Crimping tools and inserts for flexible cables

Small crimp tool, «K» with interchangeable inserts 1/2/A, 2/B, 2/C

Fig. 1

Fig. 2

HUBER+SUHNER type	Item no.	Description	Fig.
75_Z-0-0-50	22544754	tool without inserts	1
75_Z-0-0-51	22544755	tool with various inserts 1/2/A, 2/A, 2/C in wooden box	2

Interchangeable inserts for small crimp tool

HUBER +SUHNER type	Item no.	Cavity ID	Square cavity size for centre contact mm	Hexagonal cavity size for outer contact mm
76_Z-0-1-1	23000884	0.54/A	0.54	3.3
76_Z-0-2-20	22645153	1/4.95	0.75	4.95
76_Z-0-2-51	22544756	1/2/A	0.74/1.58	3.3
76_Z-0-2-53	22645337	1/2.67	0.75	2.67
76_Z-0-3-51	22544757	2/B	1.58	5.5
76_Z-0-4-51	22544758	2/C	1.58	6.5

Crimping tools and inserts for flexible cables

Large crimp tool, «G» with interchangeable inserts 1/2/A, 2/B, 2/C, 3/D

Fig. 1

Fig. 2

HUBER+SUHNER type	Item no.	Description	Fig.
75_Z-0-0-1	22543157	tool without inserts	1
76_Z-0-0-15	22543177	tool with various inserts 1/2/A, 2/B, 2/C, 3/D and cutting insert in wooden box	2

Tool boxes

HUBER+SUHNER type	Item no.	Description
76_Z-0-0-9	22644671	large tool box (empty)
76_Z-0-0-11	22543175	large tool box without tooling but including foam insert for tools and allen key

Table press with interchangeable inserts

HUBER+SUHNER type	Item no.	Description
75_Z-0-0-2	22543158	press without inserts (for inserts see page 534)

Crimping tools and inserts for flexible cables

Interchangeable inserts fitting large crimp tool and table press

HUBER +SUHNER type	Item no.	Cavity ID	Square cavity size for centre contact mm	Hexagonal cavity size for outer contact mm
76_Z-0-1-2	23000885	0.54/A	0.51	3.3
76_Z-0-2-1	22543181	1/2/A	0.74/1.58	3.3
76_Z-0-2-8	22544191	1/4.95	0.7	4.95
76_Z-0-3-1	22543185	2/B	1.58	5.5
76_Z-0-3-9	22641133	1.22/1.22/B	1.20/1.20	5.5
76_Z-0-4-1	22543189	2/C	1.58	6.5
76_Z-0-4-8	22543190	1.22/1.22/C	1.20/1.20	6.5
76_Z-0-5-8	22543192	1.22/1.22/8	1.20/1.20	8
76_Z-0-5-21	22543193	2/8.0	1.58	8
76_Z-0-6-1	22649051	3/8.65	2.38	8.65
76_Z-0-6-21	22543194	2/9.75	1.6	9.75
76_Z-0-7-1	22543195	3/D	2.38	10.7
76_Z-0-7-7	22543196	2/D	1.58	10.7
76_Z-0-7-8	22660322	2.5/D	2.48	10.7
76_Z-0-7-14	22544524	4/D	3.28	10.7
76_Z-0-10-14	23002630	12.4		12.4
76_Z-0-0-26	22645880	1/2.67	0.8	2.73
76_Z-0-3-26	84077169	1.22/B	1.2	5.5
76_Z-0-4-24	84077171	1.22/6.5	1.2	6.5
76_Z-0-5-22	84077161	1.22/8.0	1.2	8
76_Z-0-0-57	85008389	5.5		5.5
76_Z-0-4-23	84074473	C		6.5
76_Z-0-12-1	85009833	14.5		14.5

Crimping tools and inserts for flexible cables

Special insert and tools for large crimp tool and table press

HUBER+SUHNER type	Item no.	Description
76_Z-0-0-1	22543170	cutting insert for cables up to 12 mm/4.720 in outer diameter
76_Z-0-0-2	22543172	spare blades for cutting insert (10 pieces per package)
76_Z-0-0-3	22543173	support plate for bench mounting of large crimp tool

SMA tool set for semi-rigid cable assembling

This tool set includes all tools required for assembling of SMA connectors.

The following additional tools are required for assembling of N and PC7 connectors to cables semi-rigid 0.141 and 0.086: 74_Z-0-3-29, 74_Z-0-0-35, 74_Z-0-0-66, 74_Z-0-0-67, 74_Z-0-3-4.

