

Contents

	Page
Tools for contacts Han D®	99.02
Tools for contacts Han E®	99.03
Tools for contacts Han® C	99.04
Tools for Han-Modular® and other contacts	99.05
Tools for FOC contacts	99.06
Summary Han® Crimping tools	99.07
Crimping machine TK	99.08
Crimping machine TC-C01	99.10

Crimping machine TC-C01



Identification	Part No.	Drawing	Dimensions in mm
HARTING crimping tool with locator for Han D®, Han E®, Han® C	09 99 000 0110	Wire gauge 0.14 - 1.5 mm ²	
HARTING-Service crimping tool with locator for Han D®, Han E®	09 99 000 0021	Wire gauge 0.14 - 1.5 mm ²	
BUCHANAN-crimping tool Locator Multiple crimping tool depth adjustment gauge	09 99 000 0001 09 99 000 0311 09 99 000 0379	Wire gauge 0.14 - 2.5 mm ² 0.14 + 0.25 mm ² ø 1.00 0.37 mm ² ø 1.30 0.5-1 + 2.5 mm ² ø 1.55 1.5 mm ² ø 1.80	 ↑  order separately
HARTING-pneumatic crimping tool Locator Multiple crimping tool depth adjustment gauge Table fixing and foot switch for pneumatic crimping tool	09 99 000 0314 09 99 000 0311 09 99 000 0379 09 99 000 0309	Wire gauge 0.37 mm ² ø 1.30 0.5-1 + 2.5 mm ² ø 1.55 1.5 mm ² ø 1.80	 ↑  order separately 
Insertion tool for crimp contacts	09 99 000 0059	 For crimp contacts with wires of less than 0.75 mm ² it is recommended that an insertion tool is used. Contacts should be inserted from the wiring side and pushed down until a positive locking is achieved.	
Removal tool for crimp contacts Removal tool Replacement-tip for removal tool Removal tool	09 99 000 0012 09 99 000 0004 09 99 000 0052	  	.. 0012 .. 0004 .. 0052

Tools

99
02

¹⁾ For wire gauge 0.14 and 0.25 mm² use only male contact 09 15 000 6107 or female contact 09 15 000 6207.

Stock items in bold type

Identification	Part No.	Drawing	Dimensions in mm
HARTING crimping tool with locator for Han D®, Han E®, Han® C	09 99 000 0110	Wire gauge 0.5 - 4 mm ²	
HARTING-Service crimping tool with locator	09 99 000 0021	Wire gauge 0.5 - 2.5 mm ²	
BUCHANAN-crimping tool Locator	09 99 000 0001 09 99 000 0310	Wire gauge 0.14 - 4 mm ²	
Multiple crimping tool depth adjustment gauge	09 99 000 0379	Wire gauge 0,14 - 0,37 mm ² ø 1,00 0,5 - 1 mm ² ø 1,55 1,5 - 2,5 mm ² ø 1,80 3 - 4 mm ² ø 2,00	 ↑ order separately
HARTING-pneumatic crimping tool Locator	09 99 000 0314 09 99 000 0310		
Multiple crimping tool depth adjustment gauge	09 99 000 0379	Wire gauge 0.14 - 0.37 mm ² ø 1.00 0.5 - 1 mm ² ø 1.55 1.5 - 2.5 mm ² ø 1.80 3 - 4 mm ² ø 2.00	↑ order separately
Table fixing and foot switch for pneumatic crimping tool	09 99 000 0309		
Insertion tool for crimp contacts	09 99 000 0059		For crimp contacts wires of less than 0.75 mm ² it is recommended that an insertion tool is used. Contacts should be inserted from the wiring side and pushed down until a positive locking is achieved.
Removal tool for Han® ES inserts	09 99 000 0367		
Crimp contact removal for Han® EE, Han® Q 5/0, Han® Q 8/0 Han E® and Han A®	09 99 000 0319		A removal tool is necessary if contacts are to be replaced in the insert. The tool is inserted from the wiring side until a stop is noticeable. The wire with the crimp contact can then be pulled out from the same side of the insert.

