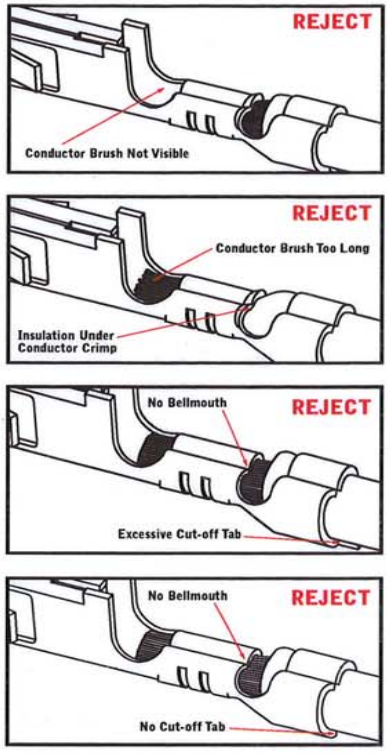


Crimp Height Testing

1. Complete tool set-up procedure.
2. Crimp a minimum of 5 samples.
3. Place the flat blade of the crimp micrometer across the center of the dual radii of the conductor crimp. Do not take measurement near the conductor bellmouth.
4. Rotate the micrometer dial until the point contacts the bottom most radial surface. If using a caliper, be certain not to measure the extrusion points of the crimp.
5. Record crimp height readings. A minimum of 5 crimp height readings are necessary to confirm each set-up. A minimum of 30 readings are necessary to determine capability.
6. Check crimp height every 250 to 500 parts throughout the run.



Examples



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