All tolls and replacement parts can be ordered individually. The individual tools can also be used with the large soldering fixture W442, HUBER+SUHNER type 74_Z-0-0-442, to be ordered separatly.

HUBER+SUHNER type	Item no.	Description	Packaging	Weight
74_Z-0-0-70	22544725	large tool set for SMA semi-rigid cable assembling	wooden box 366×188×51 mm	1.41 kg

Small tool set see 74_Z-0-0-72.

Content of set

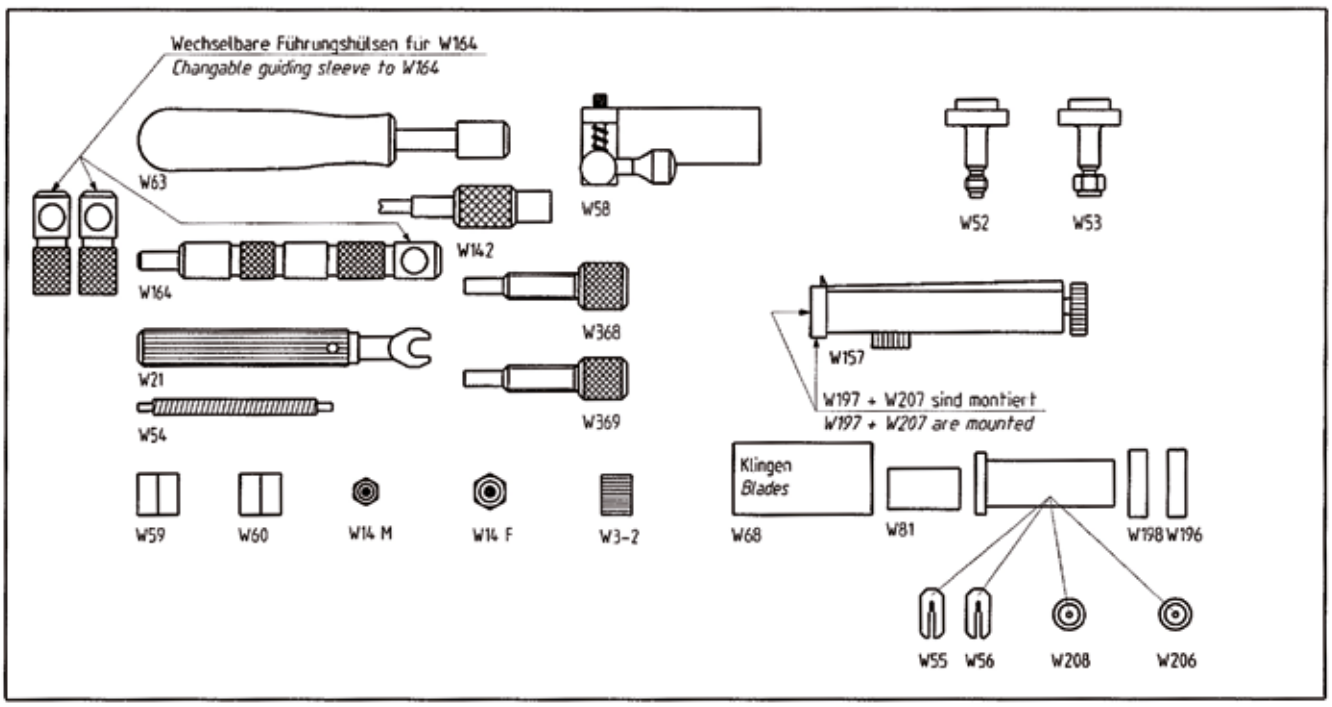
HUBER+SUHNER type	Item no.	W-no. *	Description	Qty
74_Z-0-3-2	22543148	W3-2	stripping gauge for insulation semi-rigid 0.0141	1
74_Z-0-0-14	22543124	W14	locator tool, male and female	1
74_Z-0-0-21	22543130	W21	torque wrench Ncm 100	1
74_Z-0-0-52	22544553	W52	dielectric insertion tool, for plugs	1
74_Z-0-0-53	22544554	W53	dielectric insertion tool, for jacks	1
74_Z-0-0-54	22544555	W54	contact holder for pins and sockets	1
74_Z-0-0-55	22544516	W55	soldering gauge 0.25mm	1
74_Z-0-0-56	22544517	W56	soldering gauge 0.4mm	1
74_Z-0-0-58	22544557	W58	soldering fixture	1
74_Z-0-0-59	22544558	W59	clamping inserts for semi-rigid 0.141, used with W58	2
74_Z-0-0-60	22544559	W60	clamping inserts for semi-rigid 0.086, used with W58	2
74_Z-0-0-63	22544562	W63	trim tool, for plugs without pin	1
74_Z-0-0-68	22544715	W68	1 set of blades with protector	1
74_Z-0-0-81	22641423	W81	positioner for W164 assembling of coupling nuts (SMA)	1
74_Z-0-0-142	22643462	W142	trim tool for removal of extended dielectric	1
74_Z-0-0-157	22643029	W157	cable stripping tool	1
74_Z-0-0-164	22643028	W164	trim tool for centre contact	1
74_Z-0-0-368	23021264	W368	locator tool, used with W58	1
74_Z-0-0-369	23021266	W369	locator tool, used with W58	1