Tools

99
03

Stock items in bold type

Identification	Part No.	Drawing	Dimensions in mm
HARTING crimping tool with locator for Han D®, Han E®, Han® C	09 99 000 0110	Wire gauge 1.5 - 4 mm ²	
BUCHANAN- crimping tool	09 99 000 0001	Wire gauge 1.5 - 4 mm ²	 ↑ order separately
Locator	09 99 000 0308		
Multiple crimping tool depth adjustment gauge	09 99 000 0379	Wire gauge 1.5 + 2.5 mm ² ø 1.80 4 mm ² ø 2.00	
HARTING crimping tool	09 99 000 0303	Wire gauge 4 - 6 mm ²	
Locator as spare part	09 99 000 0304	Locator is supplied with the tool	
HARTING crimping tool for Han® C	09 99 000 0377	Wire gauge 6 - 10 mm ²	
HARTING- pneumatic crimping tool	09 99 000 0314	Wire gauge 1.5 + 2.5 mm ² ø 1.80 4 mm ² ø 2.00	 ↑ order separately
Multiple crimping tool depth adjustment gauge	09 99 000 0379		
Locator	09 99 000 0308		
Table fixing and foot switch for pneumatic crimping tool	09 99 000 0309		
Removal tool for crimp contacts			
Removal tool	09 99 000 0305 09 99 000 0381	1.5 - 6 mm ² 10 mm ²	
			<p>A removal tool is necessary to remove the contacts. For each „C“ contact cavity, the location of the internal locking levers are marked on the wiring side with two black arcs. The sides of the tool must be first properly aligned so that the edges of the tool engage both levers simultaneously and then inserted until a stop is noticeable ①. Once it has been inserted, the tool must not be turned. The wire together with the tool can then be pulled out from the wiring side of the insert ②.</p>

Identification	Part No.	Drawing	Dimensions in mm
HARTING-crimping tool for coaxial contacts	09 99 000 0194	 Use the middle crimping position	
Removal tool for contacts in the multi-contact-module	09 99 000 0328		
Removal tool for locking sleeve of the HV module	09 99 000 0327		
Removal tool for Quintax contacts	09 99 000 0323		
Stripping tool	09 99 000 0159	 For wires 0.08 up to 10 mm ²	
Hexagonal screw driver for Axial screw			
with grip	40 A contacts (SW 2) 09 99 000 0313 100 A contacts (SW 4) 09 99 000 0363 200 + 350 contacts (SW 5) 09 99 000 0364 650 A contacts (SW 8) 09 99 000 0365		
Bit 1/4"	40 A contacts (SW 2) 09 99 000 0369 70 A contacts (SW 2.5) 09 99 000 0375		
Adapter 3/8"	100 A contacts (SW 4) 09 99 000 0370 200 + 350 A contacts (SW 5) 09 99 000 0371 650 A contacts (SW 8) 09 99 000 0372		

Tools

99
05

Stock items in bold type

Identification	Part No.	Drawing	Dimensions in mm
<p>Polishing tool</p> <p>DIN 41 626</p> <p>POF²⁾ cable Ø 2.2</p>	<p>20 99 000 1092</p> <p>20 99 000 1093</p>		<p>7</p> <p>Ø2.5</p> <p>20</p> <p>Ø2.2</p>
<p>Fibre stripper</p>	<p>20 99 000 1041</p> <p>20 99 000 1045</p> <p>20 99 000 1046</p>	<p>0.3 mm</p> <p>1 mm</p> <p>0.18/0.3 mm</p>	
<p>Crimping tool</p> <p>for 1 mm POF contacts</p> <ul style="list-style-type: none"> – Han D®, Han E® – DIN 41 626 – Ferrule – F-SMA, -ST 	<p>20 99 000 1035</p>		
<p>HARTING Crimping tool</p> <p>for FO connector (glass fibre)</p> <p>SW 4.3 mm</p> <p>3.8 mm</p> <p>4.95 mm</p>	<p>20 99 000 1031</p>		
<p>HARTING Crimping tool</p> <p>for FO connector (plastic fibre)</p> <p>SW 6.95, 4.95 and 3.0 mm</p>	<p>20 99 000 1033</p>		<p>for crimping the strain relief to the connector</p> <p>... 1031 FO cable for glass fibre</p> <p>... 1033 POF²⁾ and SERCOS cable Ø 6.0 and 3.6</p>
<p>Epoxy adhesive</p> <p>glass fibre</p>	<p>20 80 001 9902</p>		<p>2 ml EPO-TEK 360 with hardener (10:1), 4 g foil pack</p>
<p>Polishing paper</p> <p>for POF²⁾-grain size 1000</p> <p>for GI 9 µ-grain size</p> <p>for GI 1 µ-grain size</p>	<p>20 80 001 9911</p> <p>20 80 001 9912</p> <p>20 80 001 9913</p>		<p>Delivery range:</p> <p>Each part number ordered comprises 2 pieces</p>

