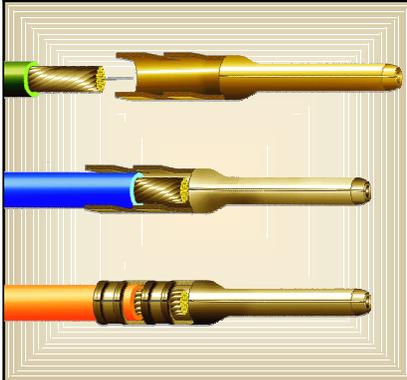


**CRIMPED TERMINATIONS
MULTIPLE CRIMP PINS & SOCKETS**

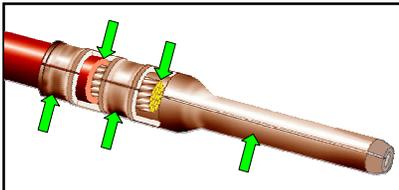


MULTIPLE CRIMP PINS & SOCKETS

Multiple crimp pins and sockets are characterized by the presence of separate crimp devices to secure the conductor and the insulation jacket.

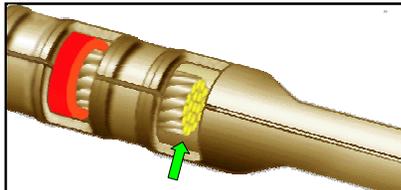
The conductor crimp grips the conductor to complete the electrical termination. The insulation crimp grips the insulation jacket to provide strain-relief to the termination.

See Section 2.01 "Crimped Terminations – General Requirements" for common accept / reject criteria.



PREFERRED

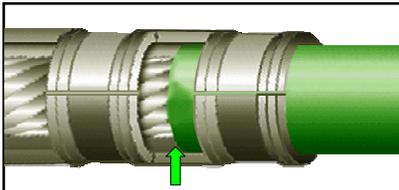
Insulation and conductor crimps are properly set and exhibit proper insulation and conductor spacing. Wire strands visible. No exposed base metal or mechanical damage.



**PREFERRED
CONDUCTOR LENGTH**

The conductor should extend a minimum of flush with, and a maximum of one (1) wire diameter beyond, the conductor crimp edge.

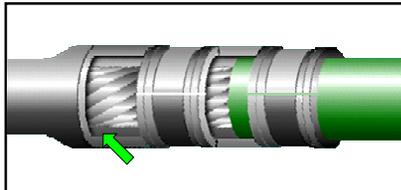
[Best Workmanship Practice](#)



**PREFERRED
INSULATION LENGTH**

The insulation should extend approximately midway between the insulation crimp and the conductor crimp.

[Best Workmanship Practice](#)



**ACCEPTABLE
EXCESS CONDUCTOR LENGTH**

The conductor may extend into the pin or socket barrel, provided the excess conductor length does not interfere with the mechanical and electrical mating of the pin and/or socket.

[Best Workmanship Practice](#)

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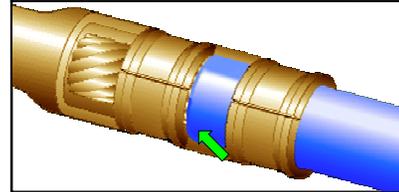
Revision Date:

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2

Section:
2.03

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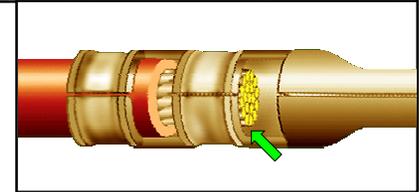
**CRIMPED TERMINATIONS
MULTIPLE CRIMP PINS & SOCKETS (cont.)**



**ACCEPTABLE
EXCESS INSULATION LENGTH**

The insulation may extend to the leading edge of the conductor crimp, provided it can be determined visually that the insulation does not enter the conductor crimp.

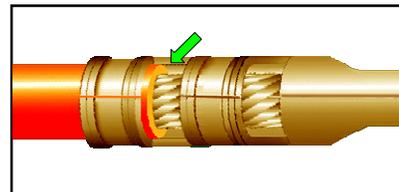
[Best Workmanship Practice](#)



**ACCEPTABLE
MINIMUM CONDUCTOR LENGTH**

The conductor should extend a minimum of flush with the conductor crimp edge.

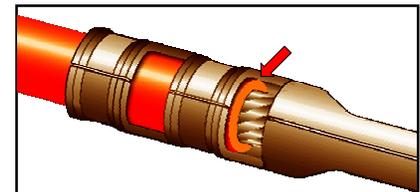
[Best Workmanship Practice](#)



**ACCEPTABLE
MINIMUM INSULATION LENGTH**

At a minimum, the insulation edge may be flush with the trailing edge of the insulation crimp.

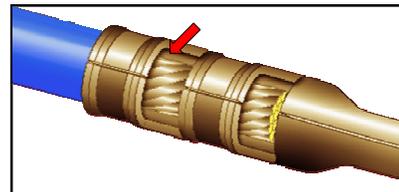
[Best Workmanship Practice](#)



**UNACCEPTABLE
INSULATION ENCROACHMENT**

Insulation encroachment into the conductor crimp section may interfere with the proper mechanical and electrical termination of the crimp.

[NASA-STD-8739.4 \[19.6.2.c.9 \]](#)



**UNACCEPTABLE
IMPROPER STRAIN RELIEF**

The insulation jacket must extend beyond the edge of the insulation crimp, and the crimp must fully engage the jacket to ensure proper strain-relief to the termination.

[NASA-STD-8739.4 \[19.6.2.c.9 \]](#)

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