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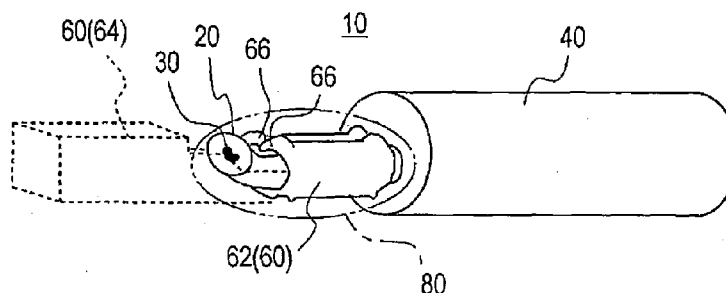
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(54) Title: SINGLE CORE ELECTRIC WIRE

FIG.3C



(57) Abstract: Herein disclosed is a technique that suppresses the decrease of a contact pressure due to creep in a crimping part of a single core electric wire and a terminal. A single core electric wire 10 includes a hollow single core wire 20 and an electric wire coat 40. The hollow single core wire 20 includes a hollow part 30. The hollow part 30 is formed in a circular shape in section in the central part of a section of the hollow single core wire 20 and is formed in an extending direction, that is, a direction of a central axis of the hollow single core wire 20. Namely, the hollow single core wire 20 has a tubular form.

DESCRIPTION

SINGLE CORE ELECTRIC WIRE

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Technical Field

The present invention relates to a single core electric wire and a terminal crimping structure of a single core electric wire.

10 Background Art

For instance, in a wiring of a wire harness installed in a motor vehicle, an electric wire is used which is obtained in such a way that a conductor such as copper or aluminum alloy is used as a core wire, a plurality of core wires are twisted together and the plurality of
15 twisted core wires are coated with an electric wire coat. In such an electric wire, a terminal is attached to a terminal part of the conductor by crimping to connect the terminals to each other so that an electrical contact is established.

20 In a crimping part of the terminal and the electric wire (the core wires), reliability of connection may be occasionally deteriorated due to a decrease of contact pressure by creep or an aged deterioration. In order to solve the above-described problem, various techniques are proposed. For instance, a technique is
25 proposed that, in an electric wire using aluminum for a core wire, the

decrease of contact pressure due to creep or a mitigation of stress is prevented and a progress of the contact corrosion of dissimilar metals is suppressed to ensure a connection reliability (see, for example, patent literature 1). Further, another technique is proposed that a ring sleeve is used which has a serration formed to cause the surface of a conductor to be chamfered by crimping to prevent an aged deterioration of a crimping and connecting part as much as possible and improve reliability of electrical connection (see, for example, patent literature 2).

Citation List

Patent Literature

[PTL 1] Japanese Patent Publication No. JP-A-2009-9736

[PTL 2] Japanese Patent Publication No. JP-A-2010-86848

Summary of Invention

Technical Problem

In a multi-core electric wire, as a sectional area of a conductor becomes larger, the number of core wires to be used becomes larger, which results in high production cost. Therefore, as an electric wire used in a position where a bending property is not necessary, a single core electric wire is occasionally used in place of the multi-core electric wire in view of reducing the production cost. Figs. 1A to 1C show a structure of a crimping part 180 formed with a terminal 160 and an ordinarily used single core electric wire 110.

Fig. 1A shows a structure of a section under a state before a crimping (caulking) operation. Fig. 1B and Fig. 1C are diagrams for explaining a contact pressure under a crimped state. In Fig. 1B and Fig. 1C, an electric wire coat 140 is omitted.

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Immediately after the crimping part 180 is formed, the contact pressure is liable to be very high in an area A where two barrel end parts 166 are caulked so as to be joined to each other, then, in an area B opposed to the area A, the contact pressure is liable to be high, while in areas C in side surface parts, the contact pressure is liable to be low. As shown in Fig. 1C, when creep is generated, the contact pressure in the area A and the area B is lowered. These phenomena arise owing to a fact that the core wire is formed by a single core wire, a load is hardly dispersed during the crimping operation of a terminal, and therefore the contact pressure is concentrated on the area A and the area B while the contact pressure is low in the areas C. Especially, in the area A, the contact pressure is very high due to the form of the terminal which comes into contact with a core wire. Further, under an environment of high temperature (occasionally, even under an environment of low temperature), when the single core electric wire 110 creeps, the contact pressure is lowered due to the creep in the area A where the contact pressure is especially high. Accordingly, a problem arises that in the crimping part, a sufficient contact pressure cannot be ensured, which results in increasing a contact resistance of the single core electric wire 110

(a single core wire 120) and the terminal 160. Since the techniques disclosed in the patent literatures 1 and 2 relate to a technique for an electric wire including a plurality of core wires as an object, the above-described problem is not disclosed therein.