Tools

99
06

²⁾ POF = Polymer optical fibre

Stock items in bold type

Crimp contacts series	Part number				mm ²	AWG	Crimping tool						Crimping machine						Tools	
	male contacts silver plated	female contacts silver plated	male contacts gold plated	female contacts gold plated			09 99 000 0001	09 99 000 0110	09 99 000 0021	09 99 000 0303	09 99 000 0377	20 99 000 1035	09 99 000 0314	09 98 000 6001 1)	09 98 000 6002 1)	09 98 000 9001	09 98 000 9002	09 98 000 9003	adjustment gauge 09 99 000 0379 2)	removal tools
Han® C Power contacts 09 32 000 	6104	6204			1.5	16	x	x								x	1.80	09 99 000 0305 09 99 000 0381		
	6105	6205			2.5	14	x	x								x	1.80			
	6107	6207			4.0	12	x	x								x	2.00			
	6108	6208			6.0	10										x				
	6109	6209			10.0	8										x				
Han D® Signal contacts 09 15 000 	6107	6207	6127	6227	0.14 - 0.25	26 - 24	x									x	1.00	09 99 000 0012 09 99 000 0052		
	6104	6204	6124	6224						x	x									
	6107	6207	6127	6227	0.37	22	x									x	1.00			
	6104	6204	6124	6224					x	x	x						x		1.30	
	6103	6203	6123	6223	0.5	20	x	x	x						x	x	1.55			
	6105	6205	6125	6225	0.75	18	x	x	x						x	x	1.55			
	6102	6202	6122	6222	1.0	18	x	x	x						x	x	1.55			
	6101	6201	6121	6221	1.5	16	x	x	x						x	x	1.80			
6106	6206	6126	6226	2.5	14	x								x	x	1.55				
Han D® FOC contacts 20 10 001	male contact 3211 / 3212 / 3213		female contact 3221 / 3222		1 mm POF											x				
Han E® Power contacts 09 33 000 	6127	6227	6117	6217	0.14 - 0.37	26 - 22	x									x	1.00	09 99 000 0319		
	6121	6220	6122	6222	0.5	20	x	x	x							x	1.55			
	6114	6214	6115	6215	0.75	18	x	x	x							x	1.55			
	6105	6205	6118	6218	1.0	18	x	x	x							x	1.55			
	6104	6204	6116	6216	1.5	16	x	x	x							x	1.80			
	6102	6202	6123	6223	2.5	14	x	x	x							x	1.80			
	6106	6206			3.0	12	x	x								x	2.00			
6107	6207	6119	6221	4.0	12	x	x								x	2.00				
Han E® FOC contacts 20 10 001	male contact 3311		female contact 3321		1 mm POF											x				
Identification																				
Locator Han C®	09 99 000 0308						x						x							
	09 99 000 0304																			
Locator Han D®	09 99 000 0311						x						x							
	09 99 000 0022																			
Locator Han E®	09 99 000 0310						x						x							
	09 99 000 0022																			

Tools

99
07

1) For using changeable units 09 99 000 6001 / 6002 basic unit 09 99 000 6000 is required
 2) Adjustment gauge with Ø 1.00 mm; 1.30 mm; 1.55 mm; 1.80 mm; 2.00 mm

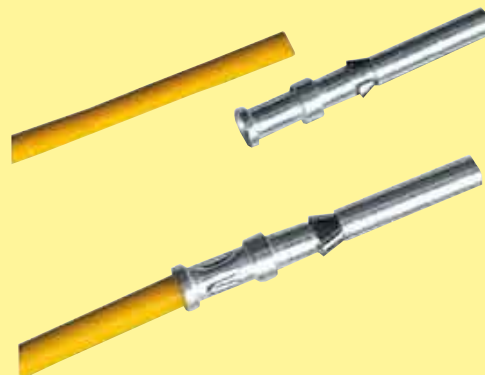


Features

- Fast stripping and crimping in one operation
- Basic unit in compact construction
- Simple handling due to ergonomic design
- For individual, turned male and female contacts (for the HARTING series Han D®, Han E®)
- Selective processing of male and female contacts (Wire gauge from 0.34 mm² to 4.0 mm², AWG 22 to AWG 12)
- Contact magazine with filling control
- Reproducible, top quality gas-tight crimp connections
- Infinitely variable adjustment parameters
 - Stripping depth
 - Stripping length
 - Crimping depth
 - Crimp contact feed rate
- Magazine empties automatically
- Adjustable feet for setting the height
- Low noise level
- For oil-free compressed air
- Air servicing unit with water separator and pressure reducer
- Very low setup effort
- Low maintenance costs

