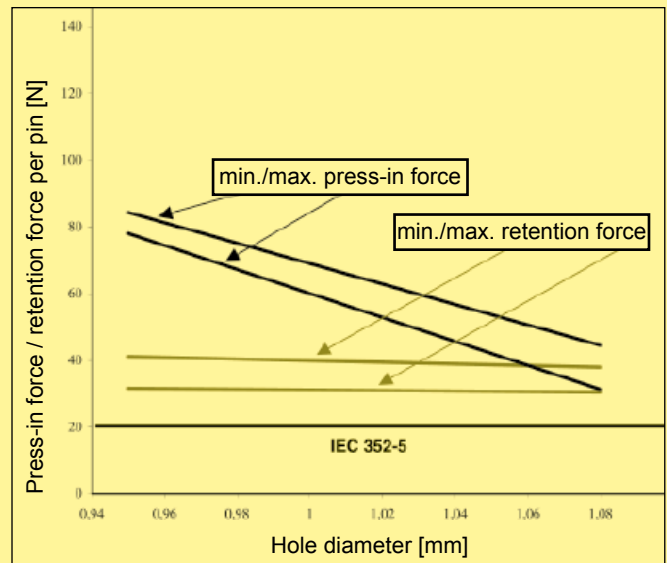


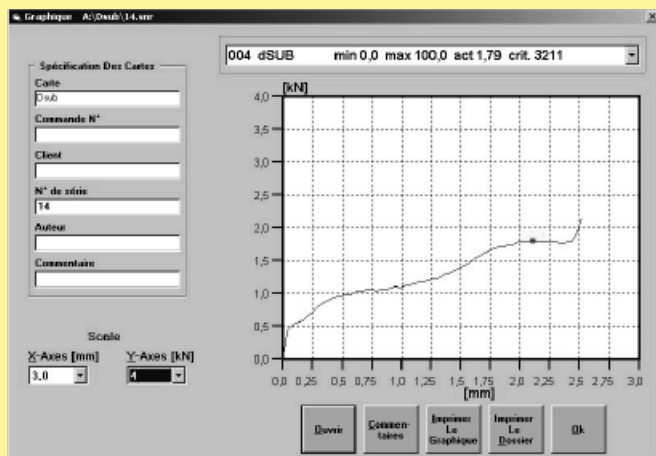
## Quality control of the press-in termination

The press-in force correlates with the diameter of the plated through hole and with the friction coefficient of the surface; therefore it can be used for a continuous monitoring of the process.

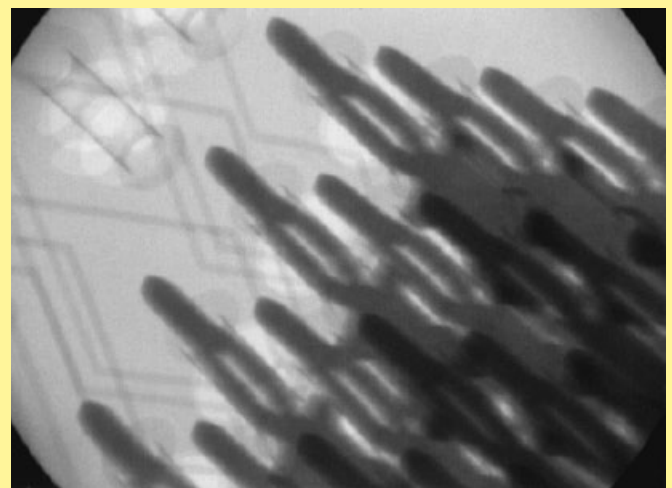
The retention force, as an indirect measure of the normal force, serves to qualify the process or random tests



Typical press-in and retention forces for the D-Sub press-in zone



The automatic press-in machines of HARTING feature a graphical user interface for monitoring the process and the quality of the press-in termination (see chapter 30).



X-ray photo of a pressed-in connector