

Crimp-Daten für Crimp-Kontakte

Crimp Data for Crimp Contacts



1. Verarbeitung der Litze

1.1 Abisolieren

Litze entsprechend den Angaben über der jeweiligen Serientabelle („Wire Strip Length“) abisolieren. Bei Leitern aus feinen Einzeldrähten dürfen diese nach dem Abisolieren weder geknickt noch gebrochen sein.

1.2 Drahtpositionierung

Das abisolierte Leiterende muss den Leiter-Crimp-Bereich überragen, mindestens um das Maß des Leiterdurchmessers, und darf nicht in den Kontaktbereich des Crimp-Kontaktes hinein reichen.

Das Mantelende der Litze muss den Mantel-Crimp-Bereich überragen, darf aber nicht in den Leiter-Crimp-Bereich hinein reichen.

2. Crimp-Höhen

Die Crimp-Höhe („Crimp Height“) bestimmt sowohl die elektrische als auch die mechanische Leistung des Crimp-Kontaktes. Die Leiter-Crimp-Höhe („Conductor Crimp Height“) liegt zwischen den optimalen Werten für mechanische Zugbelastbarkeit und elektrische Leitfähigkeit.

Die Mantel-Crimp-Höhe („Insulation Crimp Height“) variiert mit unterschiedlichen Mantelstärken. Die optimale Crimp-Höhe des Mantels führt zu festem Sitz, ohne die Isolation zu durchschneiden.

2.1 Messen der Crimp-Höhen

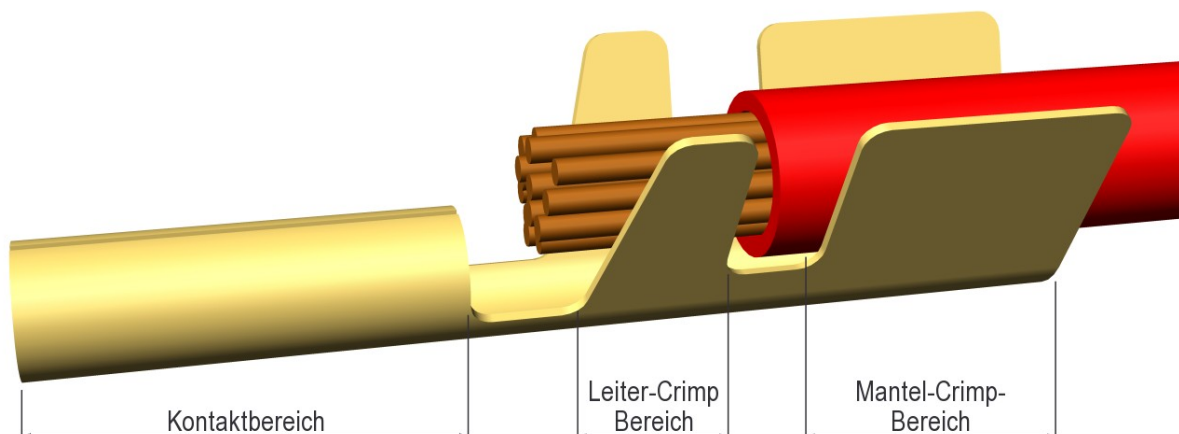
Bei der Messung der Crimp-Höhen sollten keine Grate mitgemessen werden. Die Crimp-Höhe ist nur vom Kontaktmaterial im gecrimpten Bereich des Leiters bzw. des Mantels abzunehmen.

2.2 Zustand des fertigen Crimps

Alle Einzeldrähte des Leiters müssen in die Crimp-Verbindung eingeschlossen sein. Um Montage- oder Kontaktprobleme zu vermeiden, darf der Kontakt weder verbogen, verdreht oder anderweitig verformt sein.

3. Montage im Gehäuse

Den Kontakt gerade und ohne Kraftaufwand in die vorgesehene Gehäuseöffnung einführen. Die Sicherungslasche muss hörbar im Gehäuseausbruch einrasten. Nach dem Einsetzen des Kontaktes den Draht leicht zurückziehen, um den sicheren Halt zu prüfen.