* Idendification marked on tool and referenced in assembling instruction, abbreviated notation derived from the HUBER+SUHNER type e.g. W58 from 74_Z-0-0-58.

SMA tool set for semi-rigid cable assembling

Assembly instruction for semi-rigid cables and SMA connectors

DOC-0000178687 for female connectors
DOC-0000179086 for male connectors



N, PC7, BNC, TNC, tool set for semi-rigid cable assembling

This tool set includes all tools required for assembling of N, PC7, BNC, TNC connectors.

All tolls and replacement parts can be ordered individually.

The individual tools can also be used with the large soldering fixture W442 HUBER+SUHNER type 74_Z-0-0-442, to be ordered separatly.

HUBER+SUHNER type	Item no.	Description	Packaging	Weight
74_Z-0-0-71	22641350	N, PC7, BNC, TNC, tool set for semi-rigid cable assembling	wooden box 366×188×51 mm	1.22 kg

Content of set

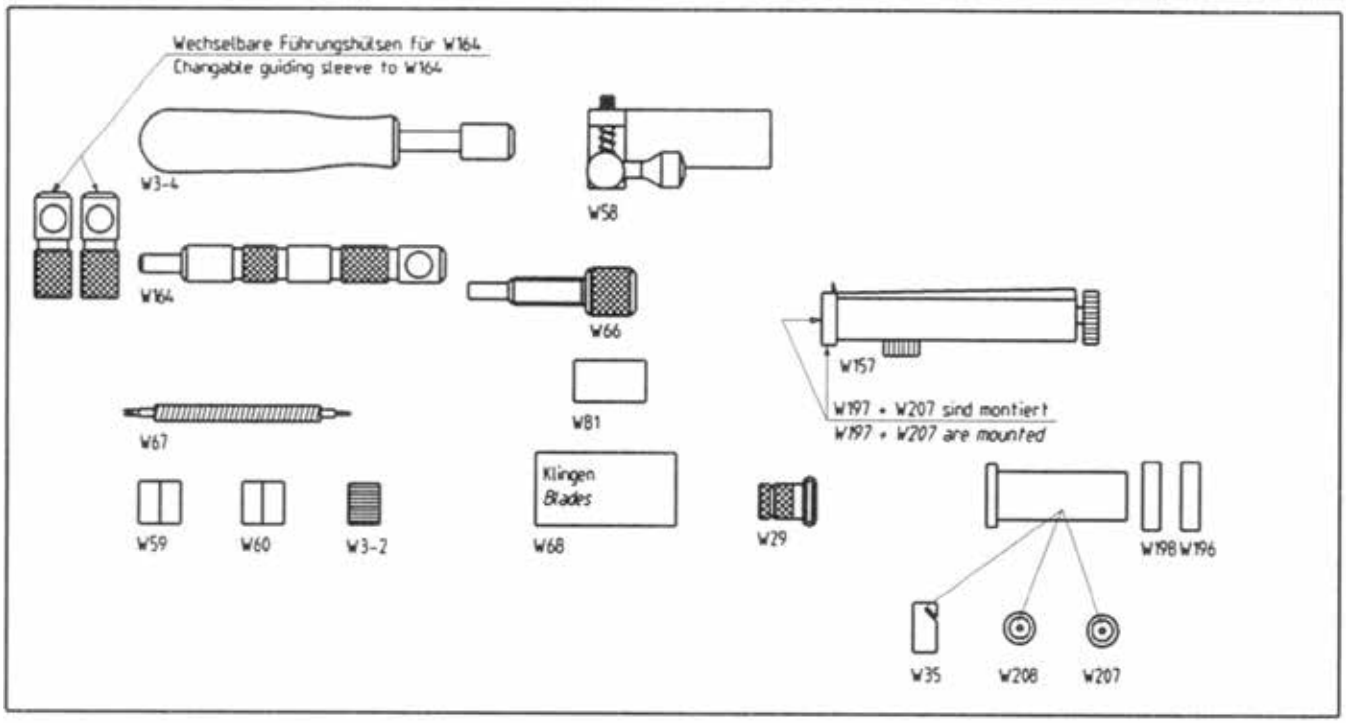
HUBER+SUHNER type	Item no.	W-no. *	Description	Qty
74_Z-0-3-2	22543148	W3-2	stripping gauge for insulation semi-rigid 0.141	1
74_Z-0-3-4	22543150	W3-4	trim tool for remove protruding dielectric semi-rigid 0.141	1
74_Z-0-0-29	22543138	W29	dialectric insertion tool for insulators	1
74_Z-0-0-35	22544282	W35	soldering gauge 0.45 mm/0.018 in	1
74_Z-0-0-58	22544557	W58	soldering fixture	1
74_Z-0-0-59	22544558	W59	clamping inserts for semi-rigid 0.141, used with W58	2
74_Z-0-0-60	22544559	W60	clamping inserts for semi-rigid 0.086, used with W58	2
74_Z-0-0-66	22544616	W66	locator tool	1
74_Z-0-0-67	22544640	W67	contact holder for pins and sockets	1
74_Z-0-0-68	22544715	W68	1 set of blades with protector	1
74_Z-0-0-81	22641423	W81	positioner for assembly of coupling nuts	1
74_Z-0-0-157	22643029	W157	cable stripping tool	1
74_Z-0-0-164	22643028	W164	trim tool for centre contact	1

