

Crimping tools



After stripping, appropriate contacts or wire end ferrules can be crimped to the cable end. It is not all that long ago that a secure connection between the conductor and contact was still achieved by soldering. "Crimping" has now been substituted extensively for this method.

"Crimping" means the creation of a uniform, unbreakable connection between the conductor and the connecting element. This is to be achieved exclusively by the use of high quality precision tools. The result is an electrically and mechanically secure connection.

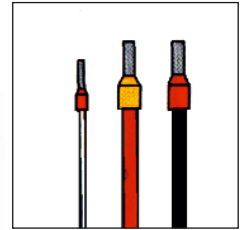
Weidmüller offers a wide range of mechanical crimping tools.

Integrated unlockable compression stops ensure optimum processing quality. The crimping results obtained with our tools correspond to international standards and regulations.

Crimping tools

stripax® plus 2.5

Stripping and crimping tool for ferrules



stripax® plus 2.5

Multifunctional tool for processing Weidmüller ferrules in strip form 0.5...2.5 mm² (~ AWG 20...14)

- Cuts
- Strips
- Automatic transport of ferrules
- Crimps
- Efficiency:
only one tool for cable processing: cuts / strips / crimps,
saves time considerably
- Easy-to-use ferrules:
- loaded in strips into handle of the stripax® plus 2.5
- automatic feed
- Conductor insertion from front for stripping and from the side for cutting and crimping
- Ferrules conform to DIN 46228 part 4
- Ratchet for precise crimping
- Ratchet release option in case of incorrect operation

Ferrules strip with 50 pieces only must be used.
The use of ferrules on reels may cause a fault.

Technical data		Ordering data	
Length	210 mm	Type	Cat. No.
Weight	260 g	stripax® plus 2,5	902000000
		Accessories	
		spare cutting blade	9050340000
		Ferrules in strip form see page	74 - 75

Crimping tools for ferrules

	PZ 1.5	stripax® plus 2.5	PZ 3	PZ 4	PZ 6 roto	PZ 6 HEX	PZ 6/5	PZ 16	PZ 50
Cat. No.	9005990000	9020000000	0567300000	9012500000	9014350000	9013650000	9011460000	9012600000	9006450000
see page	27	26	28	28	29	27	28	29	30

Crimping tools

PZ 4 • PZ 6/5 Crimping tools for ferrules

- Ferrule insertion from the side
- Ratchet for precise crimping
- Ratchet release option in case of incorrect operation



PZ 4

Crimping tool for ferrules according to DIN 46228 part 1 and 4 with and without plastic collars from 0.5...4 mm² (~ AWG 20...12)

- Only one crimping profile for the entire cross-section range



PZ 6/5

Crimping tool for ferrules according to DIN 46228 part 1 and 4 with and without plastic collars from 0.25...6 mm² (~ AWG 24...10)

- Crimp conforms to EN 60947-1
- Five crimping profiles for the rated conductor cross-sections
- Registration in accordance with VG 95211 (Military designation VG 95236 T 14 A 0001)

PZ 3 Crimping tool for ferrules



PZ 3

Crimping tool for ferrules according to DIN 46228 part 1 and 4 with and without plastic collars from 0.5...6 mm² (~ AWG 20...10)

- Ratchet for precise crimping
- Ratchet release option in case of incorrect operation
- Only one profile for entire wire range
- Ferrule insertion from the front

Technical data	
Length	200 mm
Weight	448 g

Ordering data	
Type	Cat. No.
PZ 4	9012500000

Accessories	
Ferrules see pages 74 - 79	

Technical data	
Length	200 mm
Weight	423 g

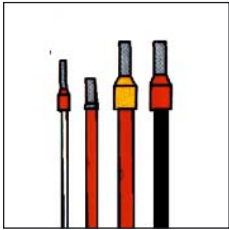
Ordering data	
Type	Cat. No.
PZ 6/5	9011460000

Accessories	
Ferrules see pages 74 - 79	

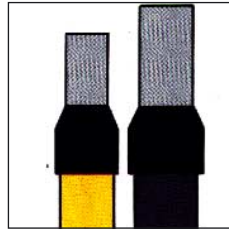
Technical data	
Length	200 mm
Weight	426 g

Ordering data	
Type	Cat. No.
PZ 3	0567300000

Accessories	
Ferrules see pages 74 - 79	



PZ 6 roto
Crimping tools
for ferrules



PZ 16 • PZ ZH 16
Crimping tools for ferrules

- Ratchet for precise crimping
- Ratchet release option in case of incorrect operation
- Ferrule insertion from the side



