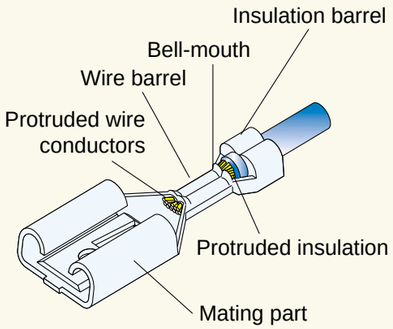
JST

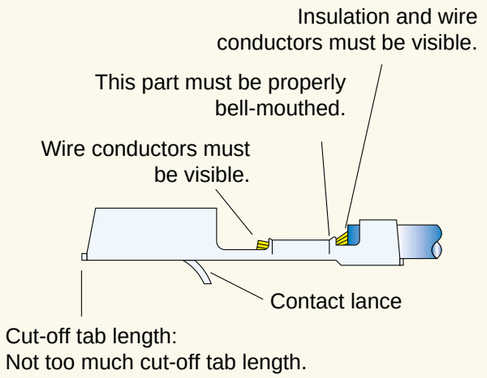
Check-points for correct Crimping

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

Correct crimping



Name



Cross section at crimped part

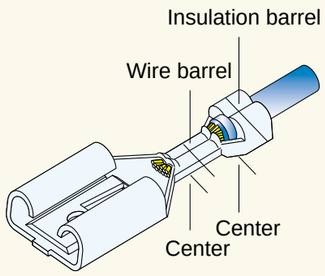
Wire barrel

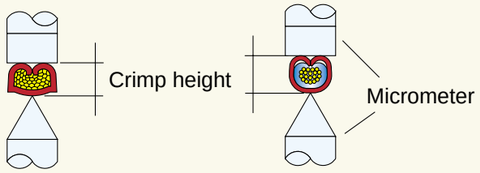
Seam must be closed.

Insulation barrel

Wire must be securely held.

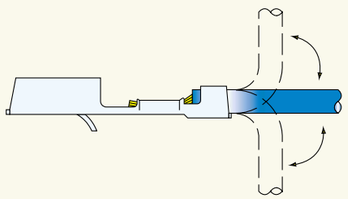
Crimp height measurement





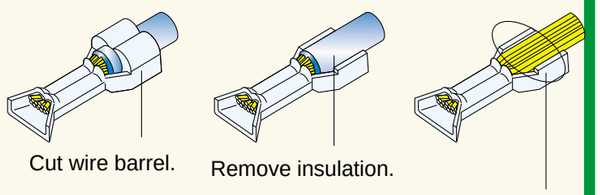
Note: Set crimp height at wire conductor part within the range of specified value.
Crimp height at insulation part is a reference value. Check it according to the following method.

Check of insulation part



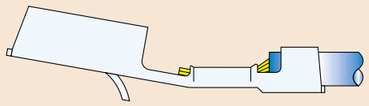
As a guide of crimped insulation, insulation must not be easily loosened due to upside-down bending of wire.

Cut off only wire insulation barrel, remove wire insulation and check wire conductors for damage.

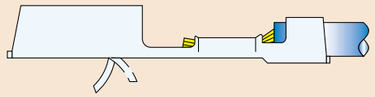


Incorrec t crimping

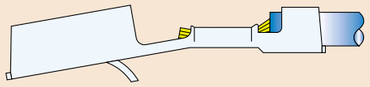
Appearance defect



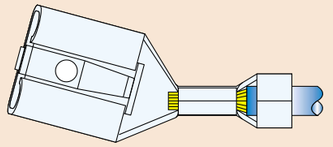
Bend up



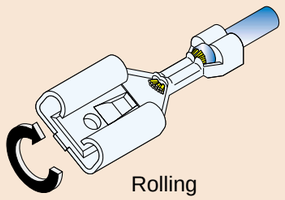
Deformation of contact lance



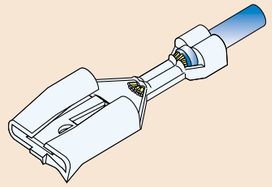
Bend down



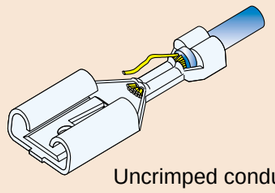
Twist



Rolling



Deformation of mating part



Uncrimped conductor

Cross section at crimped part of wire barrel

Large burr

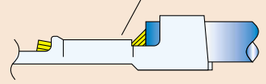
Opening of seam

One-sided burr

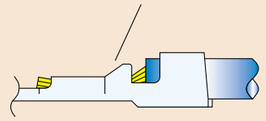
Protruding of wire conductor

Bell-mouth

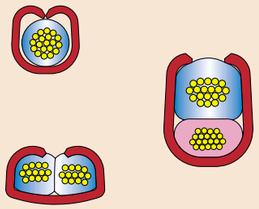
No bell-mouth



Too much bell-mouth

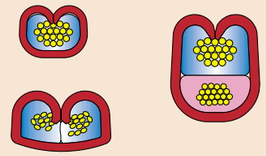


Cross section at crimped part of insulation barrel



Insufficient crimping

Insulation is not securely held.
Insulation barrel length is short.

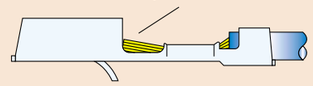


Excessive crimping

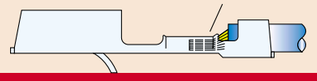
Insulation is excessively pressed.
Wire conductors have damage or deformation.

Wire conductors protruding length

Conductors protrude excessively.

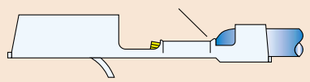


Conductors do not protrude enough.

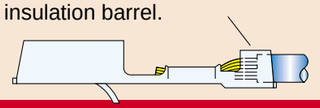


Wire insulation protruding length

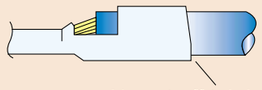
Wire insulation is crimped at the wire barrel.



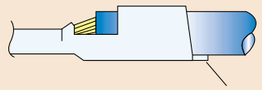
Wire insulation is incompletely crimped at the insulation barrel.



Cut-off tab length



No cut-off tab length



Too much cut-off tab length