* Idendification marked on tool and referenced in assembling instruction, abbreviated notation derived from the HUBER+SUHNER type e.g. W58 from 74_Z-0-0-58.

N, PC7, BNC, TNC, tool set for semi-rigid cable assembling

Assembly instruction for semi-rigid cables and N, BNC,TNC, PC7 connectors

DOC-0000180866 for series N connectors
DOC-0000179121 for series BNC – TNC connectors
DOC-0000180866 for series N – PC7 connectors



SMA tool set for semi-rigid cable assembling

This tool set includes all tools required for assembling of SMA connectors.

The following additional tools are required for assembling of N and PC7 connectors to semi-rigid cables 0.141 and 0.086: 74_Z-0-3-2, 74_Z-0-3-4, 74_Z-0-0-29, 74_Z-0-0-35, 74_Z-0-0-66, 74_Z-0-0-67.

All tolls and replacement parts can be ordered individually. The individual tools can also be used with the large soldering fixture W442, HUBER+SUHNER type 74_Z-0-0-442, to be ordered separatly.

HUBER+SUHNER type	Item no.	Description	Packaging	Weight
74_Z-0-0-72	22544747	small tool set for SMA semi-rigid cable assembling	wooden box 366×188×51 mm	1.13 kg

Large tool set see 74_Z-0-0-70.