PZ 6 roto

Crimping tool for ferrules according to DIN 46228 parts 1 and 4 with and without plastic collars from 0.14 ... 6 mm² (~ AWG 26 ... 10)

- Ratchet for precise crimping
- Ratchet release option in case of incorrect operation
- Only one profile for entire wire range
- Rotatable crimp die for ferrule insertion from the front or the side



PZ 16

Crimping tool for ferrules according to DIN 46228 parts 1 and 4 with and without plastic collars from 6...16 mm² (~ AWG 10 ... 6)

- Three crimping profiles for rated conductor cross-sections
- Crimp conforms to EN 60947-1
- Registration in accordance with VG 95211 (Military designation VG 95236 T 14 B 002)



PZ ZH 16

Crimping tool for twin ferrules (requirement similar to DIN 46228 T.4) with plastic collars from 6...16 mm² (~AWG 10 ... 6)

- Three crimping profiles for rated conductor cross-sections
- Crimp conforms to EN 60947-1

Technical data	
Length	200 mm
Weight	428 g

Ordering data	
Type	Cat. No.
PZ 6 roto	9014350000

Accessories	
Ferrules see pages 74 - 79	

Technical data	
Length	200 mm
Weight	418 g

Ordering data	
Type	Cat. No.
PZ 16	9012600000

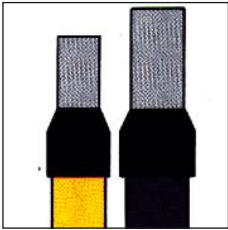
Accessories	
Ferrules see pages 74 - 79	

Technical data	
Length	260 mm
Weight	700 g

Ordering data	
Type	Cat. No.
PZ ZH 16	9013600000

Accessories	
Ferrules see pages 74 - 79	

Crimping tools



PZ 50
Crimping tool
for ferrules



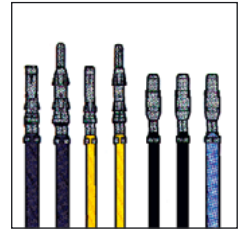
PZ 50

Crimping tool for ferrules from 25, 35 and 50 mm² with and without plastic collars according to DIN 46228 parts 1 and 4 (~ AWG 3 ... 1)

- Ratchet for precise crimping
- Ratchet release option in case of incorrect operation
- Ferrule insertion from the side
- Three crimping profiles for rated conductor cross-sections
- Crimp conforms to EN 60947-1
- Registration in accordance with VG 95211 (Military designation VG 95236 T 14 B 002)

HTF RSV • HTF DFF • HTF ZRV Crimping tools

- Ratchet for precise crimping
- Ratchet release option in case of incorrect operation
- Adjustable locator for exact positioning of contacts



HTF RSV 16 • HTF RSV 12

Crimping tools for Weidmüller RSV and DSTV-HD contacts

HTF RSV 16
0.14...1.5 mm² (AWG 26...16)

HTF RSV 12 2.5 mm² (AWG 14...12)

HTF DFF

Crimping tool for Weidmüller DFF contacts for cross-sections 0.22...2.5 mm (~ AWG 24...12)



HTF ZRV

Crimping tool for Weidmüller contacts from the ZRV contact system or for MKF flat contacts from Grote & Hartmann or other identical products from 0.2 ... 0.35 mm² and 0.5 ... 1.0 mm²

Technical data

Length	260 mm
Weight	700 g

Ordering data

Type	Cat. No.
PZ 50	9006450000

Accessories

Ferrules see pages 74 - 79

Technical data

Length	205 mm
Weight	445 g

Ordering data

Type	Cat. No.
HTF RSV 16	9013560000
HTF RSV 12	9013550000
HTF DFF	9014140000

Technical data

Length	200 mm
Weight	436 g

Ordering data

Type	Cat. No.
HTF ZRV	9014840000

Crimping tools

CTX CM • CZB 1 Crimping tools for turned contacts

- Ratchet for precise crimping
- Ratchet release option in case of incorrect operation



CTX CM 1.6/2.5 CTX CM 3.6

Crimping tools for HE-Series pin and socket contacts

CTX CM 1.6/2.5

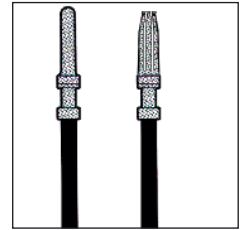
from 0.14 mm ... 4 mm²

- HD (for machined contacts)
- HE (for machined contacts)
- ConCept M 10-contacts
- ConCept M 5-contacts and similar

CTX CM 3.6

from 4.0 mm ... 10 mm²

- HD (for machined contacts)
- ConCept M 3-contacts and similar



CZB 1

Crimping tool for HE-Series pin and socket contacts
Cross-section 0.5...4.0 mm²
(4-Indent crimp)

