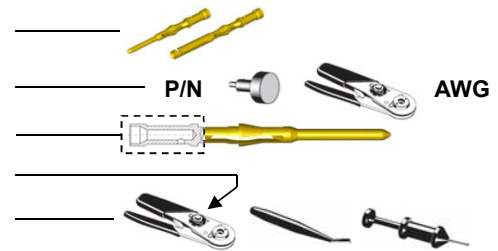


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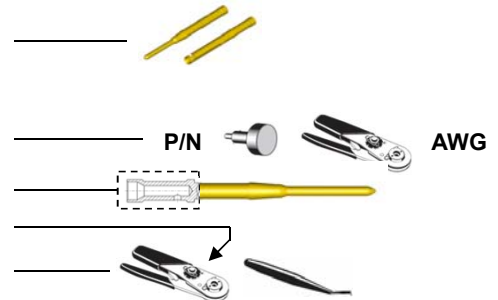
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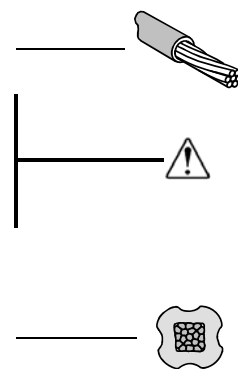
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## SCOPE

This document provides general guidelines and procedures for understanding and achieving reliable crimp terminations when using Fischer Connectors closed barrel crimp contacts.

Its contents may slightly differ from individual company guidelines and procedures, and is not intended to replace them. Given the broad variety of cable sizes, stranding and qualities, it is always recommended to perform trials to verify and if necessary adapt the procedure to the particular situation and application.

If a conflict occurs between this document and Fischer Connectors' catalogues, this document will take precedence.

## INTRODUCTION

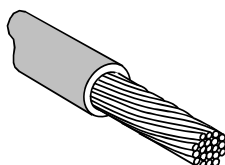
The connection between the wire and the terminal is a critical element of any wire termination. A good termination is important because it ensures mechanical integrity and electrical performances required for the application.

Crimping is one common method of achieving this connection. It occurs inside the crimp barrel (terminal) of the contact. There are two types of barrels - open and closed. This specification only deals with closed barrels because all contacts referred in this document are screw-machined which is the usual process for producing this type of barrel.

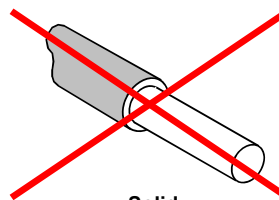
Wire sections are expressed in AWG (American Wire Gauge), mm<sup>2</sup> or CMA (Circular Mil Area). See conversion table in **Appendix 1**. Because the wire stranding and insulation type or thickness can vary widely within a particular wire size, it is very important to carefully verify the compatibility between the selected wire and the crimp contact by checking the barrel hole dimensions in **Table 1a**, and **Table 1b** for UltiMate™ Size 08 and 11.

### Wire types:

- ☞ Stranded conductors shall be used for crimping.
- Solid round conductors may only be used when their suitability has been proven.



Stranded

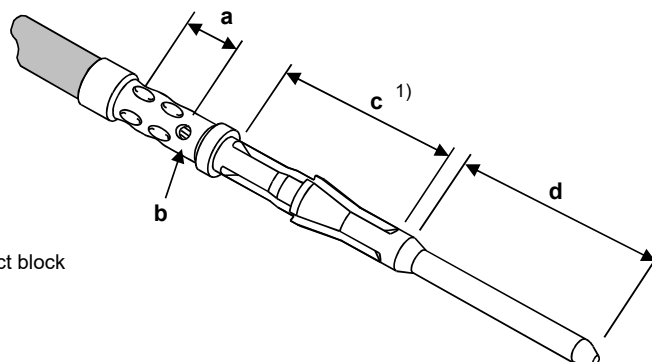


Solid



The end result of a properly crimped terminal is a reliable mechanical and electrical connection.

### Parts of a machined Fischer Connector crimp contact



- a. Conductor crimp area
- b. Inspection window
- c. Contact retaining spring mechanism in contact block
- d. Mating interface (male or female)

Note 1: This spring mechanism is not present on crimp contacts for Fischer UltiMate™ Size 08 & 11 products. For this reason these contacts **cannot** be removed from the contact block by means of extraction tools.