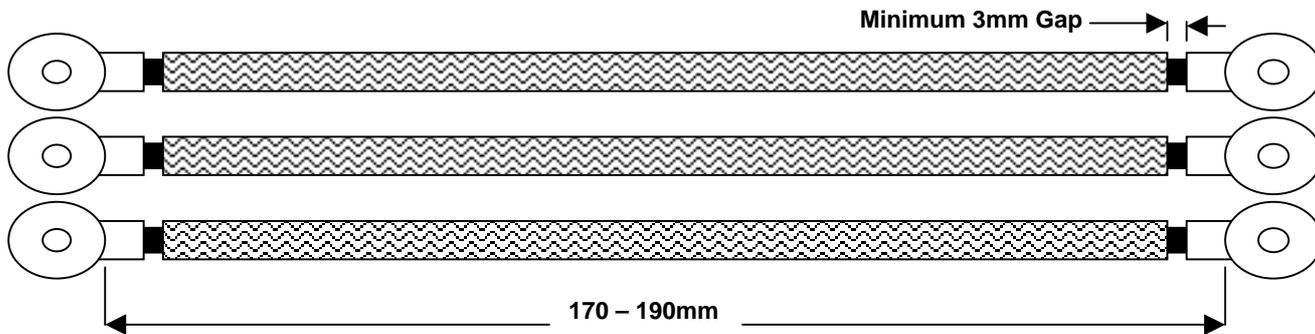


## Scope

This instruction covers the preparation of crimped joints in electrical cables, for the purpose of testing for mechanical strength and electrical integrity.

## What does a SET of SPECIMENS look like?

One set of specimens looks like this:



Within each set, the **3 cables** should all be the same type and size, as should the **6 terminals**. The dimensions for length & gap are very important, please adhere to them.

**Please Note:** Within the standard price for testing there is no allowance for stripping back insulation or calculating cross sectional area.

## What information should I provide?

You should provide, as a minimum, the **tool serial number** and the **cable cross sectional area** for every set of specimens you submit for testing. Attach a label to each set.

## How many SETS of SPECIMENS should I produce?

Produce at least **one set** of specimens **for every size of crimping nest** on the tool.

The most common crimp tool types have either one nest or three nests.

If a particular crimping nest on a tool is used for producing a variety of joints using various combinations of cable type and terminal type, then ideally, you should produce one set of specimens for each and every combination of cable and terminal used.

## Method

Use lengths of cable **170mm to 190mm** long before crimping.

Strip the cable ends of insulation, taking care not to sever or damage any strands.

Sufficient insulation should be removed to render any insulation support ineffective, and to leave **at least 3mm** of clearance between the end of the insulation and any crimped terminal.

Should the lay of the strands be disturbed, re-impose them by a light twist, but without touching with bare fingers.

Ensure conductor is clean before assembly with the terminal.