Technical data

Length	260 mm
Weight	730 g

Ordering data

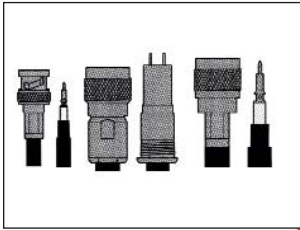
Type	Cat. No.
CTX CM 1,6/2,5	9018490000
CTX CM 3,6	9018480000

Technical data

Length	165 mm
Weight	230 g

Ordering data

Type	Cat. No.
CZB 1	9012710000



HTG 58 • HTG 59 • HTG 58-59
Crimping tools
for coaxial connectors

HTX LWL
Crimping tool
for fibre-optic connectors



HTG 58 • HTG 59 • HTG 58-59

Crimping tools for coaxial connectors such as BNC and TNC connectors with RG 58, RG 59, RG 62 and RG 71 cable

- Ratchet for precise crimping
- Ratchet release option in case of incorrect operation
- Crimping profiles for centre contact and outer sleeve

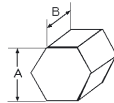
HTX LWL

Crimping tool for optical fibres 1 mm Ø, sleeve 5.5 mm Ø

- Ratchet for precise crimping
- Ratchet release option in case of incorrect operation

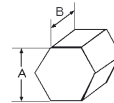
Crimp profile dimensions / Crimping width mm

A = Width across flats
B = Crimping width
C = Ø Outer sleeve of the coaxial plug
D = Ø Centre contact



	1. profile A/B	2. profile A/B	3. profile A/B	C	D
HTG 58	5.4/10	1.72/2.3		6.2	2.0
HTG 59	6.48/10	1.72/2.3		7.5	2.0
HTG 58-59	5.4/10	6.48/10	1.72/2.3	6.2/7.5	2.0

Crimp profile dimensions/ Crimping width mm



	1. profile hexagonal crimp A/B	2. profile round crimp Ø B
HTX LWL	3,15/6 sleeve Ø 3.9	4,85/6 sleeve Ø 5.5

Technical data

Length 200 mm
Weight 420 g

Ordering data

Type Cat. No.
HTG 58 901200000
HTG 59 9012010000
HTG 58-59 9012020000

Technical data

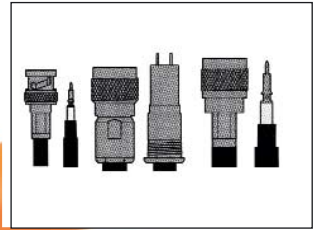
Length 200 mm
Weight 415 g

Ordering data

Type Cat. No.
HTX LWL 9011360000

Crimping tools

HTX 138 • HTG 174 • HTX 188 • CTX 500 • CTX 501 • CTX 502
Crimping tools for coaxial connectors



HTX 138 • HTG 174 • HTX 188

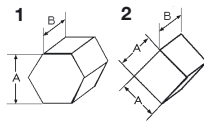
Crimping tools for coaxial connectors such as BNC, TNC and N connectors with coaxial cable

- Ratchet for precise crimping
- Ratchet release option in case of incorrect operation

HTX 138 for connectors on Twinax-coaxial cable

Crimp profile dimensions/ Crimping width mm

A = Width across flats
 B = Crimping width
 C = Ø Outer sleeve of the coaxial plug
 D = Ø Centre contact



	1. profile	2. profile	3. profile		
	A/B	A/B	A/B	C	D
HTX 138	8.24/ 10	1.72/ 2.3		9.5	2.0
HTG 174	4.52/ 10	1.72/ 2.3		7.5	2.0
HTX 188	3.25/ 10	1.72/ 2.3			

* (square crimp) refer to drawing 2

Technical data

Length	200 mm
Weight	420 g

Ordering data

Type	Cat. No.
HTX 138	901240000
HTG 174	9012410000
HTX 188	9011990000

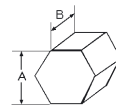
CTX 500 • CTX 501 • CTX 502

Crimping tools for coaxial connectors such as BNC, TNC and N connectors with coaxial cable

- Ratchet for precise crimping
- Ratchet release option in case of incorrect operation

Crimp profile dimensions/ Crimping width mm

A = Width across flats
 B = Crimping width
 C = Ø Outer sleeve of the coaxial plug
 D = Ø Centre contact



