

Tools for crimp termination – D-Sub-S, D-Sub-HD, DIN 41 612

Identification	Part No.	
Service crimp tool for single D-Sub standard contacts for single D-Sub high density contacts	09 99 000 0175 09 99 000 0596	
HARTING-Crimp tool for 500 bandoliered D-Sub standard contacts for 500 bandoliered D-Sub high density contacts	09 99 000 0169 09 99 000 0597	
HARTING-Semi-automatic crimping device Main drive foot-operated 220 V / 50 Hz Crimping head for bandoliered D-Sub standard contacts for DIN 41 612 contacts, types BC FC 1 FC 2 FC 3 BC solid wire Reel holder for 10 000 contacts	09 99 000 0246 09 99 000 0253 09 99 000 0252 09 99 000 0249 09 99 000 0250 09 99 000 0251 09 99 000 0628 09 99 000 0158	Wire gauge 0.09-0.56 mm ² (AWG 28-20) 0.09 - 0.5 mm ² 0.09 - 0.25 mm ² 0.14 - 0.56 mm ² 0.5 - 1.5 mm ² 0.13 mm ² (solid wire)
Insertion and removal tool for single D-Sub standard contacts for single D-Sub high density contacts	09 99 000 0171 09 99 000 0513	 <p>Assembly of crimp contacts After crimping the stranded wire to the contact using a hand tool or automatic crimping device, insert the contact into the chamber with the tool, working from the wiring side. You will hear the contacts snap home and to check that they are securely in place, give the wire a gentle pull.</p> <p>Removing crimp contacts Position the tool from the wiring side as shown in the diagram below and insert into the contact chamber. The contact can then easily be removed from the wiring side together with the wire itself and reinserted in a different chamber. The tool is designed for a maximum insulation diameter of Ø 1.7 mm.</p>

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Automated crimping machine type BK



Main characteristics

- Smooth run through electronic brakes
- Hand wheel for manual adjustments
- Maintenance friendly through needle bearing rail
- Simple handling by quick change tool and stripper

Part No. 09 98 000 5000

Technical characteristics

Dimensions	
Height	690 mm (1400 mm with a contact reel)
Width	350 mm
Depth	370 mm
Total weight	72 kg
Power supply	230 V, 50/60 Hz, 2.5 A
Consumption	0.75 kW
Motor speed	440 - 2000 rpm
Cable length	2 m incl. plug
Control	SPS
Work cycle trigger	Sensor
Work cycle	0.35 s for stripping and crimping
Illumination	Integrated tool light
Stroke counter	Daywise and fixed
Crimp force monitor	BB07i
Crimping tool	Quick change tool
Adjustable process parameters	Crimping height on wire Crimping height on insulation Depth of insulation stripping Length of insulation stripping Wire retainer position Wire position in the crimp contact Band thrust

Tooling

Identification	for use with	Part No.	Wire gauge [mm ²]	AWG	Insulation [Ø mm]
Crimping tool for D-Sub connectors ¹⁾	standard contacts	09 98 000 3008	0.09 - 0.25	28 - 24	0.7 - 1.4
		09 98 000 3009	0.25 - 0.56	24 - 20	0.9 - 1.7
	high density contacts	09 98 000 3012		26 - 24	0.8 - 1.4

Further details you will find in our product flyer.

¹⁾ 2.5 + 0.5 mm of insulation is stripped from the wire to be crimped

Tools for crimp termination – D-Sub-S, D-Sub-HD

Identification

Part No.

Drawing

Crimp tool

for turned male
and female contacts
AWG 28-18

8 indent crimp
in acc. to MIL 22 520/2-01

09 99 000 0501








Part No. contact	Part No. locator	Crimp tool selection no.
61 03 000 0112	61 03 600 0024	7
61 03 000 0113	61 03 600 0024	7
61 03 000 0073	61 03 600 0023	7
61 03 000 0074	61 03 600 0023	7
61 03 000 0094	61 03 600 0023	7
61 03 000 0096	61 03 600 0023	7
61 03 000 0078	61 03 600 0023	7
61 03 000 0080	61 03 600 0023	7