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The present invention is devised by considering the above-described circumstances and it is an object to provide a technique that suppresses the decrease of a contact pressure due to creep in a crimping part of a single core electric wire and a terminal.

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Solution to Problem

According to one aspect of the present invention, there is provided a terminal crimping structure of a single core electric wire, including a single core wire coated with an electric wire coat and a terminal fitting, wherein the single core wire has a hollow part formed therein along an extending direction, and the hollow part is collapsed in a crimping part of the exposed single core wire and the terminal fitting.

According to another aspect of the present invention, there is provided a single core electric wire, including a single core wire coated with an electric wire coat, wherein the single core wire includes a hollow part formed therein and the hollow part is collapsed when a terminal fitting is crimped in a part in which the single core wire is exposed.

The hollow part may be formed along an extending direction of

the single core wire.

Advantageous Effects of Invention

According to the invention, it is possible to provide a
5 technique that suppresses the decrease of a contact pressure due to
creep in a crimping part of a single core electric wire and a terminal.

Brief Description of the Drawings

Fig. 1A is a diagram showing a structure of a crimping part
10 formed with a terminal and a single core electric wire under a state
before a crimping operation according to a usual technique.

Fig. 1B is a diagram for explaining a contact pressure under a
crimped state according to a usual technique.

Fig. 1C is a diagram for explaining a contact pressure under a
15 crimped state according to a usual technique.

Fig. 2A is a diagram showing a single core electric wire
according to an exemplary embodiment and seen from a terminal
side in which a hollow single core wire 20 is exposed.

Fig. 2B is a diagram showing a single core electric wire
20 according to an exemplary embodiment and is a perspective view of
a side surface side.

Fig. 3A is a diagram showing a state that the single core
electric wire and the terminal are separately arranged before a
crimping operation.

25 Fig. 3B is a diagram showing a state that the single core

electric wire and the terminal are arranged immediately before the crimping operation.

Fig. 3C is a diagram showing a state after the terminal 60 is crimped to the single core electric wire 10.

5 Fig. 4 is a diagram showing a crimping part before a crimping operation in the exemplary embodiment.

Fig. 5 is a diagram showing the crimping part under a crimped state in the exemplary embodiment.

10 Fig. 6A is a diagram showing a single core electric wire according to a modified example of the exemplary embodiment and seen from a terminal side in which a hollow single core wire is exposed.

15 Fig. 6B is a diagram showing a single core electric wire according to a modified example of the exemplary embodiment and is a perspective view of a side surface side.

Fig. 7 is a diagram showing one example of a manufacturing method of a hollow single core wire according to the modified example of the exemplary embodiment.

20 Description of Embodiments

Now, a mode for carrying out the present invention (refer it to as an "exemplary embodiment", hereinafter) will be described below by referring to the drawings. Figs. 2A and 2B are diagrams showing a single core electric wire 10 according to the present exemplary
25 embodiment. Fig. 2A is a diagram seen from a terminal side in

which a hollow single core wire 20 is exposed. Fig. 2B is a perspective view of a side surface side. As shown in the drawings, the single core electric wire 10 includes a hollow single core wire 20 and an electric wire coat 40. The hollow single core wire 20 is a conductor made of, for instance, aluminum alloy, copper or copper alloy. The electric wire coat 40 is an insulating material covering the hollow single core wire 20. Here, in a terminal part of the single core electric wire 10, the electric wire coat 40 is peeled off by a prescribed length to expose the hollow single core wire 20.

