

Crimping technology for tubular terminals and butt connectors

Made as: straight ring terminals (KDR type acc. to Ergom) in accordance with DIN 46235 and connecting terminals (KLD acc. to Ergom type) in accordance with DIN 46267. In remaining terminals the DIN dimensions refer only to the tubular part of terminal. They are made as: straight ring terminals (KDR.../2X; KRM type acc. to Ergom) and angle ring terminals (K90D; KPD type acc. to Ergom); butt connectors (KLD; LMP; LMW; LMWP; ZLN type acc. to Ergom); reduction connectors (LMP.../...; LMWP.../... type acc. to Ergom); pin terminals (BMW; BMK type acc. to Ergom).

Materials: all types – E-Cu copper tube acc. to DIN 40500 Teil 2,3 or DIN 1787.

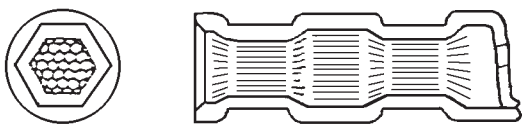
Surface: KDR; KDR .../x2; K90D; K45D; KRM; KLD; LMWP – tin-plated.
KPD; LMP; LMP.../...; LMW; LMWP; HMR; ZLM; BMW; BMK – not tin-plated.

Application:

Straight and angle ring terminals are used for connecting wire by means of a screw joint to bus-bar, switchgear, etc. Tubular connectors are used to join two wires of the same cross-section to "butt" (KLD, LMP, LMW, LMWP, ZLN) or to joint two wires of different cross-section (LMP.../...; LMWP.../...). This join (except KLD and ZLN) cannot be stressed mechanically. Copper pin terminals (BMW, BMK) are used for connecting wire to a screw joint.

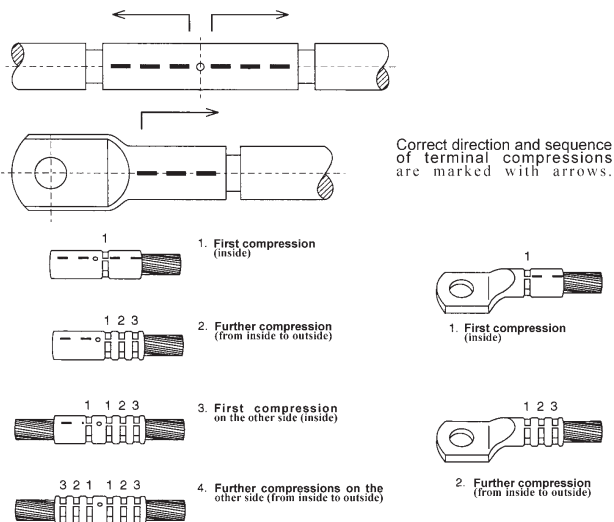
Crimping technology:

Terminals are crimped using tools with so called "hexagon" Crimping dies.



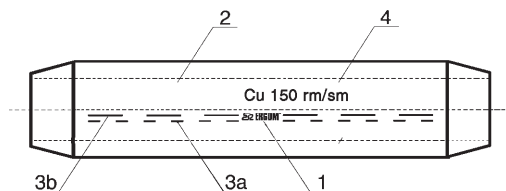
Owing to such compressing shape the joint with very high mechanical and electrical parameters is achieved. However, such joints need several compressions of terminal. The higher compression number the better the joint is.

It is very important in the case of power joints where transmission of large power and currents is required. The "hexagon" compression needs still considerable force to crimp a terminal so in case of such compression (even small wire cross-section) ZAE ERGOM recommends the use of hydraulic tools or hand-tools with a higher mechanical ratio (operated with both hands). In order to achieve a joint of required quality it is recommended to compress terminals to "hexagon" in the following way:



There is a code stamped or overprinted on every terminal to indicate:

- terminal cross-section or screw hole diameter (in case of ring terminals)
- die seat No. to crimp a terminal
- graphic code of number and position of compressions required, made with narrow dies (hand tools) or wide dies (hydraulic tools).



An example of such code is given below.

1. Trade mark.
2. Die seat No.
3. Marking of place and number of compressions.
 - 3a. Mechanic: narrow die.
 - 3b. Hydraulic: wide die.
4. Code of cable types (cross-section and profile).

All marked (recommended) crimp must be made. Please pay attention to use a proper die for the cross-section to which it is designed.

Types of cable wires

