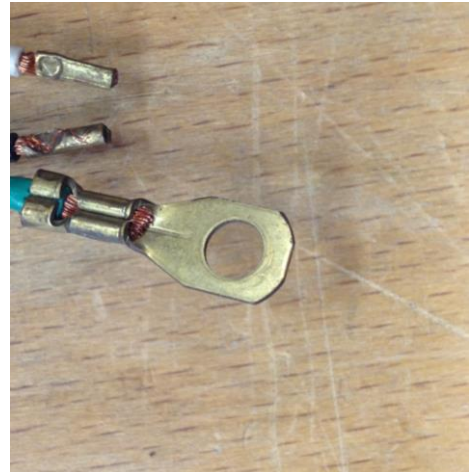


### Processing of crimping tools

**Some information:**

After stripping a cable end, appropriate contacts or wire end sleeves are crimped. Crimping is a secure connection between conductor and contact and has replaced the method of soldering a large extent. Crimping describes the production of a homogeneous, non-detachable connection between conductor and connector. The connection is achieved only through quality precision tools. The tools in this case are for crimping, not for manual crimping tools, but for crimping in automated systems.



**Initial condition:**

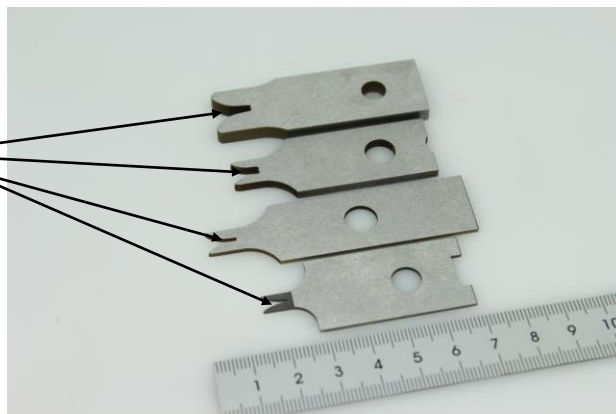
In the initial state, the functional surfaces have been wire eroded, and have a roughness of about  $Ra\ 0.2\mu m$ .

**Task:**

Polishing of the functional surfaces to  $Ra < 0.05\mu m$ . Up to now, this is done time-consuming by hand. By polishing, the wear of the tools is considerably reduced. In addition, a welding on of wire end sleeves with the tools will be avoided and the speed for the crimping process is significantly increased.

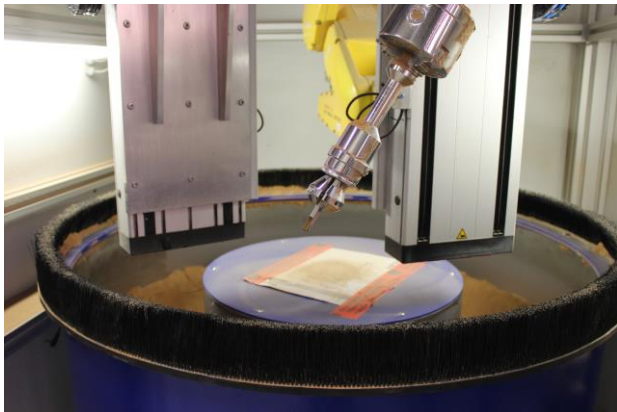
- Removal of the surface structure from wire erosion.
- Polishing of the internal functional surfaces.

Functional surfaces

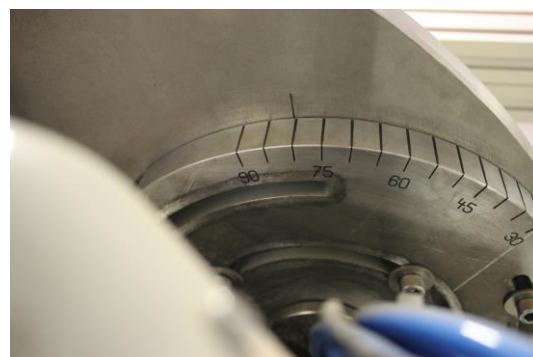
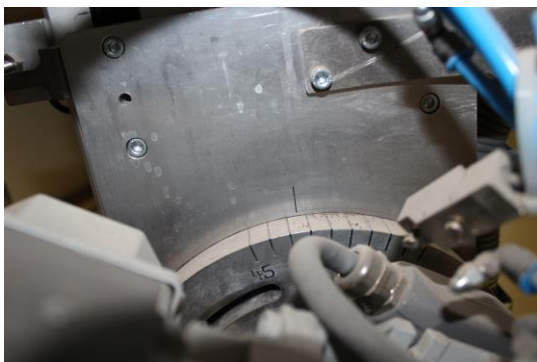


## SF-Application: Processing of crimping tools

Set-up of the process parameters:



Work piece position during process:



### Process parameters

Machine:	SF 3-1050
Media:	H1/500 + 5kg M18
Process time:	10 – 20 Min.
Speed process container:	85 rpm
Speed work piece:	0 (Fix work piece angle A)

### Result