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Further, as a characteristic structure of the present exemplary embodiment, the hollow single core wire 20 includes a hollow part 30. As shown in the drawings, the hollow part 30 is formed in a circular shape in section in the central part of a section of the hollow single core wire 20 and is formed in an extending direction (a direction of a central axis) of the hollow single core wire 20. Namely, the hollow single core wire 20 has a tubular form. The sectional forms of the hollow single core wire 20 and the hollow part 30 are exemplified as the circular forms; however, the present invention is not limited thereto. Various kinds of forms which function as the single core electric wire 10 may be used.

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Figs. 3A to 3C are diagrams showing a state that a terminal 60 is crimped to the hollow single core wire 20. Specifically, Fig. 3A shows a state that the single core electric wire 10 and the terminal

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60 are separately arranged before a crimping operation. Fig. 3B shows a state the single core electric wire 10 and the terminal 60 are arranged immediately before the crimping operation. Fig. 3C shows a state after the terminal 60 is crimped to the single core electric wire 10. In order to pay attention to Fig. 3B and Fig. 3C, a connecting part 64 in the terminal 60 which is not related to the crimping operation is shown by a broken line.

The terminal 60 is an ordinary female type terminal and includes a barrel part 62 to be crimped and connected to the hollow single core wire 20 and a box shaped connecting part 64 connected to a corresponding male type terminal. The terminal 60 is formed in a prescribed shape by press working and then bending a plate material made of aluminum alloy, copper or copper alloy. Here, as the terminal 60, the female type terminal is exemplified; however, a male type terminal may be used.

As shown in Fig. 3A, in order to have the terminal 60 crimped to the single core electric wire 10, in the terminal part of the single core electric wire 10, the electric wire coat 40 is initially peeled off by a prescribed length to expose the hollow single core wire 20.

Then, as shown in Fig. 3B, a terminal part of the exposed hollow single core wire 20 is arranged in the barrel part 62 of the terminal 60. Fig. 4 shows a sectional view of a crimping part 80

corresponding to Fig. 3B. At this time, since a crimping jig does not operate, the hollow part 30 is not deformed and the section of the hollow part 30 remains circular.

5 Subsequently, as shown in Fig. 3C, both barrel end parts 66 of the barrel part 62 are crimped so as to be joined to each other so that the crimping part 80 is formed. Fig. 5 shows a sectional view of the crimping part 80 corresponding to Fig. 3C. As shown in the drawing, when the terminal 60 is crimped to the single core electric
10 wire, the hollow part 30 is vertically collapsed in its section and has an elongated form in a transverse direction. When the hollow part 30 is collapsed in such a way, a load during the crimping operation is dispersed and equalized in an entire part of the crimping part 80, that is, areas A to C. As a result, a contact pressure of the hollow single
15 core wire 20 and the terminal 60 is equalized. Accordingly, the decrease of the contact pressure due to creep is suppressed. Thus, an increase of contact resistance of the hollow single core wire 20 and the terminal 60 can be suppressed.

20 When the contact resistance of the hollow single core wire 20 and the terminal 60 is increased, it could happen that a voltage drop which is not estimated may arise or noise is generated due to instability of a voltage gap. For instance, in a recent vehicle, enormous data is transmitted and received to control the vehicle.
25 Under circumstances that a small-signal transmission or a high

speed transmission of signals is made, a large problem is to remove noise. Ordinarily, it is difficult and unstable to quantitatively grasp the increase of the contact resistance caused by the creep. Thus, the increase of the contact resistance constitutes a large problem in view of the compatibility of a cost and a signal quality in a signal transmission.

However, as in the present exemplary embodiment, when the hollow part 30 is provided to form the crimping part 80, the load in the crimping part 80 can be equalized as described above. Thus, since the contact pressure can be restrained from lowering, the increase of the contact resistance can be suppressed. Accordingly, an electrical connection of high quality is easily ensured even by the single core electric wire 10 of a low cost. As a result, since the voltage drop can be suppressed so as to be minimized, a transmitting efficiency can be improved. Further, the small-signal transmission or the high speed transmission of signals which is usually difficult can be achieved even by the single core electric wire 10. In a technical field of a high voltage power transmission from an electric power plant, a technique is known that a plurality of core wires having hollow structures are bundled and used as a high voltage electric wire (for instance, JP-UM-A-59-16010). However, this technique takes it into consideration to lighten a wiring, and a plurality of hollow pipe shaped aluminum wires are twisted in an outer layer side of a steel core (an inner layer) in this technique.

