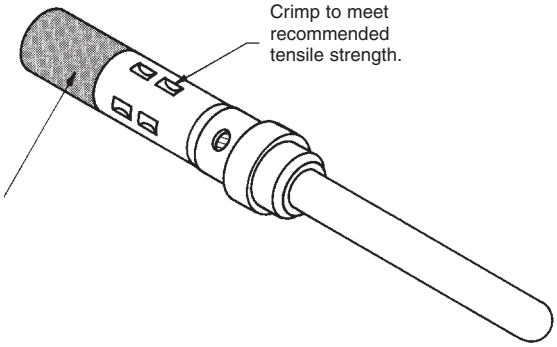
INSPECTION INFORMATION FOR REMOVABLE CRIMP CONTACTS

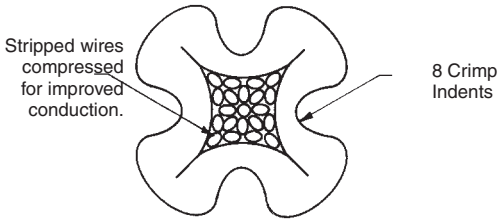
USE INDICATED POSITRONIC TOOLS FOR BEST RESULTS

Inspection Criteria:
- **Strands to be visible through the inspection hole.**
- **Strands not to be visible between the insulation and barrel.**
- **Crimped contact to meet recommended conductor tensile force shown in chart.**
- **Check for peeled gold and bent contacts.**

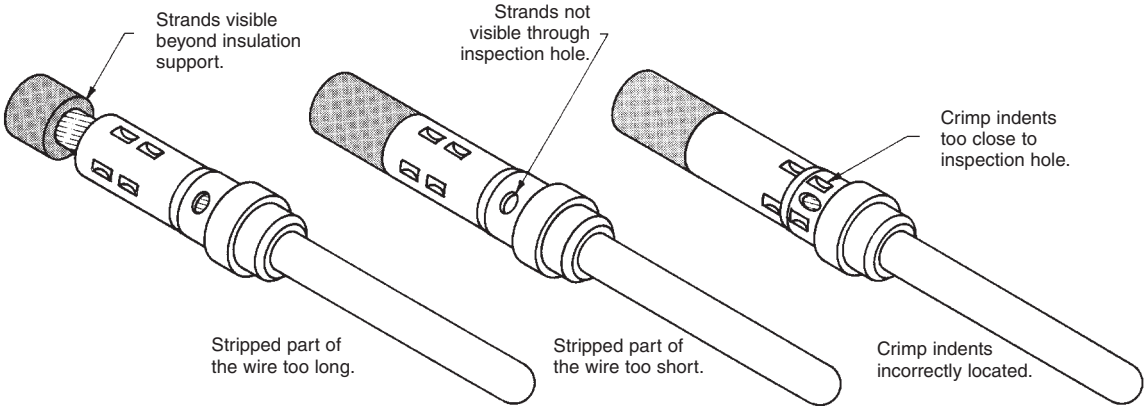
Correctly Crimped Contact



Cross Section of Correctly Crimped Contact



Examples of Crimping Faults



PULL TESTING: Using the correct wire gauge and crimp tooling for a particular contact will help ensure customers maximize the electrical and mechanical integrity of their crimps. Positronic recommends performing frequent pull tests on the crimped contacts. Please refer to the Positronic Recommended Conductor Tensile Strength table as a starting point for identifying acceptable tensile values.

Positronic Recommended Conductor Tensile Strength	
WIRE SIZE AWG/[mm²]	AXIAL LOAD POUNDS/[N]
0 / [55.0]	630 / [2803]
4 / [25]	360 / [1602]
6 / [16.0]	110 / [489]
8 / [10.0]	110 / [489]
10 / [5.3]	110 / [489]
12 / [4.0]	110 / [489]
14 / [2.5]	70 / [311]
16 / [1.5]	50 / [222]
18 / [1.0]	28 / [125]
20 / [0.5]	20 / [89]
22 / [0.3]	12 / [53]
24 / [0.25]	8 / [36]
26 / [0.12]	5 / [22]
28 / [0.08]	3 / [13]
30 / [0.05]	1.5 / [6.7]

Conductor tensile strength values are derived using silver-tin plated copper wires.

Values may change depending upon what type of wire is used.

For instructions to strip insulation, crimp contacts onto wire, and inserting contacts into insulator, visit our web site to view instructions in the Application Tools section. For information on the proper tool to use, review the Crimp Tool Cross Reference Guide available for down load from our web site.