Content of set

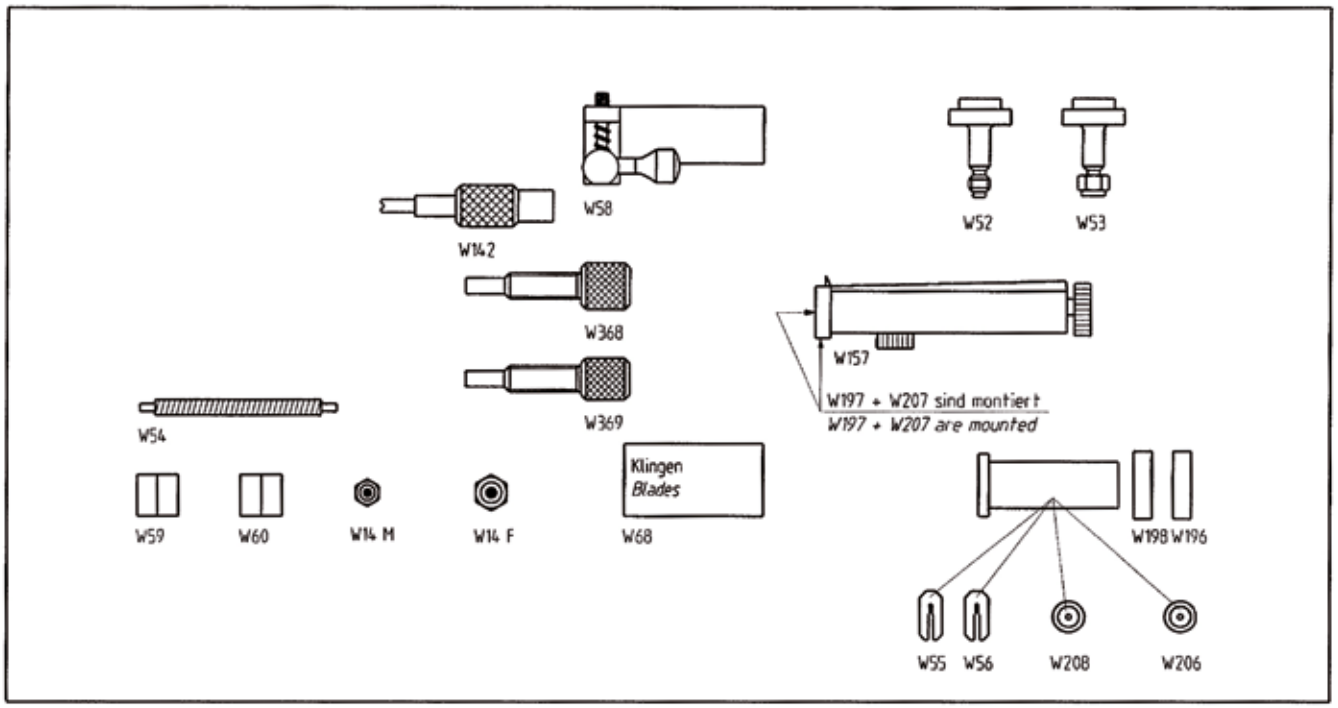
HUBER+SUHNER type	Item no.	W-no. *	Description	Qty
74_Z-0-0-14	22543124	W14	locator tool, male and female	1
74_Z-0-0-52	22544553	W52	dielectric insertion tool, for plugs	1
74_Z-0-0-53	22544554	W53	dielectric insertion tool, for jacks	1
74_Z-0-0-54	22544555	W54	contact holder for pins and sockets	1
74_Z-0-0-55	22544516	W55	soldering gauge 0.25mm	1
74_Z-0-0-56	22544517	W56	soldering gauge 0.4mm	1
74_Z-0-0-58	22544557	W58	soldering fixture	1
74_Z-0-0-59	22544558	W59	clamping Inserts for semi-rigid 0.141, used with W58	2
74_Z-0-0-60	22544559	W60	clamping Inserts for semi-rigid 0.086, used with W58	2
74_Z-0-0-68	22544715	W68	1 set of blades with protector	1
74_Z-0-0-142	22643462	W142	trim tool for removal of extended dielectric	1
74_Z-0-0-157	22643029	W157	cable stripping tool	1
74_Z-0-0-368	23021264	W368	locator tool, used with W58	1
74_Z-0-0-369	23021266	W369	locator tool, used with W58	1

* Idendification marked on tool and referenced in assembling instruction, abbreviated notation derived from the HUBER+SUHNER type e.g. W58 from 74_Z-0-0-58.

SMA tool set for semi-rigid cable assembling

Assembly instruction for semi-rigid cables and SMA connectors

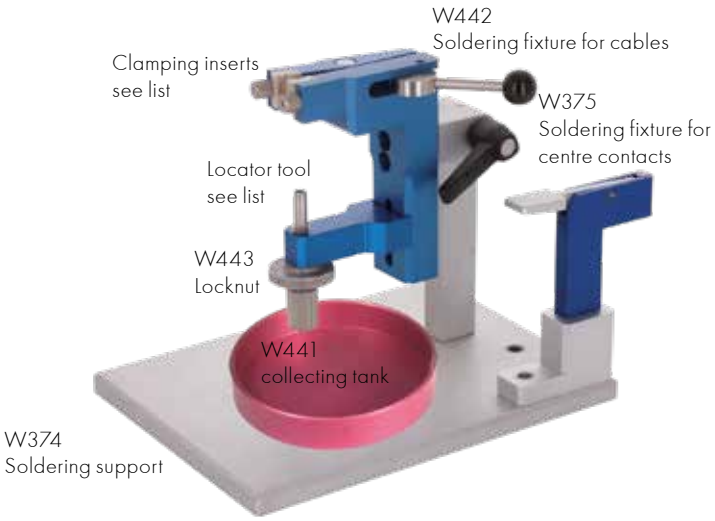
DOC-0000178687 for female connectors
DOC-0000179086 for male connectors



Soldering tool and soldering support

The soldering tool consist of several different parts.

Depending on the requirement, the individual items can be combined. The parts can be ordered separately.



