Shield Crimps are used to mechanically “finish” the end of individually shielded cables.

For ground shield terminations, the crimp assembly will have a grounding wire attachment, allowing the cable shield to be electrically terminated to ground.

For floating shield terminations, the crimp assembly will be completed without the ground wire attachment.

See Section 2.01 “Crimped Terminations – General Requirements” for common accept / reject criteria.
UNACCEPTABLE
UNEVEN SHIELD COVERAGE
The shield braid shall be dressed to provide uniform coverage and dispersion. Uneven coverage may result in electrical interference in sensitive circuits, and may interfere with the reliability of the crimp assembly.

Best Workmanship Practice

PREFERRED
GROUND WIRE ORIENTATION
The ground wire should be dressed to the rear of the crimp termination, to allow the inclusion of a stress relief loop in the completed assembly. The ground wire may also dress forward, provided sufficient stress relief is provided.

NASA-STD-8739.4 [11.5]

ACCEPTABLE
GROUND WIRE INSULATION GAP
The ground wire insulation gap shall be ≤ 0.76 mm (0.030 in.). The minimum gap shall be flush with the edge of the outer crimp ring.

NASA-STD-8739.4 [11.5]

ACCEPTABLE
INNER / OUTER FERRULE SPACING
The inner ferrule may extend a minimum of flush with, and a maximum of 1.7 mm (0.07 in.) beyond, the front edge of the outer ferrule.

NASA-STD-8739.4 [11.5]

ACCEPTABLE
MIN. / MAX. SHIELD / BRAID GAP
Min.: The placement of the crimp rings shall be such that the dress of the shield stranding is not subjected to flexure stress or tensile load.
Max.: The maximum shield gap shall not exceed 0.76 mm (0.030 in.).

NASA-STD-8739.4 [11.5]

ACCEPTABLE
NICKED SHIELD STRANDS
Nicked shield strands shall not exceed 10% of the total number of strands.

NASA-STD-8739.4 [19.6.2.b.2]

UNACCEPTABLE
EXCESSIVE GROUND CONDUCTOR LENGTH
The ground wire end shall be flush with the outer ferrule edge, but shall not overhang the inner ferrule.

NASA-STD-8739.4 [11.5]