Technical characteristics

Dimensions:	
Height	400 mm
Width	555 mm
Depth	440 mm
Total weight:	Approx. 60 kg
Local noise level:	< 70 dB (A)
Drive:	Electro-pneumatic
Electrical connection:	230 V, 50 Hz
Power rating:	0.75 kW
Pneumatic pressure:	6 bar
Compressed air connection:	3 dm ³ / work cycle
Control system:	PLC
Work cycle trigger:	Sensor
Machine work cycle:	2 seconds (stripping and crimping)
Crimp type:	Four-notch crimping
Contact feed:	Vibratory bowl feed
Stroke counters:	Resettable daily counter and permanent counter



Identification	Part No.	
Crimping machine TK (Basic machine without interchangeable unit)	09 98 000 6000	
interchangeable units for Han D® Han E®	09 98 000 6001 09 98 000 6002	

Pack contents

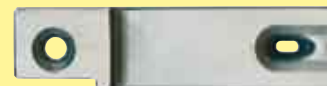
- Crimping machine TK
 - with one mounted interchangeable unit
 - with 2.0 m connection cable and grounding plug
 - with 2.0 m pneumatic hose with plug-in nipple N9
- Plug gauge for setting the crimping depth
- Centering bushing for positioning the plug gauges
- Drawer for insulation pieces
- Drawer for holding contacts when the magazine is emptied
- Tool set for adjustments
- 1 set of stripping blades
- Operating instructions
- Declaration of conformity

Options

Interchangeable unit
with plug gauges



Forming blades
with feeding funnel



Tools

99
09

Stock items in bold type






Features

- Basic unit in compact construction for pre-stripped wire
- Simple handling due to ergonomic design
- For individual, turned male and female contacts
- Selective processing of male and female HARTING contacts (wire gauge from 0.14 mm² to 10.0 mm², AWG 26 to AWG 8)
- Automatic contact feed
- Reproducible, top quality gas-tight crimp connections
- Non-slip, anti-vibration adjustable feet for setting the height
- Low noise level
- Can be transported with carrying handle
- Removable electric and pneumatic supply connections
- Maintenance interval counter
- Minimal setup effort
- Crimping depth can be set without tools
- Low maintenance costs
- Low follow-up costs for maintenance and repair
- Easy replacement of wearing components

Technical characteristics

Dimensions:	
Height	345 mm
Width	230 mm
Depth	400 mm
Total weight:	app. 24 kg
Local noise level:	62 dB (A)
Electrical connection:	230 V, 50 Hz
Power rating:	0.20 kW
Compressed air connection:	6 bar
Control system:	PLC
Work cycle trigger:	Footswitch
Machine work cycle:	1 second
Crimp type:	Four-point crimping
Contact feed:	Vibratory bowl feed
Stroke counters:	Resettable daily counter and permanent counter



Identification	Part No.	
<p>Crimping machine TC-C01</p> <ul style="list-style-type: none"> for Han D® contacts Han E® contacts Han® C contacts Other 	<ul style="list-style-type: none"> 09 98 000 9001 09 98 000 9002 09 98 000 9003 On request 	
<h2>Included in the delivery</h2>		<h2>Options</h2>
<ul style="list-style-type: none"> <input type="checkbox"/> Crimping machine TC-C01 <ul style="list-style-type: none"> – with 2.5 m connection cable and grounding plug – with 2.5 m pneumatic hose, quick-release coupling and N6 plug-in nipple <input type="checkbox"/> Footswitch <input type="checkbox"/> Carrying handle <input type="checkbox"/> Operating instructions <input type="checkbox"/> Declaration of conformity 		<p>Pneumatic maintenance unit</p>  <p>Wire guide</p>  <p>Working light</p> 