595-852-E
PHB 7000
2023-09-08

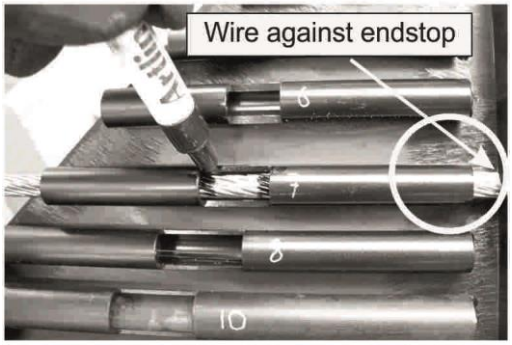
Swaging of wire terminals

Marking the wire

To ensure that the wire is inserted fully inserted into the terminal during production, the depth of the wire terminal must be marked onto the wire. This can be done in two ways.
It is recommended to use template V-1117, but a terminal can be used if template V-1117 not is available. Wires produced within the Seldén Mast group must be made using V-1117.

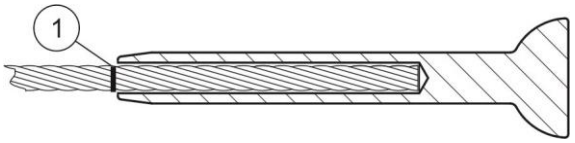
Marking with V-1117

1. Insert the wire into the correct, corresponding tube, between 3-16mm. Push the wire until it rests against the end stop.
2. Make two marks across the wire and one along the wire.

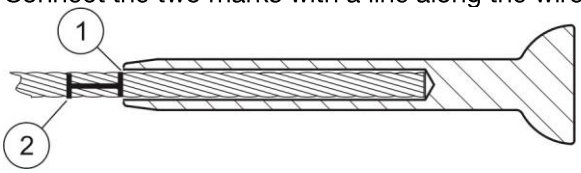


Marking with a terminal

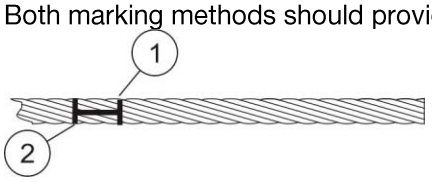
1. Mark the depth of the terminal on the wire. Use the hole in the terminal as a template. Ensure the terminal is correct for the size of the wire



2. Make a second mark on the wire of 2x the diameter of the wire back along the wire from mark (1). Connect the two marks with a line along the wire

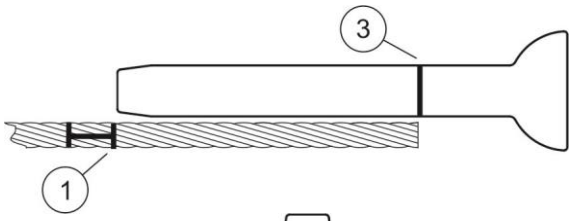


Both marking methods should provide the same resultsame and can be seen in picture below.

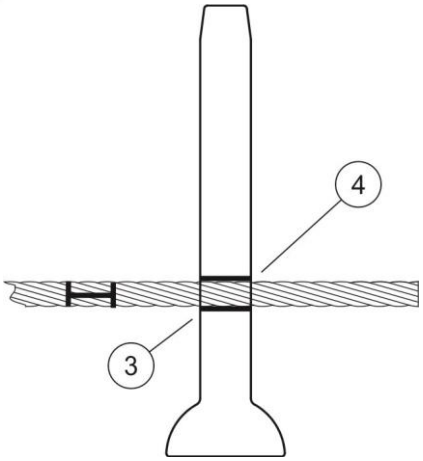


Marking of the terminal

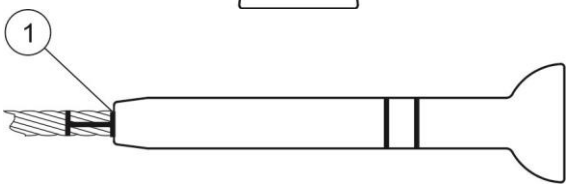
1. Place the wire alongside the terminal, with mark (1) at the edge of the terminal. Mark the terminal at the end of the wire, mark (3).