Then, the hollow pipe shaped aluminum wires have their strength set so as not to be collapsed. Namely, this technique is based on an idea completely opposite to that of the present exemplary embodiment that the hollow part 30 is formed which is supposed to be collapsed.

The present invention is described above in accordance with the exemplary embodiment. It is to be understood to a person with ordinary skill in the art that the exemplary embodiment is an example and various modified examples of component elements and combinations thereof may be made and the modified examples are included within the scope of the present invention.

Figs. 6A and 6B are diagrams showing a single core electric wire 10a according to a modified example. Fig. 6A is a diagram seen from a terminal side in which a hollow single core wire 20a is exposed. Fig. 6B is a perspective view of a side surface side. The single core electric wire 10a is different from the single core electric wire 10 shown in Fig. 2 in a form of a hollow single core wire 20a. Namely, the hollow single core wire 20a includes a hollow central part 30a having the same form as that of the hollow part 30 in section and a hollow side surface part 32a extending to an outer periphery from the hollow central part 30a. That is, the hollow single core wire 20a has a hollow structure of a substantially C shaped section.

Fig. 7 is a diagram showing one example of a manufacturing method of the hollow single core wire 20a. The hollow single core wire 20a is formed by drawing an elongated plate shaped member 25 made of metal such as aluminum alloy or copper alloy by a die 90.

5 When a terminal 60 is crimped to the single core electric wire 10a having the hollow single core wire 20a formed in such a way, the same operation and effects as those of the above-described embodiment are obtained.

The present application is based on Japanese patent
10 application No. 2011-147057 filed on July 1, 2011, and the contents of the patent application are hereby incorporated by reference.

Industrial Applicability

The present invention is useful for providing a terminal
15 crimping structure of a single core electric wire, capable of to providing a technique that suppresses the decrease of a contact pressure due to creep in a crimping part of a single core electric wire and a terminal.

20 Reference Signs List

- 10, 10a single core electric wire
- 20, 20a hollow single core wire
- 25 plate shaped member
- 30 hollow part
- 25 30a hollow central part

	32a	hollow side surface part
	40	electric wire coat
	60	terminal
	62	barrel part
5	64	connecting part
	66	barrel end part
	80	crimping part
	90	die

CLAIMS

1. A terminal crimping structure of a single core electric wire,
comprising a single core wire coated with an electric wire coat and a
5 terminal fitting, wherein

the single core wire has a hollow part formed therein along an
extending direction, and

the hollow part is collapsed in a crimping part of the exposed
single core wire and the terminal fitting.

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2. A single core electric wire, comprising a single core wire
coated with an electric wire coat, wherein

the single core wire includes a hollow part formed therein, and

the hollow part is collapsed when a terminal fitting is crimped

15 in a part in which the single core wire is exposed.

3. The single core electric wire according to claim 2, wherein

the hollow part is formed along an extending direction of the
single core wire.

