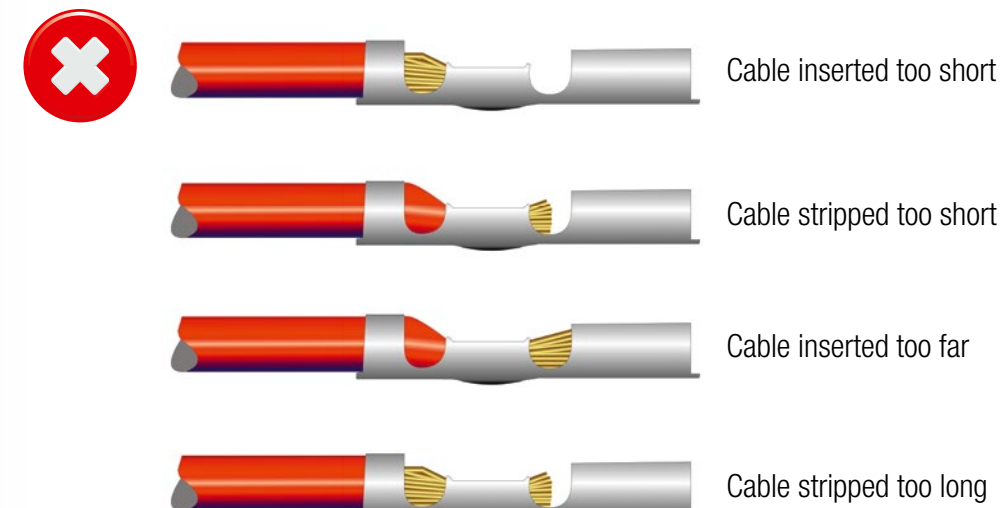
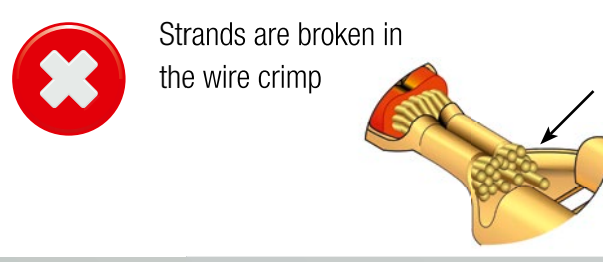
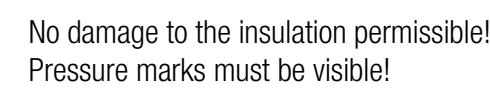
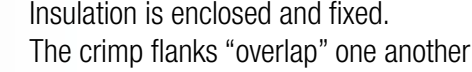
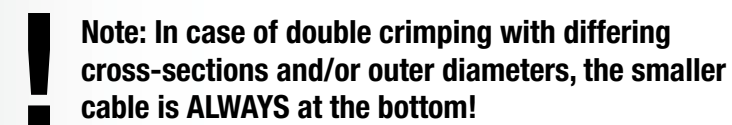
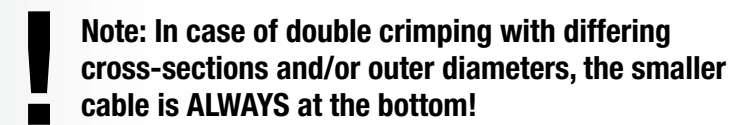


Insulation crimping



The insulation is not stripped, but only inserted in the insulation crimp zone and crimped.
The 30° deflection is applied without extraction force.

Note: It is not sufficient to simply measure the conductor extraction force, as it could have the same value for different compression levels! Inspection of the crimp dimensions is required!

Nominal conductor cross-section mm ²	Nominal size (plug width)				Extraction force (N) min.	
					Nominal size 2.8	Nominal size 4.8–9.5
0.14	2.8				20	20
0.25	2.8				40	40
0.50	2.8	4.8	6.3		60	80
0.75	2.8	4.8	6.3		70	120
1.00	2.8	4.8	6.3		80	160
1.50		4.8	6.3			200
2.50		4.8	6.3			250
4.00			6.3	9.5		350
6.00			6.3	9.5		500
For different conductor cross sections the lower extraction force is definitive in each case. The extraction force for the nominal size 2.8 arises from the lower material thickness. Except: DIN 46 249 Part 1.						
Extraction forces in accordance with SEN 245010: The SEN 245010 standard applies the most stringent QA requirements for a crimp connection in international comparison					Cross-section 0.75–50 mm ² –95 mm ² over 95 mm ²	Extraction force 150 N per mm ² 120 N per mm ² 100 N per mm ²

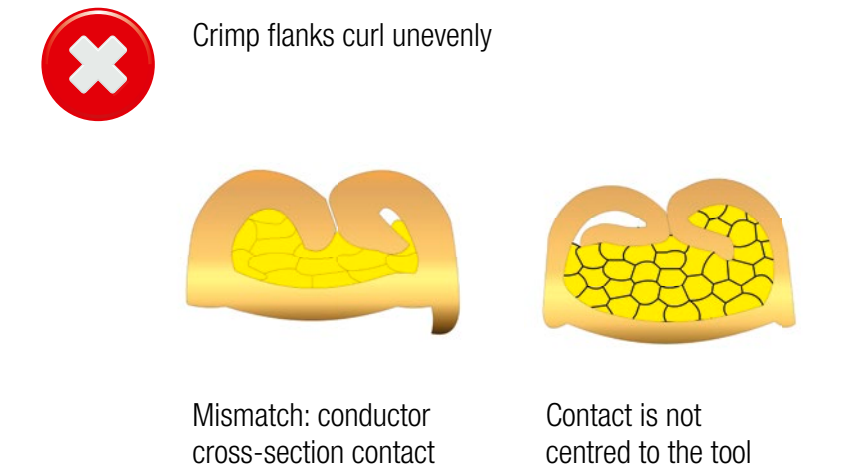
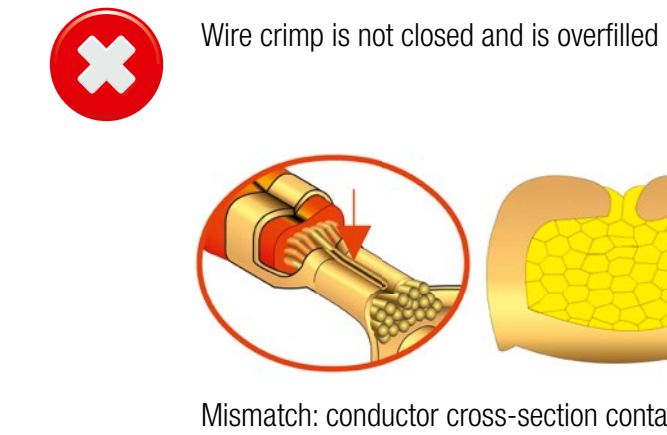
Crimp flanks are closed, support each other and are uniformly curled

Asymmetry:
Max. material thickness

Min. half material thickness

Burr height less than material thickness

Burr height less than half material thickness



Transition damaged

Note: Crimp contacts with damaged, bent and deformed functional zones (snap locks etc.) must NOT be “straightened out” and must always be disposed of as “bad parts”!

! Crimp dimensions and tolerances for the crimp contact under test are to be taken from the relevant processing specification!