Basic equipment

Large soldering fixture W442
Alternative see small fixture W58

HUBER+SUHNER type	Item no.	W-no.*	Description	Comments
74_Z-0-0-442	23024588	W442	soldering fixture	can also be used without soldering support W374, e.g. mounted/assembling on a table
74_Z-0-0-374	23022146	W374	support for soldering fixture	can be used with the new version of the soldering fixture W58, the new version contents two additional scrwholes
74_Z-0-0-443	23024584	W443	positioning locator tool	for a positioning of the locator tool- free from backflash
74_Z-0-0-441	23024586	W441	collecting tank for coolant or flux	collecting tank for coolant or flux
74_Z-0-0-375	23022145	W375	soldering fixture for centre contacts	supporting tool, to solder the cable into the centre contact

Additional components

Locator tool, adapted for W442/W58
for the approriate connector-interface see list

HUBER+SUHNER type	Item no.	W-no. *	For series
74_Z-0-0-62	22544561	W62	SMA
74_Z-0-0-66	22544616	W66	N
74_Z-0-0-209	22645585	W209	BMA plug
74_Z-0-0-210	22645586	W210	BMA jack
74_Z-0-0-231	22646131	W231	SK plug
74_Z-0-0-232	22646132	W232	SK jack
74_Z-0-0-368	23021264	W368	SMA female
74_Z-0-0-369	23021266	W369	SMA male
74_Z-0-0-390	23035218	W390	QN
74_Z-0-0-391	23035220	W391	QN

Clamping inserts, adapted for W442/W58
for the approriate connector-interface see list

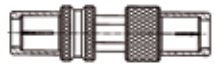
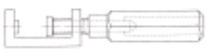
HUBER+SUHNER type	Item no.	W-no. *	For series
74_Z-0-0-59	22544558	W59	BMA, N, SMA, semi-rigid 0.141
74_Z-0-0-60	22544559	W60	BMA, N, SMA, semi-rigid 0.086
74_Z-0-0-133	22643022	W133	BMA, N, SMA, semi-rigid 0.047
74_Z-0-0-233	22646133	W233	SK, semi-rigid 0.118
74_Z-0-0-364	23019268	W364	MULTIFLEX_86
74_Z-0-0-365	23019269	W365	MULTIFLEX_141, SUCOFORM_141

* Idendification marked on tool and referenced in assembling instruction, abbreviated notation derived from the HUBER+SUHNER type e.g. W58 from 74_Z-0-0-58.

Selection of common and helpful assembly tools

HUBER+SUHNER type	Item no.	W-no. *	For series and cables	Description	Works with tool of W-no.	Picture
74_Z-0-0-12	22642718			small hand saw		
74_Z-0-0-13	22644241			replacement saw blade for 74_Z-0-0-12		
74_Z-0-0-14	22543124	W14	SMA	locator tools for contact and insulators		
74_Z-0-0-21	22543130	W21	SMA, PC3.5	torque wrench 100 Ncm		
74_Z-0-0-24	22543133		SMA	tap drill for SMA (1/4-36 UNS-2B thread)		
74_Z-0-0-29	22543138	W29	N	dielectric insertion tool for insulators		
74_Z-0-0-30	22543139		MCX, MMBX	assembly tool for right angle connectors for decoupling and cap mounting		
74_Z-0-0-35	22544282	W35	N	soldering gauge 0.45 mm/0.018 in		
74_Z-0-0-52	22544553	W52	SMA plugs	dielectric insertion tool		
74_Z-0-0-53	22544554	W53	SMA jacks	dielectric insertion tool		
74_Z-0-0-54	22544555	W54	SMA	contact holder for pins and sockets		
74_Z-0-0-55 74_Z-0-0-56	22544516 22544517	W55 W56	SMA SMA	soldering gauge 0.20 mm soldering gauge 0.40 mm	W58/W442 W58/W442	
74_Z-0-0-58	22544557	W58	BMA, SK, N, SMA	soldering fixture	W374/W55/ W56	
74_Z-0-0-59	22544558	W59	BMA, N, SMA, semi-rigid 0.141	clamping inserts	W58/W442	
74_Z-0-0-60	22544559	W60	BMA, N, SMA, semi-rigid 0.086	clamping inserts	W58/W442	