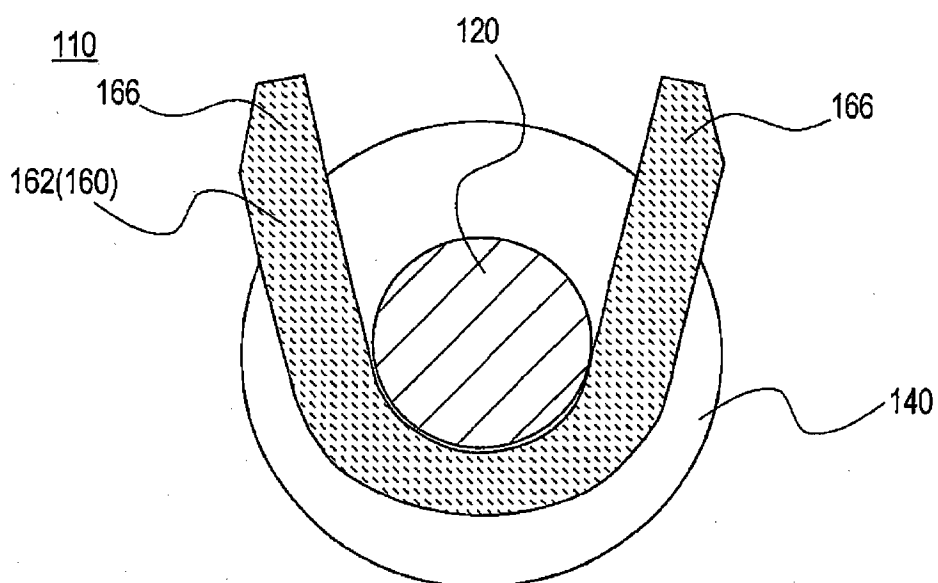
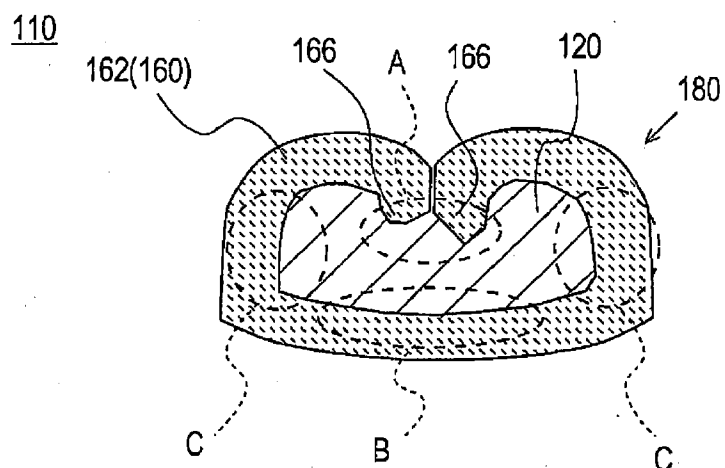
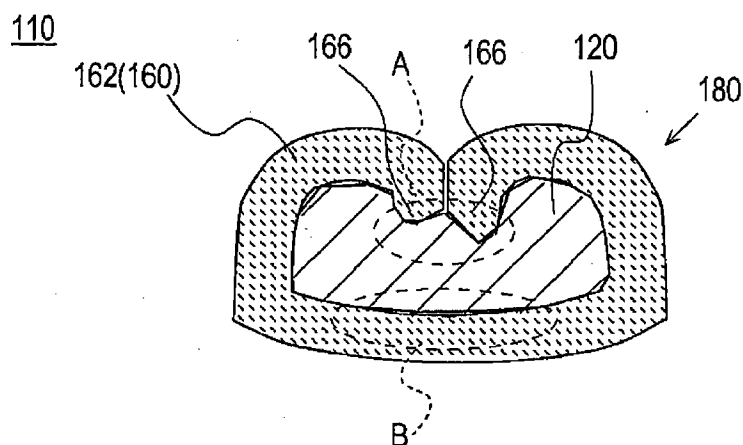
FIG. 1A**FIG. 1B****FIG. 1C**

