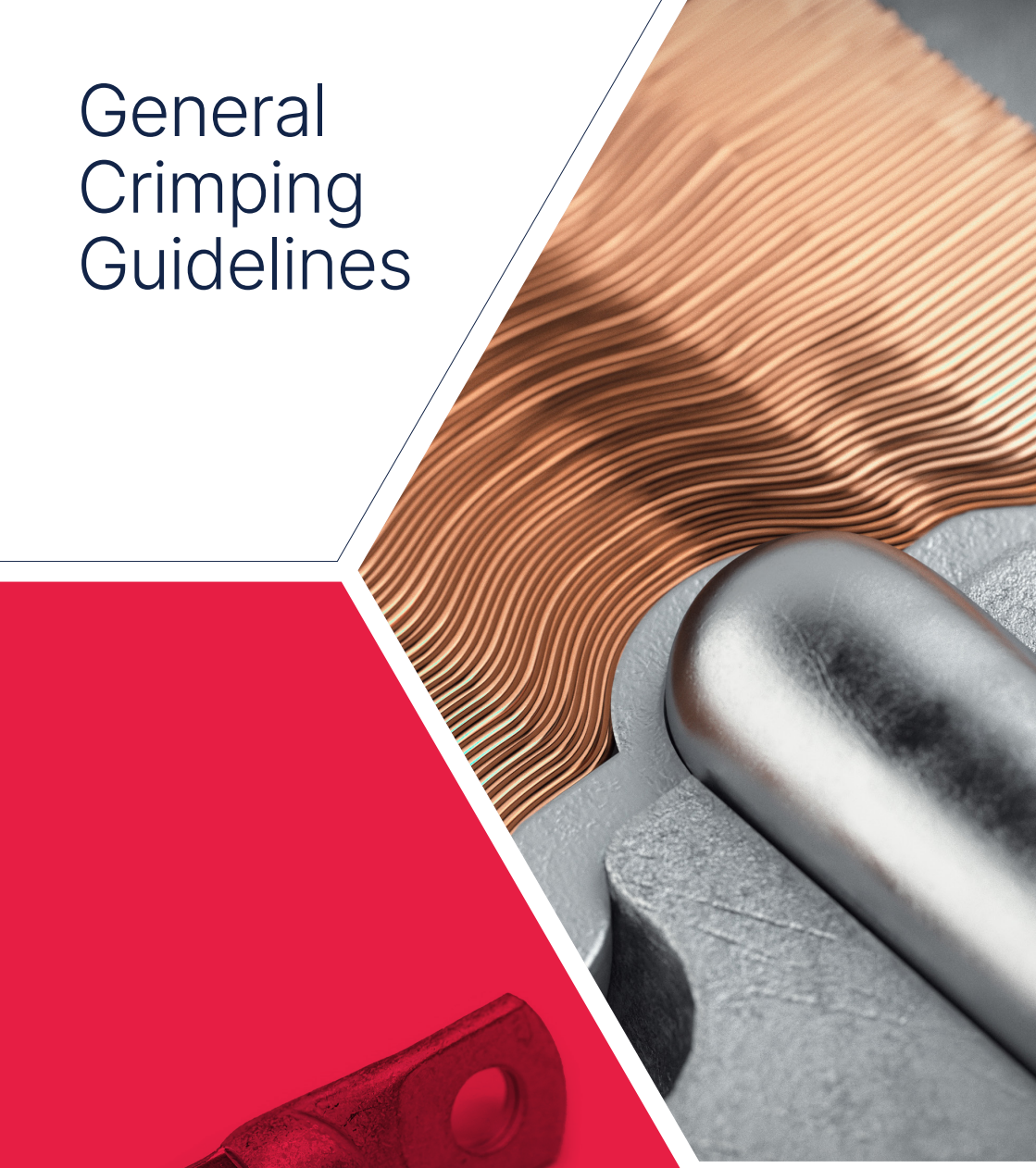
General Crimping Guidelines

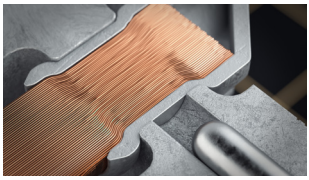
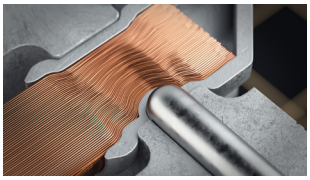
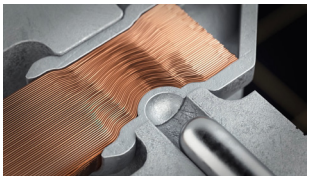


ELPRESS

Academy

General Crimping Guidelines

This is a general crimping instruction. Always make sure you maintain the dies and tools according to the maintenance instructions in the Technical information,"Running maintenance of crimp dies".