1. Processing of the Strand

1.1 Stripping

Strip the strand according to the wire strip length above the resp. table for the series. In case of conductors made of fine individual wires these must not be kinked or broken after stripping.

1.2 Wire positioning

The stripped conductor end must protrude the conductor crimp area at least by the size of the conductor diameter, and must not reach into the contact area of the crimp contact.

The insulation end of the wire must protrude beyond the insulator crimp area but must not reach into the conductor crimp area.

2. Crimp Heights

The crimp height determines both the electrical and mechanical performance of the crimp contact. The conductor crimp height lies between the optimal values for tensile strength and electrical conductivity.

The insulation crimp height varies with different insulation thicknesses. The optimal insulation crimp height results in a tight fit without cutting through the insulation.

2.1 Measuring of Crimp Heights

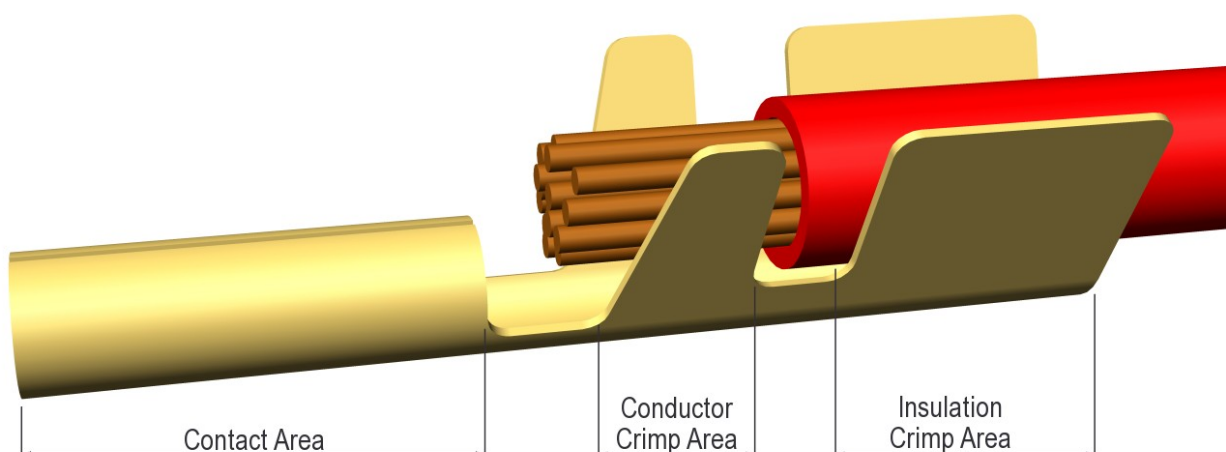
When measuring crimp heights, no burrs should be measured. The crimp height measures are directly taken from the contact material in the crimped area, from the crimped wire or the crimped insulation.

2.2 Condition of the Finished Crimp

All fine individual wires of the lead have to be enclosed by the crimp connection. To avoid assembly or contact problems, the contact must not be bent, twisted or otherwise deformed during processing.

3. Installation in the Casing

Insert the contact aligned and without effort into the provided housing opening. The locking tab must audibly click into place in the housing cut-out. After inserting the contact, pull the wire back gently to examine secure hold.



4. Tabellen / Tables

Empfohlene Crimp-Höhen am Beispiel von UL-Standardleitungen.

Recommended crimp heights based on UL standard wires.

