

Crimping technology for cord-end terminals

Made as uninsulated terminals H type acc. to Ergom or insulated terminals: HI type acc. to Ergom.

Material: Cu tube, E-Cu 57 grade acc. to DIN 1787 or DIN 40500, thickness 0,15÷0,3 mm Insulation polyamide or polypropylene, operating temperature from -55÷+105 °C.


























































Surface: tin-plated 3 µm.

Design: DIN 46228 Teil 1 – H type terminals DIN 46228 Teil 4 – HI type terminals

Rated sizes: acc. to DIN: 0,5÷50 mm², practically sizes 0,14÷150 mm² are offered in a considerably larger range than given in the standard.

Application: for ends of copper cable to hold all cable wires together after taking off the insulation and to stiffen them, e.g. before screwing on. Owing to the use of cord end terminals it is possible to achieve higher connection resistance to vibrations as well as a lower short-circuit hazard caused by a loose wire of conductor. By insulated terminals the insulating sleeve is not compressed on the wire, it plays here a role of protection tubing for conductor.

Various colours of terminals correspond to various rated cross-sections of wires. There are three colour coding systems for rated sizes of terminals: German (N), French (F) and according to DIN.

Cross section [mm ²]	System					
	German (N)		acc. to DIN		French (F)	
0,14		Grey		Grey		Brown
0,25		Blue		Yellow		Violet
0,34		Turquoise		Turquoise		Rose
0,5		Orange		White		White
0,75		White		Grey		Blue
1		Yellow		Red		Red
1,5		Red		Black		Black
2,5		Blue		Blue		Grey
4		Grey		Grey		Orange
6		Black		Yellow		Green
10		Ivory		Red		Brown
16		Green		Blue		White
25		Brown		Yellow		Black
35		Beige		Red		Red
50		Olive		Blue		Blue
70		Yellow		Yellow		Yellow
95		Red		Red		Red
120		Blue		Blue		Blue
150		Yellow		Yellow		Yellow

Crimping technology

For crimping we use the tools with "trapezoidal" or "square" crimping dies. The crimping tool to a small extent deforms a wire and crimping terminal. The force of crimping terminal on the wire has no influence on the resistance of a wire-terminal passage since actual pressure occurs in the electric device to which the wire is connected. Thus it was possible to design a compression die for crimping a 0,14÷6 mm² or 0,5÷10 mm² terminals in one seat. The dies with seats for 16 mm² terminals designed for a definite wire cross-section are used.

In case of square crimping the die has a special construction which consists of four movable sides to form a square. This ensures that a die is very well adjusted to the crimped terminal, in the wire range: 0,08÷6 mm² or 4÷16 mm². Such construction makes it easier to remove the terminal from crimping tool after compression.

We use the same tool for uninsulated terminals as for insulated as the insulating sleeve in the insulated terminal is not deformed while compressing.



"Trapezoidal" crimping form



"Trapezoidal with teeth" crimping form



"Square" crimping form