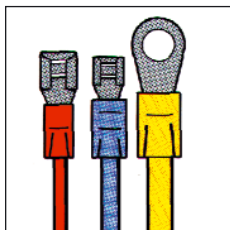
	1. profile	2. profile		
	A/B	A/B	C	D
CTX 500	10.54/ 12	2.54/ 3.17	12.2	2.9
CTX 501	10.9/ 12	2.45/ 3.17	12.6	2.8
CTX 502	9.3/ 12	1.75/ 2.3	10.7	2.0

Technical data

Length	260 mm
Weight	730 g

Ordering data

Type	Cat. No.
CTX 500	9006320000
CTX 501	9006370000
CTX 502	9006380000



HTI 15 · CTI 6 · CTI 6 S
Crimping tools for insulated cable lugs



HTI 15

Crimping tool for PVC, PC and polyamide-insulated cable lugs with a cross section 0.5...2.5 mm²

- Locator for exact positioning of crimping parts
- Ratchet for precise crimping
- Ratchet release option in case of incorrect operation

For

- Cable lugs
- Pin-type cable lugs
- Parallel and serial connectors
- Connectors

CTI 6 · CTI 6 S

Crimping tools for PVC, PC and polyamide-insulated cable lugs with a cross section 0.5...6 mm²

- Locator for exact positioning of crimping parts
- Ratchet for precise crimping
- Ratchet release option in case of incorrect operation

For

- Cable lugs
- Pin-type cable lugs
- Parallel and serial connectors
- Connectors

Technical data

Type	Length	Weight
HTI 15	200 mm	434 g

Crimpprofile red 0.5...1.5 mm² (~ AWG 20...16)
Crimpprofile blue 1.1...2.5 mm² (~ AWG 16...14)

Ordering data

Type	Cat. No.
HTI 15	9014400000

Technical data

Type	Length	Weight
CTI 6	260 mm	710 g
CTI 6 S	240 mm	660 g

Crimpprofile red 0.5...1.5 mm² (~ AWG 20...16)
Crimpprofile blue 1.1...2.5 mm² (~ AWG 16...14)
Crimpprofile yellow 2.6...6.0 mm² (~ AWG 12...10)

Ordering data

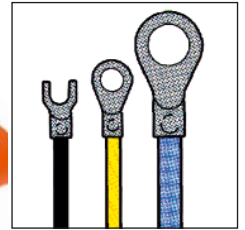
Type	Cat. No.
CTI 6	9006120000
CTI 6 S	9006210000

Crimping tools

HTN 21 • CTN 25

Crimping tools for non-insulated cable lugs

- Ratchet for precise crimping
- Ratchet release option in case of incorrect operation



HTN 21

Crimping tools for non-insulated cable lugs with a cross section 0.5...6 mm²

- rolled & brazed cable lugs
- Tube cable lugs
- Pin-type cable lugs
- Parallel and serial connectors
- Available with and without locator

CTN 25 D 4 • CTN 25 D 5

Crimping tools for non-insulated cable lugs with a cross section 10...25 mm²

CTN 25 D 4

- rolled and brazed cable lugs
- Pin-type cable lugs
- Parallel and serial connectors

CTN 25 D 5

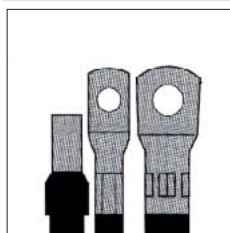
- Tube cable lugs and connectors

Technical data		
Type	Length	Weight
HTN 21	200 mm	427 g

Ordering data	
Type	Cat. No.
HTN 21 with locator	9014100000
HTN 21 without locator	9014610000

Technical data		
Type	Length	Weight
CTN 25 D 4	260 mm	685 g
CTN 25 D 5	260 mm	685 g

Ordering data	
Type	Cat. No.
CTN 25 D 4	9006220000
CTN 25 D 5	9006230000



MTR 35 • MTR 110
MTR 160 • MTR 300
 Crimping tools for connectors



MTR 35 · MTR 110

Crimping tools for connectors such as

- Tube cable lugs 6...120 mm²
- Ferrules 25...95 mm²
- Fast ratchet action for easy connector precentering and removal
- Precision mechanism enables high crimping pressure at low hand forces
- Purely mechanical function guarantees safe and easy handling under all conditions
- Ratchet for precise crimping
- Ratchet release option in case of incorrect operation
- Lockable hand lever for easy transportation eliminates danger of injury
- Comprehensive range of crimping die sets conforming to standards
- Customer-specific crimping die sets available on request
- Hinged head for easy removal of the crimped connector

