


Training tool: Industrial processing techniques in Crimping

(Crimping machine, Stripper-crimper, Applicator)

Reference: Tool-07-EN-VT

File format: App (exe)

Language: English 



Crimping Machine Structure of a Crimping Machine



- Basic
- Tool holder
- Machine Stroke
- Standards
- Inserting Crimp Tools
- Machine Capability



- (1) Receptacle for the contact coil
- (2) Drive motor
- (3) Eccentric
- (4) Guide
- (5) Ram (fixture for the crimping tool pressure block)
- (6) Bottom tool fixture with quick clamping device for the crimping tool
- (7) Guide plate for the crimp contacts

Important: The bottom tool fixture (6) of the crimping machine and the base plate (C) of the crimping tool must be flat and undamaged. When inserting the crimping tool into the crimping machine, it is essential to ensure that there are no residues from cut-off tabs, wires strands or insulation materials between the surfaces of the bottom tool holder (6) and the tool base plate (C).

Especially when using crimp force monitoring, damage to the bottom tool fixture (6) and the tool base plate (C) lead to incorrect measurements. As a result, higher tolerances must be set, which makes the detection of errors (e.g. missing individual strands) only possible to a more limited extent.



Requirements: Open Crimp Barrel

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Crimping Tool Technology (Applicator) – Open Crimp Barrel

- Basics and philosophy of Crimp applicators.
- Design of crimping tools, crimping tool types.
- Quality requirements for crimping tools.
- Basic setting options for crimping tools.
- Incorrect settings and the effects on the crimp connection.
- Setting up and preparing crimping tools for production, a roadmap.
- Visual inspection, maintenance, servicing and storage.



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Crimping Tool Technology (Applicator) – Open Crimp Barrel

Overview

Tool Types



Overviews

Basic Structure

References

Crimper & Anvil

Shear units

Crimp height

The Feed

Wire Stop
The Wiper

Hold-Down
Systems

Crimp Applicators are sometimes referred to as "MQC Tools" ("Mini Quick Change" = because they can be changed quickly & easy).

These applicators are used wherever crimp connections are made in larger quantities.

The purpose of quick-change applicators is, as the name suggests, to be able to change the tools in short time from one crimping machine to another, and without any major set-up delays. For this purpose, it is necessary that all crimping machines have the same opening dimension of 135.78 mm at the "bottom dead center".

If all crimping machines used in production are set to this dimension, the tools can be changed without any problems and without major set-up times.

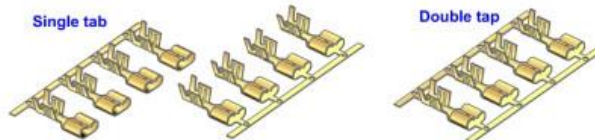
Important: A check of the crimp specifications is always required!



Crimp Applicator Endfeed with mechanical feed



Crimp Applicator Sidefeed with mechanical feed



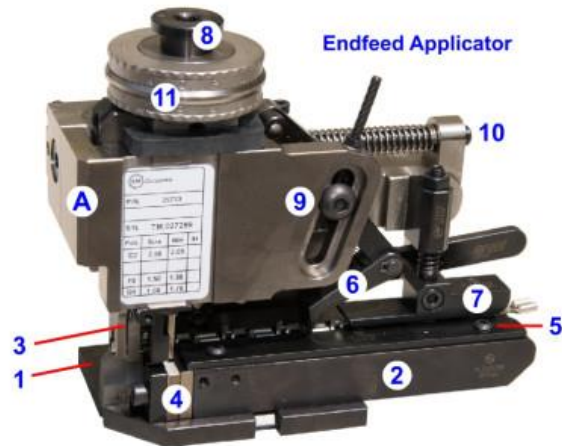
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Crimp Applicator Endfeed: Settings



- | | | |
|--------------------------|-----------------------|--------------------------------|
| (A) Tool body | (3) Wearing parts kit | (7) Contact brake |
| (B) Identification label | (4) Shear unit | (8) Ram (top tool fixture) |
| (1) Tool base plate | (5) Contact guide | (9) Adjustment: Feed stroke |
| (2) Tool table | (6) Feed finger | (10) Adjustment: Feed position |

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Crimp Applicator Sidefeed: Settings



The Feed

Feed Stroke

Contact Brake

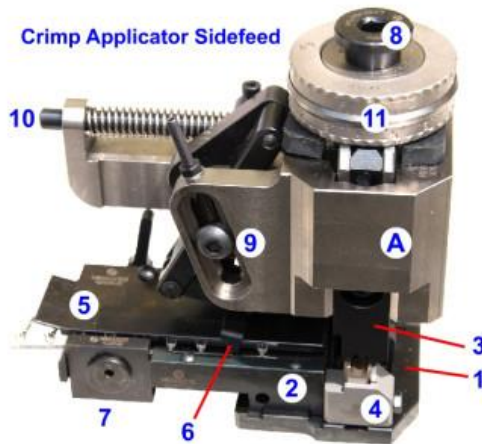
Contact Guide

Contact position

Feed Finger

Shear units

Crimp Applicator Sidefeed



- | | | |
|--------------------------|-----------------------|--------------------------------|
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| (B) Identification label | (4) Shear unit | (8) Ram (top tool fixture) |
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Crimp Tool Maintenance



Basic

Wear & Tear
Applicator

Replacing
Wear Parts

Set-Up Crimping
Machine

Maintenance Plan

Visual Inspection
Wear Parts

Visual Inspection
Applicator

Crimp Tool
Storage



Regular maintenance of the crimping tools increases the durability of the tools, guarantees 100% functionality and thus ensures the quality of the crimp connections.

Only well-maintained production facilities produce quality!

Note: Switch off the crimping machine before all maintenance work on the crimping tool!



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