

Crimp connection

A perfect crimp connection is gastight and therefore corrosion free. It is equivalent to a cold weld of the connected parts. For this reason, major features in achieving high quality crimp connections are the design of the crimping areas of the contact and of course the crimping tool itself. Wires to be connected must be carefully matched to the correct size of crimp contacts. If these basic requirements are met, users will be assured of highly reliable connections with a low contact resistance and a high resistance against corrosion.

The economical and technical advantages are:

- Constant contact resistance as a result of an unvariable crimp connection quality
- Corrosion free connections as a result of cold weld action
- Preparation of harnessing with crimp contacts already fitted
- More economic cable connection

Requirements for crimp connections are set out in DIN IEC 60 352-2.

Pull out force of stranded wire

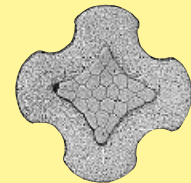
The main criterion by which to judge the quality of a crimp connection is the retention force achieved by the wire conductor in the terminal section of the contact. DIN IEC 60 352, part 2, defines the extraction force in relation to the cross-section of the conductor. When fitted using HARTING crimping tools and subject to their utilization in an approved manner, our crimp connectors comply with the required extraction forces.



B shape cross section stamped contact



H shape cross section turned contact



4 points shape cross section turned contact

Tensile strength of crimped connections

Conductor cross-section		Tensile strength
mm ²	AWG	N
0.05	30	6
0.08	28	11
0.12	26	15
0.14		18
0.22	24	28
0.25		32
0.32	22	40
0.5	20	60
0.75		85
0.82	18	90
1.0		108
1.3	16	135
1.5		150
2.1	14	200
2.5		230
3.3	12	275
4.0		310
5.3	10	355
6.0		360
8.4	8	370
10.0		380

Extract from DIN IEC 60 352-2, Amend. 2, table IV