Contact crimping

1. Mount the dies in the fork

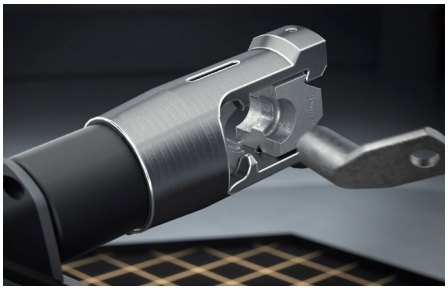


Figure 1, 13DB22 dies in a PVX1300 crimping tool.

2. Strip the cable insulation. NOTE! Do not damage the strands. Use appropriate tool to ensure the strands are not damaged during this procedure. The correct strip length according to terminals value.

Figure 2, stripping length.

Figure 3, stripping tool.

3. Insert the Elpress type terminal in the crimp tool and crimp until the terminal is fixed (just so it keeps the terminal in place). Make sure the correct DIE number matches both the terminal and die.

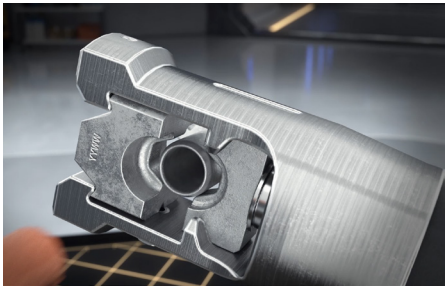


Figure 4, Terminal fixed in the tool.

4. Insert the conductor in the terminal. Make sure you insert the conductor fully.

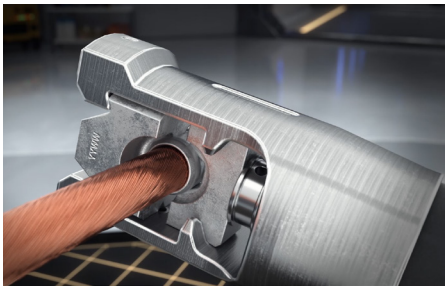


Figure 5, Conductor inserted in Terminal.

Figure 6, Gap between the terminal and insulation of the conductor.

5. Make sure the crimp distance is approximately 2-5 mm from the tube edge. Make the correct No. crimps acc. die instructions.

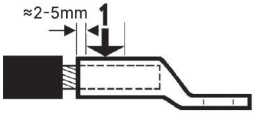


Figure 7, For terminals up to 95 mm² (DUAL crimp).

6. The following crimp order shall be proceeded. See Figure 8.

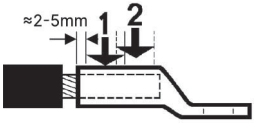


Figure 8, For terminals equal and above 120 mm² (DUAL crimp).

7. Crimp the terminal. Hold the conductor steady, in place during the whole crimp procedure. The crimp tool will release and retract automatically when the correct pressure has been reached.

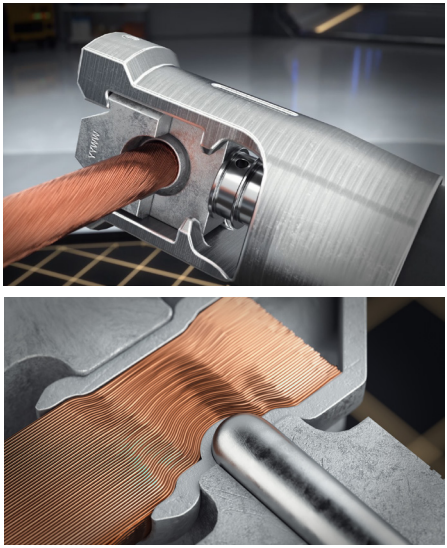
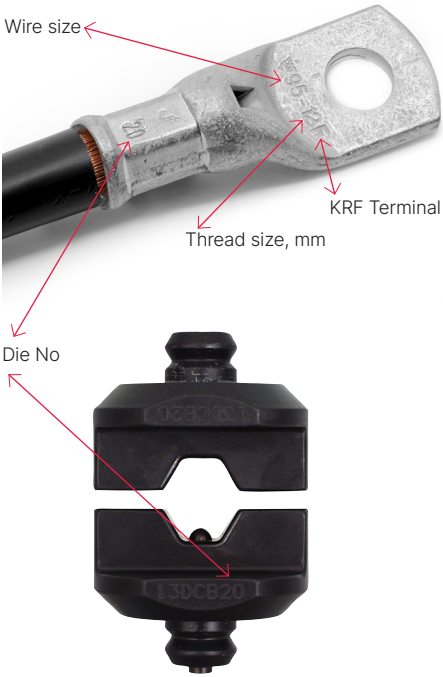


Figure 9, Crimp procedure.