Selection of common and helpful assembly tools

HUBER+SUHNER type	Item no.	W-no. *	For series and cables	Description	Works with tool of W-no.	Picture
74_Z-0-0-62	22544561	W62	SMA	locator tool for SMA plugs without pin	W58/W442	
74_Z-0-0-63	22544562	W63	SMA	trim tool for SMA plugs without pin		
74_Z-0-0-66	22544616	W66	N	locator tool	W58/W442	
74_Z-0-0-67	22544640	W67	N	contact holder for pins and sockets		
74_Z-0-0-68	22544715	W68	BMA, SK, N, SMA	1 set of blades with protector		
74_Z-0-0-75	22544807	W75	SK, SMA	assembly tool for hermetic jacks		
74_Z-0-0-81	22641423		SK, SMA	positioner for assembly of coupling nuts		
74_Z-0-0-89	22644721	W89	716	screwdriver for female centre contacts	W79	
74_Z-0-0-115	22642492			syringe for casting compound capacity 3.5 ccm		
74_Z-0-0-116	22642493			casting compound (set of two tubes: resin and hardener)		
74_Z-0-0-133	22643022	W133	BMA, N, SMA, semi-rigid 0.047	clamping inserts	W58/W442	
74_Z-0-0-142	22643462	W142	SMA	trim tool for removal of extended dielectric		
74_Z-0-0-157	22643029	W157	BMA, SK, N, SMA, semi-rigid 0.047, 0.186, 0.141, SUCOFORM_86 and 141	cable stripping tool		
74_Z-0-0-160	22643514		semi-rigid 0.047, 0.086, 0.141	replacement cutting wheels set	W157	
74_Z-0-0-164	22643028	W164	BMA, N, SMA, semi-rigid 0.086, 0.141	trim tool for centre contacts	W245	
74_Z-0-0-177	22644541	W177	16 SMB, C, S	tool for cap mounting		

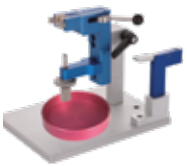
Selection of common and helpful assembly tools

HUBER+SUHNER type	Item no.	W-no. *	For series and cables	Description	Works with tool of W-no.	Picture
74_Z-0-0-196 74_Z-0-0-197 74_Z-0-0-198 74_Z-0-0-397	22645359 22645360 22645361 84005300		semi-rigid 0.047 semi-rigid 0.086 semi-rigid 0.141 semi-rigid 0.118	replacement support cover	W157	
74_Z-0-0-206 74_Z-0-0-207 74_Z-0-0-208	22645364 22645363 22645362		semi-rigid 0.047 semi-rigid 0.086 semi-rigid 0.141	replacement cutting weels	W157	
74_Z-0-0-209	22645585	W209	BMA plug	locator tool	W58/W442	
74_Z-0-0-210	22645586	W210	BMA jack	locator tool	W58/W442	
74_Z-0-0-211	22645591		BMA hermetic seal	soldering fixture for hermetic seal		
74_Z-0-0-213	22645593	W213	BMA	removal tool for receptacles with snap-in mechanism		
74_Z-0-0-214	22645579		BMA hermetic seal	torque wrench 200 Ncm		
74_Z-0-0-225	22645861		MMCX	decoupling and cap mounting		
74_Z-0-0-226	22646136	W226	SK	soldering fixture for glass bead		
74_Z-0-0-227	22646137	W227	SK	soldering fixture for glass bead		
74_Z-0-0-228	22646138	W228	SK	asembling tool for dialectric bead		
74_Z-0-0-229	22646139	W229		tap drill (thread1/4-36 UNS for blind hole thread)		
74_Z-0-0-230	22646130	W230	SK	step drill (only if sliding contacts are not used)		
74_Z-0-0-231	22646131	W231	SK plug	locator tool	W58/W442	
74_Z-0-0-232	22646132	W232	SK jack	locator tool	W58/W442	
74_Z-0-0-233	22646133	W233	SK, semi-rigid 0.118	clamping inserts	W58/W442	
74_Z-0-0-234	22646134	W234	SK, semi-rigid 0.118	replacement cutting wheels	W157	