MTR 160 · MTR 300

Crimping tools for connectors such as

- Tube cable lugs 10...300 mm²
- Rolled and brazed Cu connectors 10...150 mm²
- Fast ratchet action for easy connector precentering and removal
- Precision mechanism enables high crimping pressure at low hand forces
- Purely mechanical function guarantees safe and easy handling under all conditions
- Ratchet for precise crimping
- Ratchet release option in case of incorrect operation
- Lockable hand lever for easy transportation eliminates danger of injury
- Comprehensive range of crimping die sets conforming to standards
- Customer-specific crimping die sets available on request
- Hinged head for easy removal of the crimped connector (only only MTR 300)

Technical data	MTR 35	MTR 110
Crimping force kN	25	55
Crimping range mm ²		
Cu connectors (rolled and brazed)	6 ... 35	6 ... 70
Cu tube connectors	6 ... 50	10 ... 120
Ferrules	25 ... 50	70 ... 95
Insulated connectors	10 ... 25	10 ... 35
Travel mm	8	10.2
Length	270	420
Weight kg	1.3	2

Ordering data	Cat. No.
Type	
MTR 35	9017500000
MTR 110	9018020000

Accessories	
Carrying case for MTR 35 (not shown, Size 325x125x52 mm)	9017840000
Carrying case for MTR 110 (not shown, Size 450 x 200 x 55 mm)	9018040000
Crimping dies see page 38	
Ferrules see pages 74, 75, 78	

Technical data	MTR 160	MTR 300
Crimping force kN	100	100
Crimping range mm ²		
Cu connectors (rolled and brazed)	10 ... 150	10 ... 150
Cu tube connectors	10 ... 240	10 ... 300
Insulated connectors		10 ... 120
Die sets for prerounding		25 sm ... 240 sm 35 se ... 240 se
Travel mm	16.2	16
Length	540	540
Weight kg	4	4

Ordering data	Cat. No.
Type	
MTR 160	9017250000
MTR 300	9021390000

Accessories	
Carrying case for MTR 160	9017270000
Carrying case for MTR 300	9021420000
Crimping dies see page 38	



Crimping tools

Crimp inserts



MTR 35

Cross- Code No. Crimp Cat. No.
section DIN width
mm² 48083 mm



Die sets for **copper tube** cable lugs and connectors **DIN 46235**

	6	5	5.5	9017550000
	10	6	5.5	9017560000
	16	8	5.5	9017570000
	25	10	5.5	9017580000
	35	12	5.5	9017590000
	50	14	5.5	9017760000

Die sets for **aluminium tube** cable lugs and connectors **DIN 46829**



	25	12	7.0	9017600000
	35	14	7.0	9017610000
				



Die sets for **copper tube** cable lugs and connectors **standard types**



	6	6.0	9017770000
	10	6.0	9017620000
	16	6.0	9017630000
	25	6.0	9017640000
	35	6.0	9017650000
	50	6.0	9017660000

MTR 110

Cross- Code No. Crimp Cat. No.
section DIN width
mm² 48083 mm

	10/70	6/16	5.5	9018100000
	16/35	8/12	5.5	9018110000
	25/50	10/14	5.5	9018120000
	95	18	5.5	9018130000
	120	20	5.5	9018140000



	16/35	10/14	7.0	9018800000
	25/50	12/16	7.0	9018810000
	70	18	7.0	9018820000

	10/70	7.0	9018400000
	16/35	7.0	9018410000
	25/50	7.0	9018420000
	95	5.0	9018430000
	120	5.0	9018440000



MTR 160

Cross- Code No. Crimp Cat. No.
section DIN width
mm² 48083 mm

Die sets for **copper tube** cable lugs and connectors **DIN 46235**



	10	6	7.0	9020900000
	16	8	7.0	9020910000
	25	10	7.0	9020920000
	35	12	7.0	9020930000
	50	14	7.0	9020940000
	70	16	7.0	9020950000
	95	18	7.0	9020960000
	120	20	7.0	9020970000
	150	22	7.0	9020980000
	185	25	7.0	9020990000
	240	28	7.0	9021000000



Die sets for **copper tube** cable lugs and connectors **standard types**

	10/25	9.8	9021750000
	16/35	9.8	9021760000
	50	8.0	9021770000
	70	8.0	9021780000
	95	8.0	9021790000
	120	8.0	9021800000
	150	8.0	9021810000
	185	8.0	9021820000
	240	8.0	9021830000



MTR 300





Cross- Code No. Crimp Cat. No.
section DIN width
mm² 48083 mm

	10	6	7.0	9021430000
	16	8	7.0	9021440000
	25	10	7.0	9021450000
	35	12	7.0	9021460000
	50	14	7.0	9021470000
	70	16	7.0	9021480000
	95	18	7.0	9022290000
	120	20	7.0	9022300000
	150	22	7.0	9022310000
	185	25	7.0	9022320000
	240	28	7.0	9022330000
	300	32	7.0	9022340000

