

# Quality Assurance with Schleuniger

## Crimp Quality Control Criteria

	Insulation Crimp	Wire Crimp
Good		
Conditional Approval		
Bad		

Width of flash max. 1/2 of material thickness

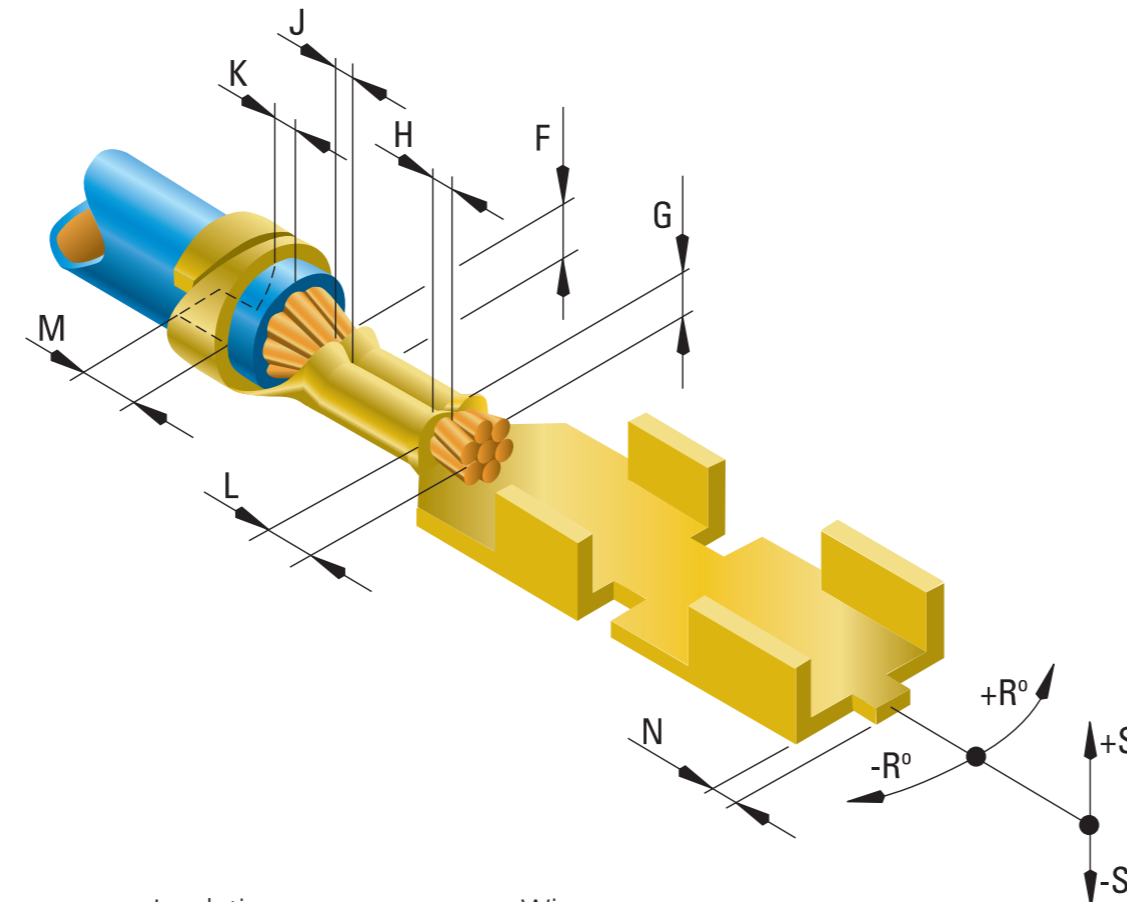
Flange distance to base min. 1/2 of material thickness