Locator for crimp tool
Details see table

61 03 600 0023
61 03 600 0024









Tools for crimp termination – D-Sub-M

Identification	Part No.																												
Hand crimp tool for signal contacts	09 99 000 0501	 Wire gauge AWG 18 – 28																											
Die (To be ordered separately.)	09 99 000 0502																												
Hand crimp tool with fixed die for signal contacts	09 99 000 0505	 Wire gauge AWG 20 – 28																											
Hand crimp tool for power contacts	09 99 000 0509																												
Positioner for male and female contacts (To be ordered separately.)	09 99 000 0504	<table border="1"> <thead> <tr> <th>Contact Part No.</th> <th>Gauge</th> <th>Tool setting</th> </tr> </thead> <tbody> <tr> <td>09 69 182 5420</td> <td>AWG 16, 18, 20</td> <td>3 for AWG 16, 2 for AWG 18 and AWG 20</td> </tr> <tr> <td>09 69 282 5420</td> <td>AWG 16, 18, 20</td> <td>3 for AWG 16, 2 for AWG 18 and AWG 20</td> </tr> <tr> <td>09 69 182 5421</td> <td>AWG 12, 14</td> <td>5 for AWG 12 and 4 for AWG 14</td> </tr> <tr> <td>09 69 282 5421</td> <td>AWG 12, 14</td> <td>5 for AWG 12 and 4 for AWG 14</td> </tr> <tr> <td>09 69 182 5422</td> <td>AWG 10, 12</td> <td>7 for AWG 10 and 6 for AWG 12</td> </tr> <tr> <td>09 69 282 5422</td> <td>AWG 10, 12</td> <td>7 for AWG 10 and 6 for AWG 12</td> </tr> <tr> <td>09 69 182 5423</td> <td>AWG 8, 10</td> <td>7 for AWG 8 and 6 for AWG 10</td> </tr> <tr> <td>09 69 282 5423</td> <td>AWG 8, 10</td> <td>7 for AWG 8 and 6 for AWG 10</td> </tr> </tbody> </table>	Contact Part No.	Gauge	Tool setting	09 69 182 5420	AWG 16, 18, 20	3 for AWG 16, 2 for AWG 18 and AWG 20	09 69 282 5420	AWG 16, 18, 20	3 for AWG 16, 2 for AWG 18 and AWG 20	09 69 182 5421	AWG 12, 14	5 for AWG 12 and 4 for AWG 14	09 69 282 5421	AWG 12, 14	5 for AWG 12 and 4 for AWG 14	09 69 182 5422	AWG 10, 12	7 for AWG 10 and 6 for AWG 12	09 69 282 5422	AWG 10, 12	7 for AWG 10 and 6 for AWG 12	09 69 182 5423	AWG 8, 10	7 for AWG 8 and 6 for AWG 10	09 69 282 5423	AWG 8, 10	7 for AWG 8 and 6 for AWG 10
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Hand crimp tool for coaxial contacts, solder/crimp version ¹⁾	09 99 000 0503																												
Die (To be ordered separately.)	09 99 000 0508	 <table border="1"> <thead> <tr> <th>Contact Part No.</th> <th>Cavity</th> </tr> </thead> <tbody> <tr> <td>09 69 181 x230</td> <td>B</td> </tr> <tr> <td>09 69 281 x230</td> <td>B</td> </tr> <tr> <td>09 69 181 x141</td> <td>C</td> </tr> <tr> <td>09 69 281 x141</td> <td>C</td> </tr> <tr> <td>09 69 181 x140</td> <td>B</td> </tr> <tr> <td>09 69 281 x140</td> <td>B</td> </tr> </tbody> </table>	Contact Part No.	Cavity	09 69 181 x230	B	09 69 281 x230	B	09 69 181 x141	C	09 69 281 x141	C	09 69 181 x140	B	09 69 281 x140	B													
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Die (To be ordered separately.)	09 99 000 0515	<table border="1"> <thead> <tr> <th>Contact Part No.</th> <th>Cavity</th> </tr> </thead> <tbody> <tr> <td>09 69 181 x143</td> <td>A</td> </tr> <tr> <td>09 69 281 x143</td> <td>A</td> </tr> </tbody> </table>	Contact Part No.	Cavity	09 69 181 x143	A	09 69 281 x143	A																					
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Die (To be ordered separately.)	09 99 000 0519	<table border="1"> <thead> <tr> <th>Contact Part No.</th> <th>Cavity</th> </tr> </thead> <tbody> <tr> <td>09 69 181 x233</td> <td>B</td> </tr> <tr> <td>09 69 281 x233</td> <td>B</td> </tr> </tbody> </table>	Contact Part No.	Cavity	09 69 181 x233	B	09 69 281 x233	B																					
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¹⁾ Only the outer ferrule is crimped (inner conductor is soldered)