8. After crimp procedure, control the crimp result according to System Elpress.



8.1 Visual inspection – There shall be no protruding material.
Make sure you follow the maintenance instructions.

8.2 Marking
The markings shall be matching for all the parts within the system.
After the crimp procedure is completed, the die number is indented on the crimp-surface for a secure traceability.

8.3 Control N-MAX measure according to the measurepoints seen in the picture. The measurement shall be performed in the crimp-direction.

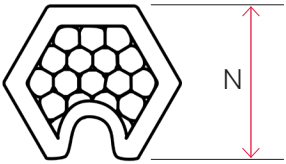
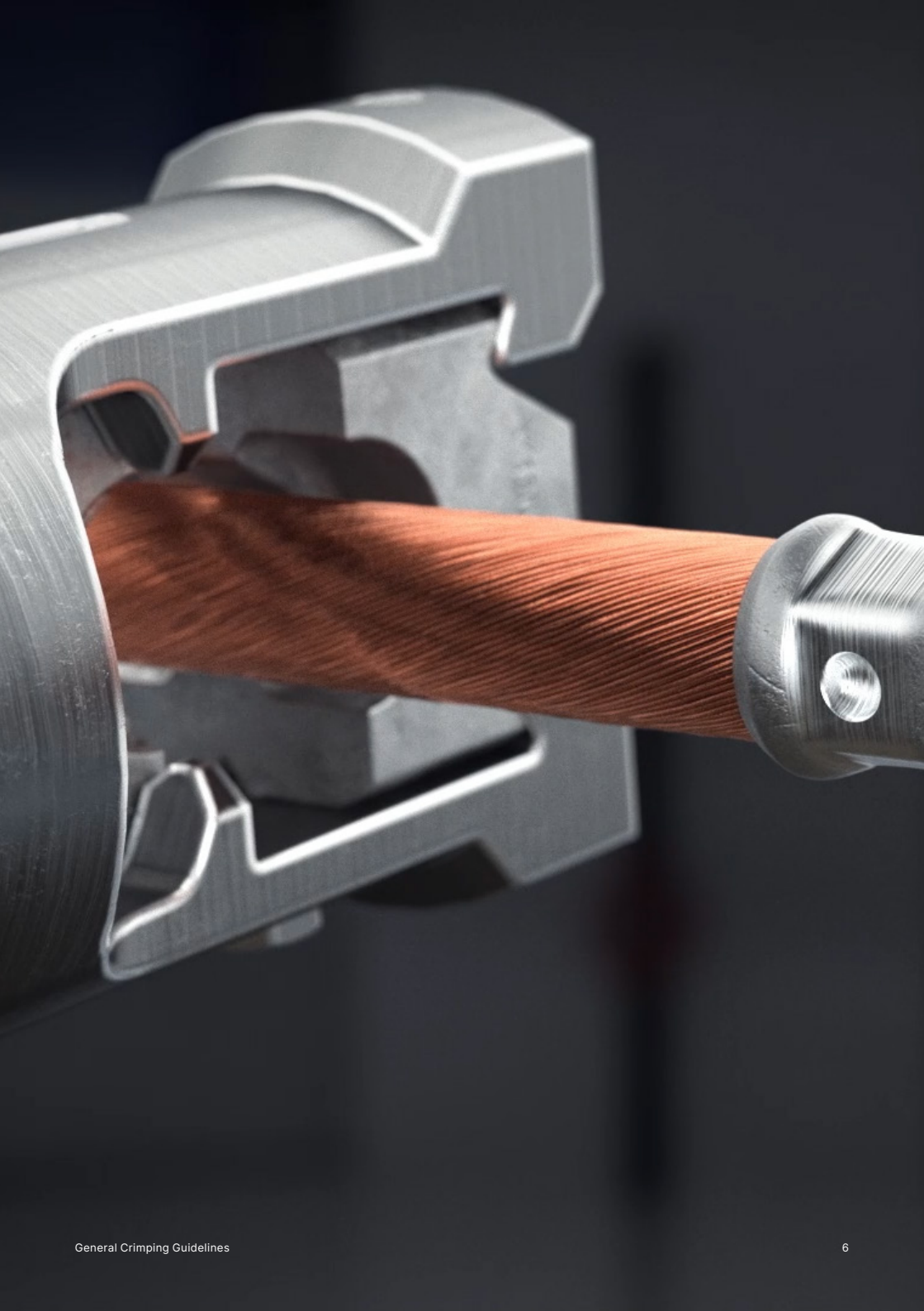
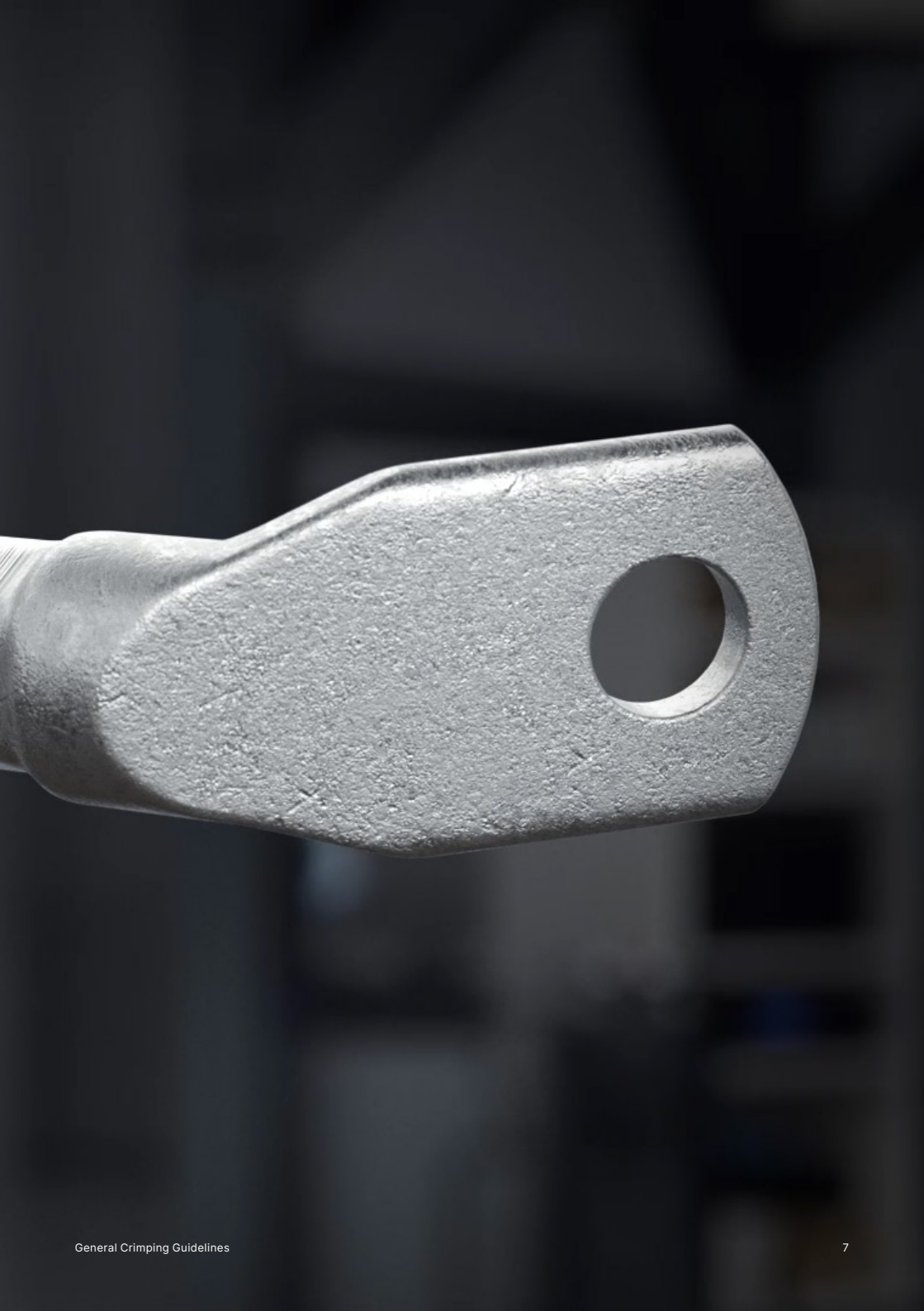


Figure 10, N-measure for DUAL-crimp dies.

Figure 12, Crimp result of a KRF95-12.





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