	10/25	9.8	9024010000
	16/35	9.8	9024400000
	50	8.0	9024410000
	70	8.0	9024420000
	95	8.0	9024430000
	120	8.0	9025210000
	150	8.0	9025220000
	185	8.0	9025230000
	240	8.0	9028020000



Indentors and dies for solder-less copper cable lugs and connectors
DIN 46234, DIN 46341, T1

	Indentor	9017670000
	6...35 mm ²	
	Die	9017680000
	6 mm ²	
	Die	9017690000
	10 mm ²	
	Die	9017700000
	16 mm ²	
	Die	9017710000
	25 mm ²	
	Die	9017720000
	35 mm ²	
	with control mark	


	Indentor	9018500000
	6...70 mm ²	
	4 die	9018600000
	10/16/25/35 mm ²	
	4 die	9018610000
	16/25/35/50 mm ²	
	2 die	9018620000
	6/50 mm ²	
	2 die	9018630000
	10/70 mm ²	
	Single die	9018640000
	70 mm ²	
	with control mark	

Die sets for solder-less copper cable lugs and connectors with insulation to
DIN 46231, 46237, 46245, 46341, T2


	10 mm ²	9017990000
	16 mm ²	9018000000
	25 mm ²	9018010000

	10 mm ²	7.0	9018700000
	16 mm ²	8.0	9018710000
	25 mm ²	9.0	9018720000
	35 mm ²	9.5	9018730000
	Oval crimp	with control mark	
	Crimp die with locator		


Prerounding die sets for sectored cable

	25/50 mm ²	12	9018450000
	35/70 mm ²	12	9018460000
	95 mm ²	12	9018470000



Indentor and die sets for ferrules





	Indentor	25...50 mm ²	9017970000
	Die	25 mm ²	9017740000
	Die	35 mm ²	9017750000
	Die	50 mm ²	9017540000

Die sets for ferrules



	Die set 70 mm ²	9023360000
	Die set 95 mm ²	9023370000

Die sets for solderless copper cable lugs and connectors
DIN 46234, DIN 46341, T1


	10	9021300000
	16	9021310000
	25	9021320000
	35	9021330000
	50	9021340000
	70	9021350000
		
	95	9021360000
	120	9021370000
	150	9021380000
	with control mark	

	Double nest dies	
	16/35	9022360000
	10/70	9022350000
	25 / 50	9022370000
	Indentor	
	10 - 70	9022990000
	Single nest die	
	95	9022380000
	120	9022390000
	150	9022400000
	Indentor	
	95-150	9023110000

Die sets for solder-less copper cable lugs and connectors with insulation to
DIN 46231, 46237, 46245, 46341, T2

	10	9016180000
	16	9016190000
	25	9016200000
	35	9016210000
	50	9016220000
	70	9016230000
	95	9016240000
	120	9016250000