Tools for crimp termination – D-Sub-M

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<p>Hand crimp tool for coaxial contacts, crimp/crimp version¹⁾, suitable for inner contact</p>	09 99 000 0501										
<p>Inner contact die (To be ordered separately.)</p>	09 99 000 0507	 <table border="1" data-bbox="1018 562 1361 913"> <thead> <tr> <th>Contact Part No.</th> </tr> </thead> <tbody> <tr><td>09 69 182 x140</td></tr> <tr><td>09 69 282 x140</td></tr> <tr><td>09 69 182 x230</td></tr> <tr><td>09 69 282 x230</td></tr> <tr><td>09 69 182 x232</td></tr> <tr><td>09 69 282 x232</td></tr> <tr><td>09 69 182 x233</td></tr> <tr><td>09 69 282 x233</td></tr> </tbody> </table>	Contact Part No.	09 69 182 x140	09 69 282 x140	09 69 182 x230	09 69 282 x230	09 69 182 x232	09 69 282 x232	09 69 182 x233	09 69 282 x233
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<p>Hand crimp tool for coaxial contacts, crimp/crimp version¹⁾, suitable for outer ferrule</p>	09 99 000 0503										
<p>Outer contact die (To be ordered separately.)</p>	09 99 000 0508	 <table border="1" data-bbox="1018 1261 1361 1406"> <thead> <tr> <th>Contact Part No.</th> <th>Cavity</th> </tr> </thead> <tbody> <tr><td>09 69 182 x140</td> <td rowspan="2">B</td> </tr> <tr><td>09 69 282 x140</td> </tr> <tr><td>09 69 182 x230</td> <td rowspan="2">B</td> </tr> <tr><td>09 69 282 x230</td> </tr> </tbody> </table>	Contact Part No.	Cavity	09 69 182 x140	B	09 69 282 x140	09 69 182 x230	B	09 69 282 x230	
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<p>Outer contact die (To be ordered separately.)</p>	09 99 000 0518	<table border="1" data-bbox="1018 1473 1361 1563"> <thead> <tr> <th>Contact Part No.</th> <th>Cavity</th> </tr> </thead> <tbody> <tr><td>09 69 182 x232</td> <td rowspan="2">A</td> </tr> <tr><td>09 69 282 x232</td> </tr> </tbody> </table>	Contact Part No.	Cavity	09 69 182 x232	A	09 69 282 x232				
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<p>Outer contact die (To be ordered separately.)</p>	09 99 000 0519	<table border="1" data-bbox="1018 1630 1361 1720"> <thead> <tr> <th>Contact Part No.</th> <th>Cavity</th> </tr> </thead> <tbody> <tr><td>09 69 182 x233</td> <td rowspan="2">B</td> </tr> <tr><td>09 69 282 x233</td> </tr> </tbody> </table>	Contact Part No.	Cavity	09 69 182 x233	B	09 69 282 x233				
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<p>Insertion and extraction tool for signal contacts</p>	09 99 000 0511										
<p>Extraction tool for coaxial, power and high voltage contacts</p>	09 99 000 0512										

Tooling

¹⁾ Both inner and outer conductor are crimped

Tools for crimp termination – InduCom

Identification	Part No.	Drawing																				
Hexagonal head screwdriver for hoods with hexagonal screws	61 03 600 0021																					
Crimp tool for flange and ferrule	61 03 600 0020	 <table border="1" data-bbox="774 790 903 1440"> <thead> <tr> <th>Width of hexagonal nut [mm]</th> </tr> </thead> <tbody> <tr><td>5.0</td></tr> <tr><td>5.5</td></tr> <tr><td>6.0</td></tr> <tr><td>6.5</td></tr> <tr><td>7.0</td></tr> <tr><td>7.5</td></tr> <tr><td>8.0</td></tr> <tr><td>8.5</td></tr> <tr><td>9.0</td></tr> <tr><td>9.5</td></tr> <tr><td>10.0</td></tr> <tr><td>10.5</td></tr> <tr><td>11.0</td></tr> <tr><td>11.5</td></tr> <tr><td>12.0</td></tr> <tr><td>12.5</td></tr> <tr><td>13.0</td></tr> <tr><td>13.5</td></tr> <tr><td>14.0</td></tr> </tbody> </table>	Width of hexagonal nut [mm]	5.0	5.5	6.0	6.5	7.0	7.5	8.0	8.5	9.0	9.5	10.0	10.5	11.0	11.5	12.0	12.5	13.0	13.5	14.0
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Inserts for crimp tool	61 03 000 0179 61 03 000 0180 61 03 000 0098 61 03 000 0099 61 03 000 0100 61 03 000 0101 61 03 000 0102 61 03 000 0103 61 03 000 0104 61 03 000 0105 61 03 000 0174 61 03 000 0172 61 03 000 0168 61 03 000 0169 61 03 000 0175 61 03 000 0176 61 03 000 0177 61 03 000 0178 61 03 000 0173																					
Mounting tool for flange for D-Sub hoods (9-37 contacts) for D-Sub hoods (50 contacts)	61 03 600 0017 61 03 600 0018																					
Insertion and removal tool for contacts	09 99 000 0171	