2. Turn the terminal 90º and make a second mark on the terminal mark (4) (this is the start point for swaging). Use mark (3) and the wire as a guide.

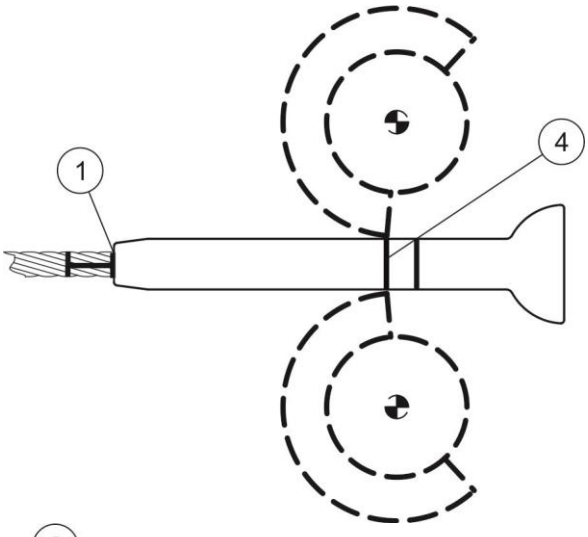


3. Put the wire into the terminal wire, mark (1) must be visual when the wire is pushed fully into the terminal.



Swaging of terminal

1. Place the wire and terminal into the swaging machine. Start swaging at mark (4). Make sure that mark (1) is at the edge of the terminal before starting the swaging.



2. After swaging is completed, check that only mark (2) on the wire is visible.

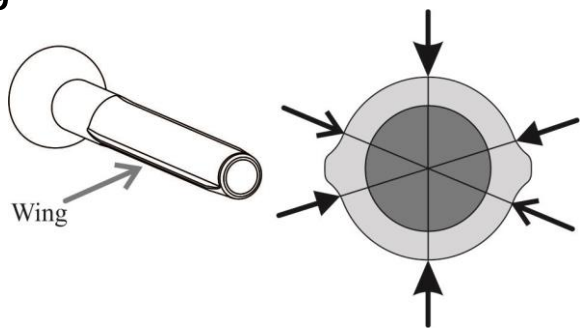
Diameter check after swaging

1. The diameter of the terminal after swaging must be according to table 1. If the diameter is out of tolerance contact supervisor.

Wire	Number of swage passes	Dia. of terminal after swaging	
3	one time	5,56	0 -0,13
4		6,35	0 -0,13
5		7,95	0 -0,13
6		11,13	0 -0,18
7		12,70	0 -0,20
8		14,30	0 -0,20
10		15,88	0 -0,20
12		19,05	0 -0,23
14		22,22	0 -0,23
16		25,40	0 -0,25
19		30,70	0 -0,34

Table 1

*If the swaged wire is going to be used in a Furlex, the wire terminal must be swaged two times to make it round.
Turn the wire terminal 90º before starting the swaging, so the “wings” are swaged.



Measure the terminal at the following 3 places following swaging:

1. 90 º to the “wings”
2. Close to the “wings” on one side
3. Close to the “wings “on the other side.

Check the smallest dimension is within tolerance according to the dimension in the table 1.

Measure the length of swaging

2. Check the length of the swage according table 2 below.

ø Wire	Hole Depth	L= Length	
		min	max
3	38	*36*	*41*
4	44,5	*42*	*48*
5	50	*47*	*54*
6	62	*58*	*67*
7	65	*61*	*70*
8	73	*69*	*79*
10	87	*82*	*94*
12	104	*98*	*112*
14	127	*119*	*137*
16	190	181	205
19	210	*200*	227

Table 2