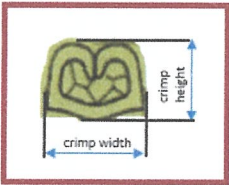

























Process Name/ Title: Wire Cutting and Crimping / Crimp Cross Section Standard Criteria		Document No:	WI-PRO-CNC-046	
WORK INSTRUCTION		Effective Date:	July 10, 2017	
Product Code/Name: ALL	Customer Code: ALL	Rev. No.:	0	Page No.: Page 1 of 1

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers																								
	<p>Cross Section after terminal crimping will be judged as per levels below if not defective:</p> <p>Defect Judgment Criteria:</p> <div style="text-align: right;"></div> <table border="1"><thead><tr><th>Category</th><th>Photo</th><th>Description</th></tr></thead><tbody><tr><td>Crimp Lacking</td><td></td><td><ul style="list-style-type: none">* Core wire is not compressed and each wire strand is at original state.* There is a gap between the terminal and wire strands as well as between the wire strands.* Small gaps at the corners in fully crimped state are acceptable.</td></tr><tr><td>Opened Seam</td><td></td><td><ul style="list-style-type: none">* There is gap (opening) at the barrel's seam portion (the top where it closes)</td></tr><tr><td>Barrel Overlapping</td><td></td><td><ul style="list-style-type: none">* One barrel strikes the other barrel part and overlapping with each other.</td></tr><tr><td>Barrel Pushed to Bottom</td><td></td><td><ul style="list-style-type: none">* The barrel stretched until it reached the bottom part of the terminal.</td></tr><tr><td>Deviate to wire strands</td><td></td><td><ul style="list-style-type: none">* There are more wire strands on the half portion of the barrel and there is gap on the other half portion. (Insufficient compression / crimping)</td></tr><tr><td>Insufficient Crimping</td><td></td><td><ul style="list-style-type: none">* Wire Barrel length short* Insufficient curving of the barrel and is not crimped enough.* Also, due to thermal expansion the terminal is easily opened. (There is a spring back effect)</td></tr><tr><td>Back Burr NG</td><td></td><td><ul style="list-style-type: none">* The back burr has a protruding end shape from the crimped terminal bottom part.* Overlapping of wire barrel and lack of curve closure sometimes will create opening of the terminal.</td></tr></tbody></table> <p>Note:</p> <ul style="list-style-type: none">• In case of the above stated cross crimping condition, adjust applicator feeder and observe the produced parts again.• For the applicator that could not be adjusted, request adjustment to maker.	Category	Photo	Description	Crimp Lacking		<ul style="list-style-type: none">* Core wire is not compressed and each wire strand is at original state.* There is a gap between the terminal and wire strands as well as between the wire strands.* Small gaps at the corners in fully crimped state are acceptable.	Opened Seam		<ul style="list-style-type: none">* There is gap (opening) at the barrel's seam portion (the top where it closes)	Barrel Overlapping		<ul style="list-style-type: none">* One barrel strikes the other barrel part and overlapping with each other.	Barrel Pushed to Bottom		<ul style="list-style-type: none">* The barrel stretched until it reached the bottom part of the terminal.	Deviate to wire strands		<ul style="list-style-type: none">* There are more wire strands on the half portion of the barrel and there is gap on the other half portion. (Insufficient compression / crimping)	Insufficient Crimping		<ul style="list-style-type: none">* Wire Barrel length short* Insufficient curving of the barrel and is not crimped enough.* Also, due to thermal expansion the terminal is easily opened. (There is a spring back effect)	Back Burr NG		<ul style="list-style-type: none">* The back burr has a protruding end shape from the crimped terminal bottom part.* Overlapping of wire barrel and lack of curve closure sometimes will create opening of the terminal.	
Category	Photo	Description																								
Crimp Lacking		<ul style="list-style-type: none">* Core wire is not compressed and each wire strand is at original state.* There is a gap between the terminal and wire strands as well as between the wire strands.* Small gaps at the corners in fully crimped state are acceptable.																								
Opened Seam		<ul style="list-style-type: none">* There is gap (opening) at the barrel's seam portion (the top where it closes)																								
Barrel Overlapping		<ul style="list-style-type: none">* One barrel strikes the other barrel part and overlapping with each other.																								
Barrel Pushed to Bottom		<ul style="list-style-type: none">* The barrel stretched until it reached the bottom part of the terminal.																								
Deviate to wire strands		<ul style="list-style-type: none">* There are more wire strands on the half portion of the barrel and there is gap on the other half portion. (Insufficient compression / crimping)																								
Insufficient Crimping		<ul style="list-style-type: none">* Wire Barrel length short* Insufficient curving of the barrel and is not crimped enough.* Also, due to thermal expansion the terminal is easily opened. (There is a spring back effect)																								
Back Burr NG		<ul style="list-style-type: none">* The back burr has a protruding end shape from the crimped terminal bottom part.* Overlapping of wire barrel and lack of curve closure sometimes will create opening of the terminal.																								

NBC (Philippines)
MASTER COPY

			Prepare			Check	Approve
Eff./Rev.Date	Doc/DCN No.	Rev. No. (if applicable)	Previously established Work Instruction (for history purpose only)		Est. date:	07/10/2017	
-	NBHS -1714	NA	Details of change		Revise	Check	Approve