W+P Part Number: 1250-01-30-00

Wire Strip Length: 1.35mm

Insulation OD: UL1571

AWG	Conductor Crimp Height [mm]	Conductor Crimp Width [mm]	Insulation Crimp Height [mm]	Insulation Crimp Width [mm]	Min.Crimp Tensile Strength [kgf]
28	0.70±0.1	0.85±0.05	1.10±0.1	0.95±0.05	1.1
30	0.65±0.1	0.85±0.05	1.03±0.1	0.95±0.05	0.6
32	0.50±0.1	0.85±0.05	0.95±0.1	0.95±0.05	0.45

W+P Part Number: 574-01-2-50

Wire Strip Length: 3.0mm

Insulation OD: UL1007

AWG	Conductor Crimp Height [mm]	Conductor Crimp Width [mm]	Insulation Crimp Height [mm]	Insulation Crimp Width [mm]	Tolerances [mm]
22	0.9	1.50	1.50	1.80	±0.1
24	0.8	1.50	1.50	1.40	±0.1
26	0.8	1.50	1.50	1.40	±0.1
28	0.7	1.50	1.50	1.30	±0.1
30	0.7	1.50	1.50	1.30	±0.1

W+P Part Number: 576-01-2-50

Wire Strip Length: 2.5mm

Insulation OD: UL1007

AWG	Conductor Crimp Height [mm]	Conductor Crimp Width [mm]	Insulation Crimp Height [mm]	Insulation Crimp Width [mm]	Tolerances [mm]
22	0.9	1.60	1.60	1.80	±0.1
24	0.8	1.60	1.60	1.40	±0.1
26	0.8	1.60	1.60	1.40	±0.1
28	0.7	1.60	1.60	1.30	±0.1
30	0.7	1.60	1.60	1.30	±0.1

W+P Part Number: 532-01-2-50

Wire Strip Length: 3.0mm

Insulation OD: UL1007

AWG	Conductor Crimp Height [mm]	Conductor Crimp Width [mm]	Insulation Crimp Height [mm]	Insulation Crimp Width [mm]	Tolerances [mm]
22	1.0	2.50	2.90	1.90	±0.1
24	0.9	2.50	2.90	1.40	±0.1
26	0.8	2.50	2.90	1.40	±0.1
28	0.7	2.50	2.90	1.30	±0.1
30	0.7	2.50	2.90	1.30	±0.1

W+P Part Number: 560-01-2-50

Wire Strip Length: 1.5mm

Insulation OD: UL1061

AWG	Conductor Crimp Height [mm]	Conductor Crimp Width [mm]	Insulation Crimp Height [mm]	Insulation Crimp Width [mm]	Tolerances [mm]
26	0.8	0.8	1.1	0.9	±0.1
28	0.7	0.8	1.0	0.9	±0.1
30	0.7	0.7	1.0	0.9	±0.1

Terminal Insertion Force: 0.5kgf

W+P Part Number: 561-01-2-50

Wire Strip Length: 1.5mm

Insulation OD: UL1061

AWG	Conductor Crimp Height [mm]	Conductor Crimp Width [mm]	Insulation Crimp Height [mm]	Insulation Crimp Width [mm]	Tolerances [mm]
26	0.9	0.9	1.40	1.0	±0.1
28	0.8	0.9	1.30	1.0	±0.1
30	0.7	0.9	1.30	1.0	±0.1

Terminal Insertion Force: 0.5kgf

W+P Part Number: 5630-01-2-50

Wire Strip Length: 1.5mm

Insulation OD: UL1061

AWG	Conductor Crimp Height [mm]	Conductor Crimp Width [mm]	Insulation Crimp Height [mm]	Insulation Crimp Width [mm]	Tolerances [mm]
26	0.8	0.8	1.1	0.9	±0.1
28	0.7	0.8	1.0	0.9	±0.1
30	0.7	0.7	1.0	0.9	±0.1

Terminal Insertion Force: 0.5kgf

W+P Part Number: 518-01-3-00

Wire Strip Length: 1.5mm

Insulation OD: UL1061 (1.1mm max.)