FIG.2A

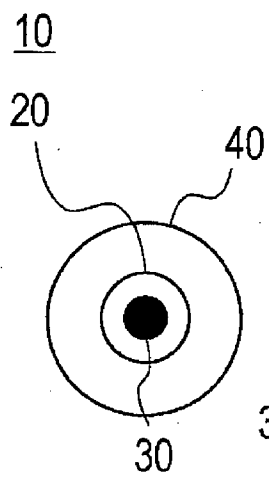


FIG.2B

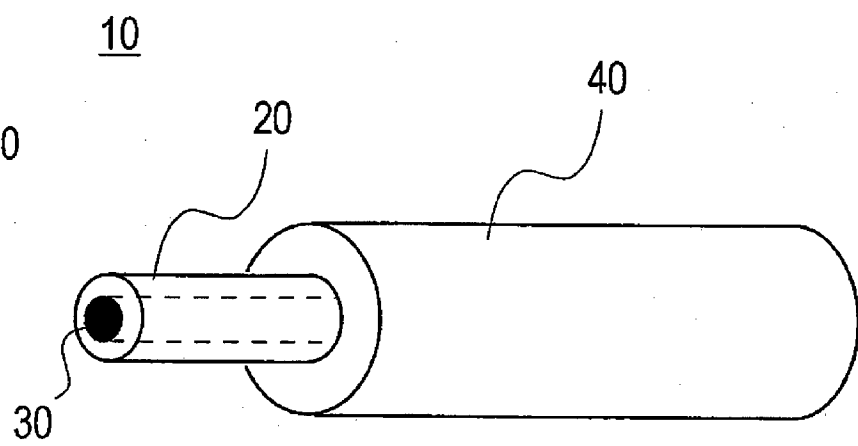


FIG.3A

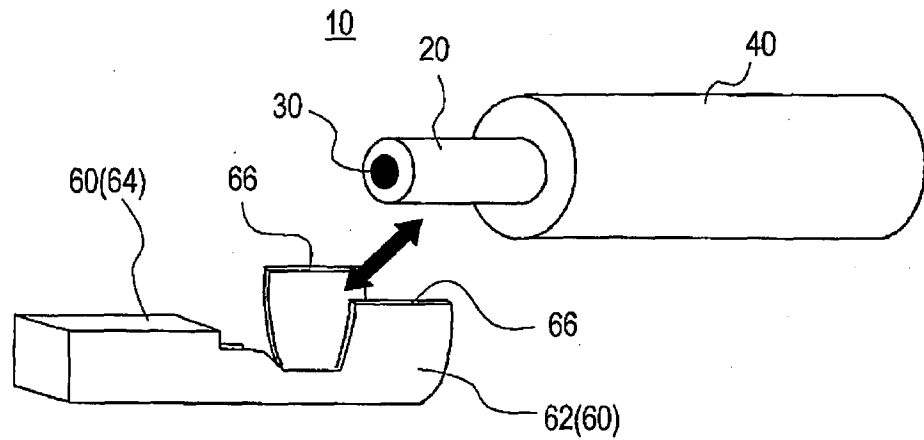


FIG.3B

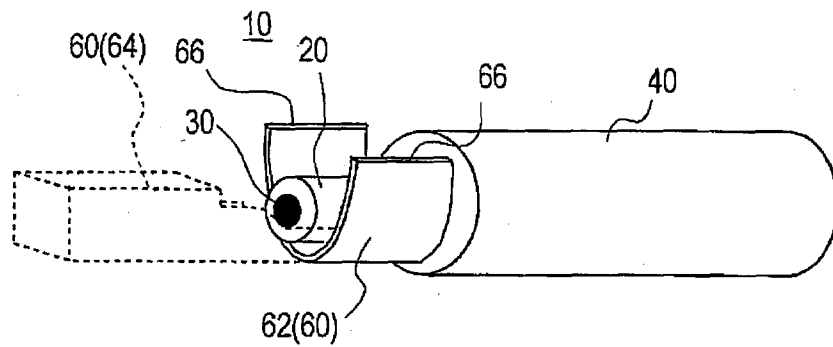


FIG.3C

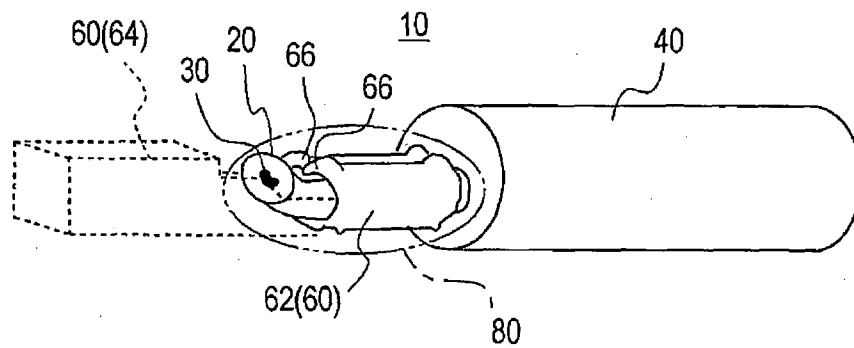


FIG. 4

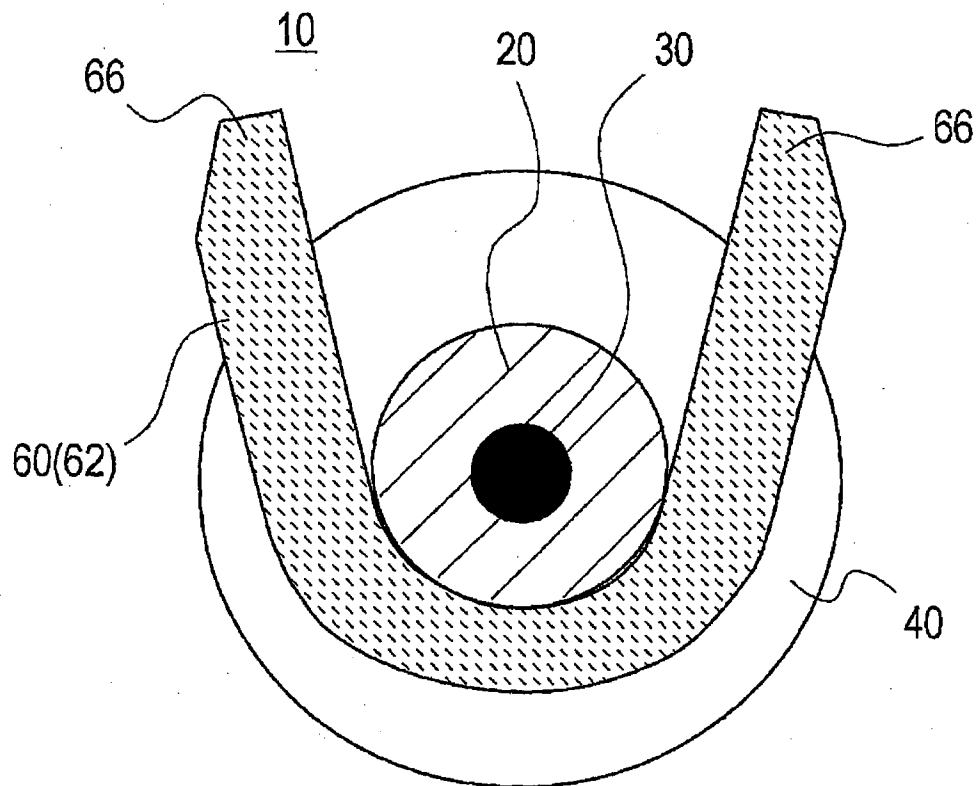


FIG. 5

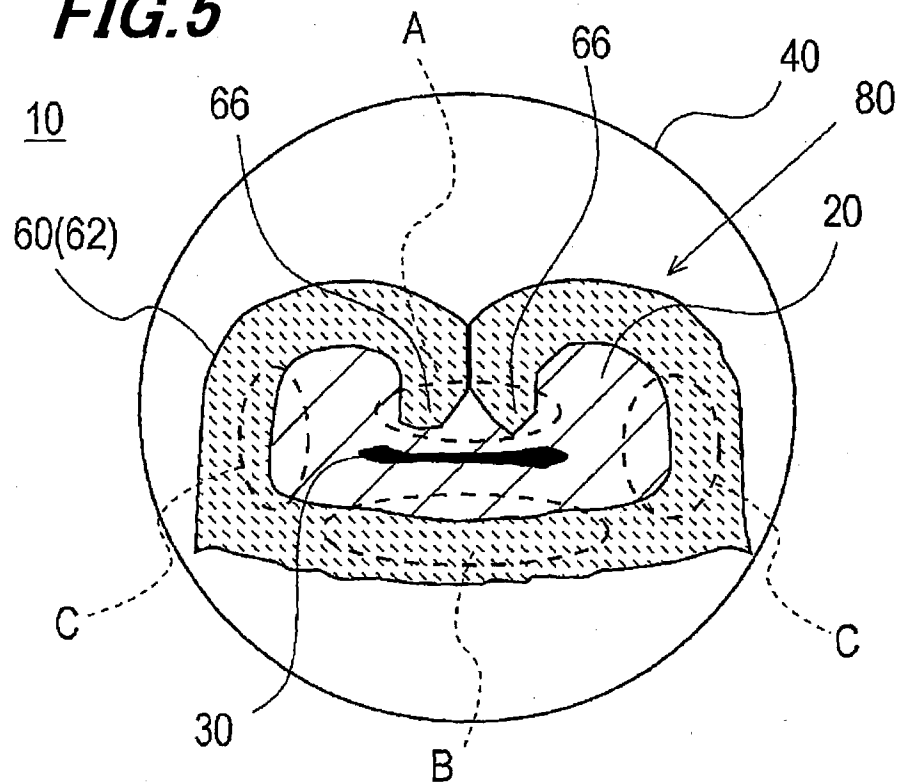


FIG. 6A **FIG. 6B**

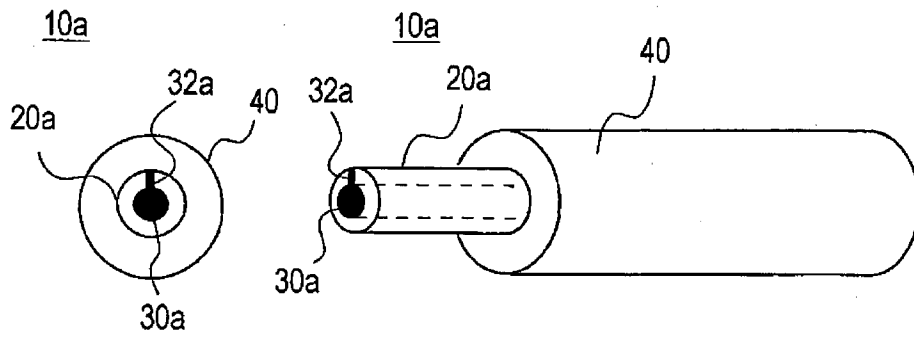
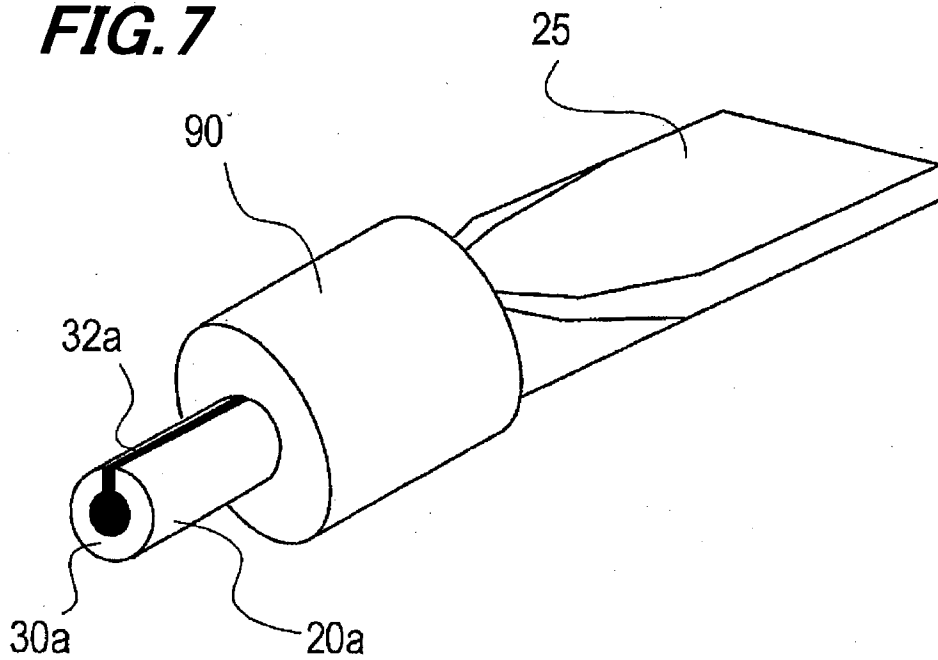


FIG. 7



INTERNATIONAL SEARCH REPORT

International application No
PCT/JP2012/066626

A. CLASSIFICATION OF SUBJECT MATTER
INV. H01R4/18
ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
H01B H01R B60R

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 5 796 043 A (MARUYAMA MASARU [JP]) 18 August 1998 (1998-08-18) the whole document	1-3
A	----- CN 2 462 519 Y (MA LIJUN [CN]) 28 November 2001 (2001-11-28) the whole document -----	1-3



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents :

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Date of the actual completion of the international search

17 September 2012

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25/09/2012

Name and mailing address of the ISA/

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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/JP2012/066626

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
US 5796043	A	18-08-1998	JP 3147219 B2	19-03-2001
			JP 9190842 A	22-07-1997
			US 5796043 A	18-08-1998

CN 2462519	Y	28-11-2001	NONE	
