

Identification Part number

HARTING PushPull Power 8-indent crimping tool incl. positioner	09 46 800 0000
Locator HARTING PushPull Power contacts for Buchanan crimping tool (09 99 000 0001)	09 46 800 0010



For wire gauges  
0.08 ... 4.0 mm<sup>2</sup>  
(AWG 28 ... 12).

Insertion tool	09 46 800 0099
Extraction tool	09 46 800 0098



For an easy insertion and  
extraction of the male and  
female crimp contacts into /  
out of the insulator body.

### Crimp connection

A perfect crimp connection is gastight, therefore corrosion free and amounts to a cold weld of the parts being connected. For this reason, major features in achieving high quality crimp connections are the design of the contact crimping parts and of course the crimping tool itself. Wires to be connected must be carefully matched with the correct size of crimp contacts. If these basic requirements are met, users will be assured of highly reliable connections with low contact resistance and high resistance to corrosive attack.

The economic and technical advantages are:

- Constant contact resistance as a result of precisely repeated crimp connection quality
- Corrosion free connections as a result of cold weld action
- Pre-preparation of cable forms with crimp contacts fitted
- Optimum cost cable connection

Requirements for crimp connectors are laid down in DIN IEC 60352-2, Amend. 2, as illustrated in the table.

#### Pull out force of stranded wire

The main criterion to judge the quality of a crimp connection is the retention force achieved by the wire conductor in the terminal section of the contact. DIN IEC 60352, part 2, defines the extraction force in relation to the cross-section of the conductor. When fitted using HARTING crimping tools and subject to their utilization in an approved manner, our crimp connectors comply with the required extraction forces.

### Crimping tools

Crimping tools (hand operated or automatic) are carefully designed to produce with high pressure forming parts a symmetrical connection of the crimping part of the contact and the wire being connected with the minimum increase in size at the connection point. The positioner automatically locates the crimp and wire at the correct point in the tool.

A ratchet in the tool performs 2 functions:

- ① It prevents insertion of the crimp into the tool for crimping before the jaws are fully open
- ② It prevents the tool being opened before the crimping action is completed

Identical, perfectly formed, connections can be produced using this crimping system.

### Tensile strength of crimped connections

Conductor cross-section		Tensile strength
mm <sup>2</sup>	AWG	N
0.08	28	11
0.12	26	15
0.14		18
0.22	24	28
0.25		32
0.32	22	40
0.5	20	60
0.75		85
0.82	18	90
1.0		108
1.3	16	135
1.5		150
2.1	14	200
2.5		230
3.3	12	275
4.0		310

Extract from DIN IEC 60352-2, Amend. 2, Table IV



Crimp-cross section  
HARTING crimp profile