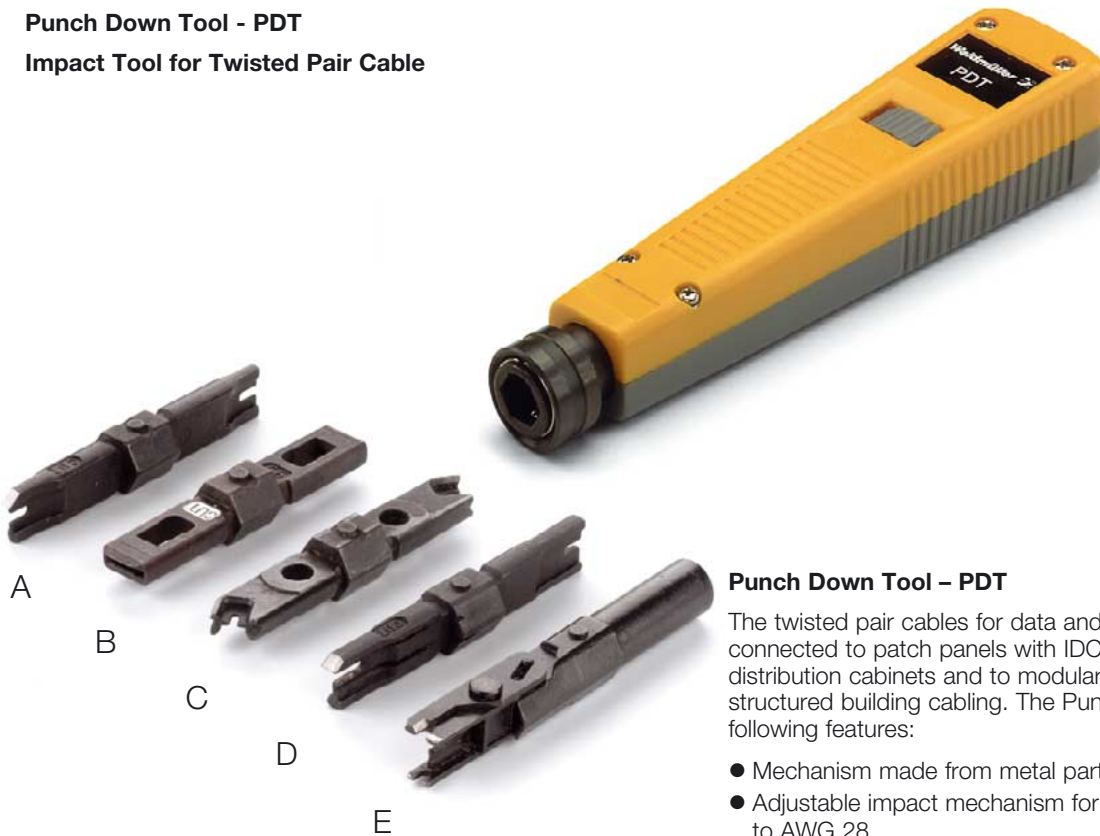
Prerounding die sets for Cu/Al

	25 sm/35 se	9016260000
	35 sm/50 se	9016270000
	50 sm/70 se	9016280000
	70 sm/95 se	9016290000
	95 sm/120 se	9016370000
	120 sm/150 se	9016380000
	150 sm/185 se	9016390000
	185 sm/240 se	9016440000
	240 sm	9016500000

Crimping tools

Punch Down Tool - PDT

Impact Tool for Twisted Pair Cable



Punch Down Tool – PDT

The twisted pair cables for data and voice throughput are connected to patch panels with IDC contacts in building or floor distribution cabinets and to modular wall outlet sockets in the structured building cabling. The Punch Down Tool provides the following features:

- Mechanism made from metal parts
- Adjustable impact mechanism for conductor sizes AWG 20 to AWG 28
- Different punch down blades for terminal blocks 110 type (from AT&T), 66 type, LSA Plus type from Krone (standard and scissors type cutting function) as well as for phone jacks 630A6
- Reversible clip-in blades to punch down or to punch down and to cut off the excess conductors
- Spare blade storage in handle

Technical data

Punch Down Tool

Length/width/height	160/37/29 mm
Weight	142 g

Punch down blade

Length	approx. 60 mm
Weight	16 g

Ordering data

Type	Cat. No.	
Punch Down Tool PDT (without blades)	9013970000	
PD Blade 110	9013960000	(A)
PD Blade 66	9013980000	(B)
PD Blade 630	9013990000	(C)
PD Blade Krone LSA Plus (Standard)	9014000000	(D)
PD Blade Krone LSA Plus (scissors type)	9014050000	(E)

Crimping tools

Crimping of ferrules

Optimum crimp of various cross-sections (good sample)

Examples of visual assessment for crimps with Weidmüller tools and crimping machines.

Front view:



0.5 mm²



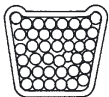
0.75 mm²



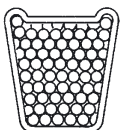
1.0 mm²



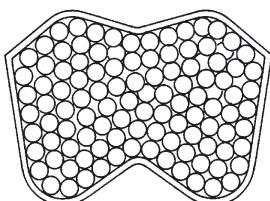
1.5 mm²



2.5 mm²

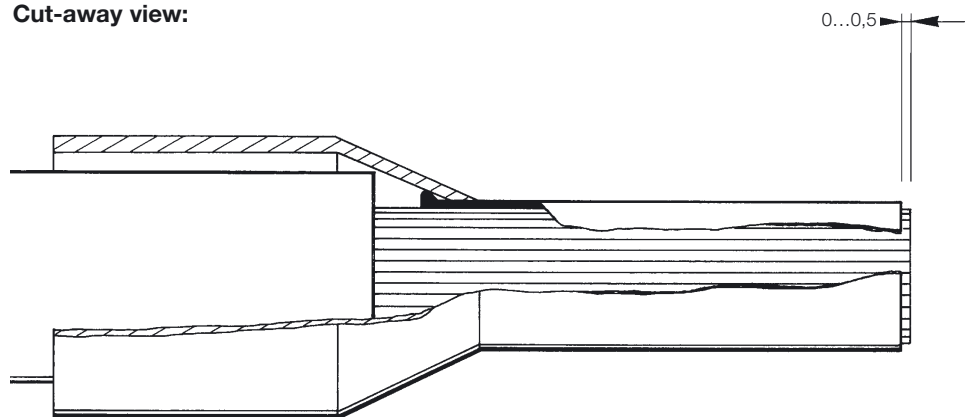


4.0 mm²



The crimp shape is nearly the same for cross-sections 6 – 50 mm².