Selection of common and helpful assembly tools

HUBER+SUHNER type	Item no.	W-no. *	For series and cables	Description	Works with tool of W-no.	Picture
74_Z-0-0-235	22646135	W235	SK	step drill (only if sliding contacts are not used)		
74_Z-0-0-238	22646071			tap drill (thread 5/8-24 UNEF)		
74_Z-0-0-246	22646873	W246	SMA	jacket remover for semi-rigid and Sucoform cables, after cutting and braking of jacket	W157/W246	
74_Z-0-0-264	22646290	W264	SK, semi-rigid 0.118	trim tool for centre conductor		
74_Z-0-0-265	22646291	W265	SK	spare blade for W264		
74_Z-0-0-270	22648901	W270	1.0/2.3	removal tool for 1.0/2.3 inserts		
74_Z-0-0-272	22648614		MMCX	decoupling and cap mounting for 11_ MMCX,16_MMCX connectors		
74_Z-0-0-350	23004135		MMCX	removal tool		
74_Z-0-0-360	23023444	W360	QMA	locator tool		
74_Z-0-0-364	23019268	W364	MULTIFLEX_86	clamping inserts	W58/W442	
74_Z-0-0-365	23019269	W365	MULTIFLEX_141, SUCOFORM_141	clamping inserts	W58/W442	
74_Z-0-0-368	23021264	W368	SMA female	locator tool	W58/W442	
74_Z-0-0-369	23021266	W369	SMA male	locator tool	W58/W442	
74_Z-0-0-374	23022146	W374	BMA, SK, SMA, N	support for soldering fixture	W58/W442	

Selection of common and helpful assembly tools

HUBER+SUHNER type	Item no.	W-no. *	For series and cables	Description	Works with tool of W-no.	Picture
74_Z-0-0-375	23022145	W375	BMA, SK, SMA, N	soldering fixture for centre contacts	W442	
74_Z-0-0-390	23035218	W390	QN	locator tool for 11_QN, 16_QN	W58/W442	
74_Z-0-0-391	23035220	W391	QN	locator tool for 24_QN	W58/W442	
74_Z-0-0-437	23023494		MMBX 32_adapters within series	assembly tool		
74_Z-0-0-441	23024586	W441	BMA, SK, SMA, N	collecting tank for coolant or flux	W374	
74_Z-0-0-442	23024588	W442	BMA, SK, SMA, N	soldering fixture	W374	
74_Z-0-0-443	23024584	W443	BMA, SK, SMA, N	positioning locator tool	W442	
74_Z-0-0-459	84032400	W459	QMA, QN	decoupling tool for high density application		
74_Z-0-0-461	84029787	W461	QMA waterproof	suitable for semi-rigid cables		
74_Z-0-0-488	84101887	W488	MBX 32- adapters within series	assembly and disassembly tool		
74_Z-0-0-555	84020011	W555	MMPX	decoupling tool (distance washers included)		
74_Z-0-0-556	84031617	W556	MMPX	distance washers (for replacement)		

Selection of common and helpful assembly tools

HUBER+SUHNER type	Item no.	W-no. *	For series and cables	Description	Works with tool of W-no.	Picture
74_Z-0-0-557	84032418		MMBX	decoupling tool		
74_Z-0-0-622	85022707	W622	MFBX	coupling tool		
74_Z-0-3-2	22543148	W3-2	SMA, N, semi-rigid 0.141	stripping gauge for insulation		
74_Z-0-3-4	22543150	W3-4	N, semi-rigid 0.0141	trim tool for remove protruding dielectric		

* Idendification marked on tool and referenced in assembling instruction, abbreviated notation derived from the HUBER+SUHNER type e.g. W58 from 74_Z-0-0-58.

Torque wrenches

Box-spanner

Torque wrench (standard style)

HUBER+SUHNER type	Item no.	Suitable for series	Torque Ncm	Opening WAF mm	Notes
74_Z-0-0-504	85020152	4.3-10	500	22.0	standard style
74_Z-0-0-321	22651994	N	100	19.0	standard style
74_Z-0-0-193	22645085	N	100	20.0	standard style
74_Z-0-0-330	22658130	N	100	18.0	standard style
74_Z-0-0-663	85101096	NEX10	150	11.0	standard style
74_Z-0-0-174	22643898	SK	130	8.0	standard style
74_Z-0-0-189	22644368	SK hermetic	200	8.0	standard style
74_Z-0-0-77	22544820	SMA	100	8.0	box spanner style
74_Z-0-0-21	22543130	SMA/PC3.5	100	8.0	standard style
74_Z-0-0-79	22642374	SMA economic	45	8.0	standard style
74_Z-0-0-80	22544821	SMA hermetic	195	7.0	standard style
74_Z-0-0-45	22544232	SMC	30	6.0	standard style
74_Z-0-0-192	22645084	TNC	100	15.0	standard style
74_Z-0-0-373	23021864	TNC	100	14.0	standard style
74_Z-0-0-511	84151106	TNC	260	14.0	standard style

Precision torque wrench

- In plastic box
- With calibration certificate

HUBER+SUHNER type	Item no.	For series	Torque Ncm	Opening WAF mm	Notes
74_Z-0-0-492	84104509	SMA, PC3.5, SK	90	8.0	precision (standard style)