Terminal material broken

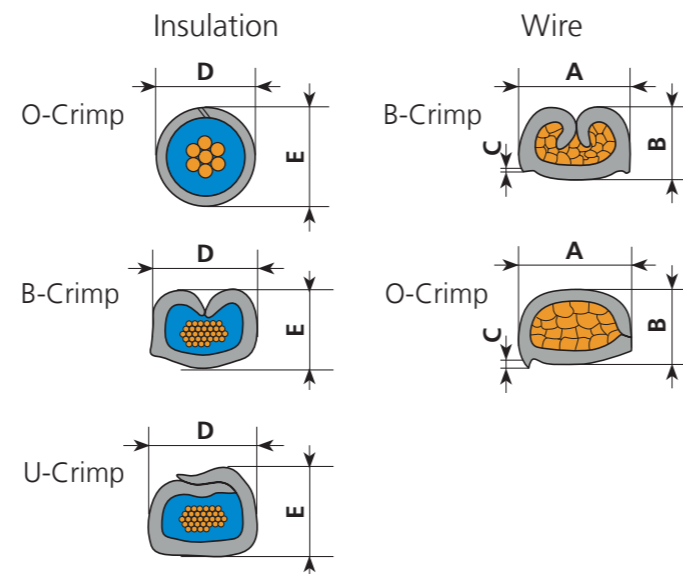
Distributor .....

### Processing Specifications

#### Crimping Terms



- A. wire crimp width
- B. wire crimp height
- C. flash
- D. insulation crimp width
- E. insulation crimp height
- F. rear bellmouth height
- G. front bellmouth height
- H. front bellmouth length
- J. rear bellmouth length
- K. end of insulation
- L. wire brush
- M. insulation barrel length
- N. cut-off-tab (front and back)
- O. strip length
- P. insulation diameter
- R. terminal bent left/right
- S. terminal bent upward/downward



#### Conversion Chart for Conductors

AWG	Conductor Diameter		Conductor Cross Section	
	Inches	mm	sq. Inches	mm <sup>2</sup>
32	0,00795	0,202	0,000050	0,032
31	0,00893	0,227	0,000063	0,040
30	0,01003	0,255	0,000079	0,051
29	0,01126	0,286	0,000100	0,064
28	0,01264	0,321	0,000125	0,081
27	0,01420	0,361	0,000158	0,102
26	0,01594	0,405	0,000200	0,129
25	0,01790	0,455	0,000252	0,162
24	0,02010	0,511	0,000317	0,205
23	0,02257	0,573	0,000400	0,258
22	0,02535	0,644	0,000505	0,326
21	0,02846	0,723	0,000636	0,410
20	0,03196	0,812	0,000802	0,518
19	0,03589	0,912	0,001012	0,653
18	0,04030	1,024	0,001276	0,823
17	0,04526	1,150	0,001609	1,038
16	0,05082	1,291	0,002028	1,309
15	0,05707	1,450	0,002558	1,650
14	0,06408	1,628	0,003225	2,081
13	0,07196	1,828	0,004067	2,624
12	0,08081	2,053	0,005129	3,309
11	0,09074	2,305	0,006467	4,172
10	0,10190	2,588	0,008155	5,261
9	0,11440	2,906	0,010279	6,631
8	0,12850	3,264	0,012969	8,367

#### Minimum Pull Out Force

Always test with open insulation crimp

pull out force test standard EN 60352-2

Schleuniger aims at a 10% higher pull force than required in EN 60352-2.

Conductor Cross Section	Tensile Strength of Conductor		Pull Force	
	mm <sup>2</sup>	N	kg	kg
32	0,032	8	0,81	0,4079
30	0,051	12	1,22	0,6118
28	0,081	18	1,83	1,1217
26	0,129	29	2,95	1,5296
	0,140	32	3,26	1,8355
24	0,205	47	4,80	2,8552
	0,250	57	5,80	3,2631
22	0,326	74	7,50	4,0789
20	0,518	117	11,90	6,1183
	0,750	169	17,22	8,6676
18	0,823	186	19,00	9,1774
	1,000	225	22,90	11,0129
16	1,309	295	30,00	13,7662
	1,500	338	34,40	15,2957
14	2,081	468	47,70	20,3943
	2,500	563	57,40	23,4535
12	3,309	745	76,00	28,0422
	4,000	900	91,70	31,6112
10	5,261	1186	120,00	36,1999
	6,000	1350	137,60	36,7098
8	8,367	1725	174,00	37,7295
	10,000	2000	200,00	38,7492