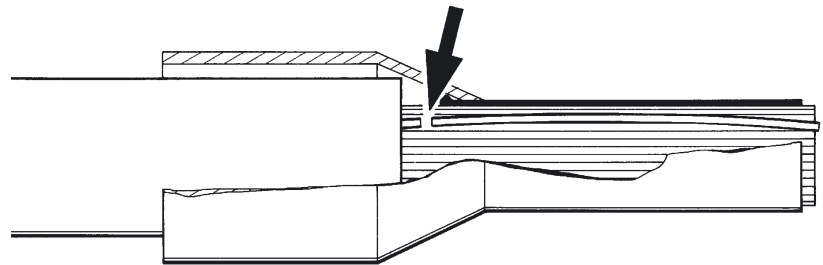
Cut-away view:



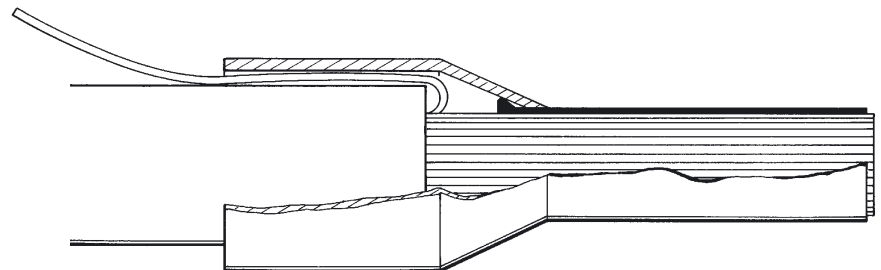
The conductor insulation must be pushed into the insulating collar. The cavity of the ferrule must be completely filled by the conductor. Depending on cross-section, the conductor should protrude approx. 0...0.5 mm from the ferrule cavity.

Incorrect combination of cable and ferrule can cause failed crimp connection.

It is not possible that a tool will work with every combination of wire and crimping material. It is possible that a crimp complying to standards is not attainable even when using standardised articles. The difficulty in selecting is due to the large number of different conductors available on the market. This is the reason why testing and defining of material is so important. It must be sure that testing and later use of the machine happen under the same conditions.



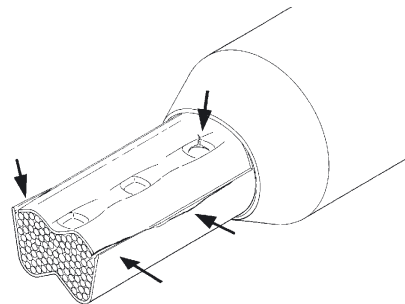
Individual wire squeezed off.



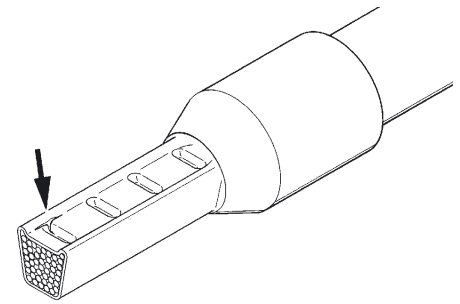
Individual wire pushed back.

Faults which can occur during crimping:

- Cracking along the lateral edges and the die impressions.
- Ferrules split open.
- Non-symmetrical crimp shape.
- Severe burring along the lateral edges.
- The ferrule is not filled by the conductor.
- Individual wires are pushed back and protude from the collar.
- Individual wires are squeezed off.
- Insulating collar damaged by crimping die.
- Conductor insulation is not pushed into the insulating collar.
- Ferrule bent in longitudinal direction after crimping.



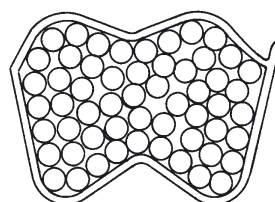
Cracks on the lateral edges.
Lateral edges split open.
Formation of cracks at the impressions of crimping die.



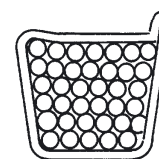
Formation of cracks at the impressions of crimping die.

Note:

The ferrule must not break open after being connected once in any desired Weidmüller clamp corresponding to the conductor cross-section with a torque to DIN IEC 0611.



Non-symmetrical crimp shape.
Burring on one side.



Non-symmetrical crimp shape.
Burring on one side.