AWG	Conductor Crimp Height [mm]	Conductor Crimp Width [mm]	Insulation Crimp Height [mm]	Insulation Crimp Width [mm]	Tolerances [mm]	Min.Crimp Tensile Strength [kgf]
28	0.72	1.22	1.46	1.39	±0.05	2.0
30	0.70	1.15	1.36	1.39	±0.05	1.8
32	0.67	1.08	1.26	1.26	±0.05	1.5

W+P Part Number: 575-01-2-50

Wire Strip Length: 2.5mm

Insulation OD: UL1007

AWG	Conductor Crimp Height [mm]	Conductor Crimp Width [mm]	Insulation Crimp Height [mm]	Insulation Crimp Width [mm]	Tolerances [mm]
26	0.9	1.3	1.4	1.5	±0.1
28	0.8	1.3	1.3	1.5	±0.1
30	0.7	1.3	1.3	1.5	±0.1

Terminal Insertion Force: 1.5kgf

W+P Part Number: 534-01-2-50

Wire Strip Length: 2.5mm

Insulation OD: UL1007

AWG	Conductor Crimp Height [mm]	Conductor Crimp Width [mm]	Insulation Crimp Height [mm]	Insulation Crimp Width [mm]	Tolerances [mm]	Min.Crimp Tensile Strength [kgf]
18	1.12 ~ 1.20	1.9±0.1	2.4	3.0±0.1	±0.05	11.0
20	1.08 ~ 1.15	1.9±0.1	2.2	3.0±0.1	±0.05	9.7
22	1.00 ~ 1.08	1.9±0.1	2.0	3.0±0.1	±0.05	7.0

W+P Part Number: 528-01-2-50

Wire Strip Length: 3.0mm

Insulation OD: UL1007

AWG	Conductor Crimp Height [mm]	Conductor Crimp Width [mm]	Insulation Crimp Height [mm]	Insulation Crimp Width [mm]	Tolerances [mm]
22	0.8	1.5	1.7	1.8	±0.1
24	0.75	1.5	1.6	1.8	±0.1
26	0.72	1.5	1.32	1.8	±0.1
28	0.7	1.5	1.3	1.8	±0.1

W+P Part Number: 527-01-2-50

Wire Strip Length: 2.5mm

Insulation OD: UL1007

AWG	Conductor Crimp Height [mm]	Conductor Crimp Width [mm]	Insulation Crimp Height [mm]	Insulation Crimp Width [mm]	Tolerances [mm]
22	0.85	1.55	1.84	2.96	±0.5
24	0.74	1.55	1.68	2.96	±0.5
26	0.7	1.55	1.56	2.96	±0.5
28	0.7	1.55	1.54	2.94	±0.5

W+P Part Number: 522-01-2-50

Wire Strip Length: 3.0mm

Insulation OD: UL1007

AWG	Conductor Crimp Height [mm]	Conductor Crimp Width [mm]	Insulation Crimp Height [mm]	Insulation Crimp Width [mm]	Tolerances [mm]
22	1.0	1.4	1.3	1.6	±0.1
24	0.9	1.4	1.2	1.6	±0.1
26	0.9	1.4	1.2	1.6	±0.1
28	0.8	1.4	0.9	1.6	±0.1

W+P Part Number: 521-01-2-50

Wire Strip Length: 2.5mm

Insulation OD: UL1007

AWG	Conductor Crimp Height [mm]	Conductor Crimp Width [mm]	Insulation Crimp Height [mm]	Insulation Crimp Width [mm]	Tolerances [mm]
22	1.0	1.4	1.6	1.6	±0.1
24	0.8	1.4	1.6	1.6	±0.1
26	0.7	1.3	1.5	1.5	±0.1
28	0.7	1.3	1.5	1.5	±0.1

W+P Part Number: 529-01-3-50

Wire Strip Length: 2.5mm

Insulation OD: UL1007

AWG	Conductor Crimp Height [mm]	Conductor Crimp Width [mm]	Insulation Crimp Height [mm]	Insulation Crimp Width [mm]	Tolerances [mm]
22	0.9	1.6	1.7	1.65	±0.05
24	0.8	1.6	1.65	1.65	±0.05
26	0.75	1.6	1.55	1.65	±0.05
28	0.7	1.6	1.5	1.65	±0.05