

2. CUTTING-, STRIPPING AND CRIMPING TOOLS

2.3 Crimping tools for cable end sleeves

After the leadings are cutted and stripped the next step is to crimp cable connectors to the conductor ends. This will be normally done by a solderless crimping operation. To prevent a fan out of the conductor ends of stranded or fine stranded copper leadings and to relieve the inserting into clamps, cable end sleeves acc. to DIN 46228 part 1 + 4 in uninsulated as well as insulated design are used. Because the crimping designs are not regulated, different crimping designs acc. to the adjoining table has been established on the market.

To offer to the users their individual preferred or for the application best suited crimping design, druseidt offers various kinds of tools with different forms of die-sets. So tools with self-regulating die-sets with front- or sidewise insertion as well as with separated crimping profiles or as multi functionally tools (cutting-, stripping-, twisting- and crimping inside of one tool) are offered. The tightening forces for the crimped leadings are regulated inside of the EN 60947-1, VDE 0660/part 100 as well as EN 60999 part 1 + 2. Further information are described in the technical appendix on page 205. To realize the described values it is necessary that the outer- \varnothing of the stripped leading and the inside- \varnothing of the cable end sleeve have nearly the same value. The sleeve must be filled on completely and the conductor should be overlap a little bit (in dependence of the cross-section ca. 0,5 mm).

Crimping designs for cable end sleeves:

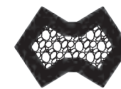
Trapezoid crimping



Square crimping



Double-W-crimping



It is necessary to control the crimped cable end sleeve acc. to crimping mistakes e. g.:

- Crack formation or bursting of the sleeve
- Compliance with the crimp geometry (unsymmetrical crimp designs can be identified by a burr formation on the sleeve)
- Squeezing of conductor wires



Crimping tools for cable end sleeves

acc. to DIN 46228 part 1 and 4


12637
Trapezoid crimping

05122

05125
Trapezoid crimping

Part-No.	cross-section range	description	length	weight kg/pcs.
12637	0,25 - 2,5 mm ²	Simply tool. Trapezoid crimping with cable cutter and spring	140 mm	0,32
05122	0,75 - 16 mm ²	Universal crimping tool with cable cutter	220 mm	0,31
05125	0,50 - 16 mm ²	Crimping tool with ratchet and trapezoid crimping. Ferrule insertion from the side. Seven crimping profiles for the rated conductor cross-sections.	230 mm	0,55

Remark: Part-No. 12637/05122: Simply, low cost tools. Only applicable for occasional repairing works.

Part-No. 05125: Universal tool with ratchet in a good ration in price and performance.

05124
Square crimping

05130
Hexagonal crimping

05131
Square crimping

Part-No.	cross-section range	description	length	weight kg/pcs.
05124	Single 0,50 - 6 mm ² Twin 0,50 - 4 mm ²	Crimping tool with ratchet and square crimping Only one die for the whole cross-section range with front insertion	200 mm	0,43
05130	Single 0,08 - 10 mm ² Twin 0,50 - 6 mm ²	Crimping tool with ratchet and hexagonal crimping Only one die for the whole cross-section range with ferrule insertion from the side	175 mm	0,41
05131	Single 0,08 - 16 mm ² Twin 0,50 - 10 mm ²	Crimping tool with ratchet and square crimping. Only one die for the whole cross-section range with ferrule insertion from the side	175 mm	0,41

Remark: Part-No. 05124: Handy tools with a good ratio in price and performance. With ratchet which guarantee a constant contact pressure. For cable end sleeves up to a length of 14 mm.

Part-No. 05130/05131: High quality crimping tools with only one die for cable end sleeves up to a length of 13 mm. Extremely handy design with ferrule insertion from the side and two component handles.

Crimping tools for cable end sleeves

acc. to DIN 46228 page 1 and 4



12640/12641
Square crimping



12646/12647
Trapezoid crimping

Part-No.	cross-section range		description	length	weight kg/pcs.
12640	Single	0,08 - 10 mm ²	Crimping tool with ratchet and square crimping. Only one die for the whole cross-section range with ferrule insertion from the side.	200 mm	0,33
	Twin	0,5 - 4 mm ²			
12641	Single	2,5 - 16 mm ²		200 mm	0,33
	Twin	6 - 10 mm ²			
12646	Single	0,14 - 6 mm ²	Crimping tool with ratchet and trapezoid crimping. Only one die for the whole cross-section range with front insertion.	230 mm	0,50
	Twin	0,5 - 4 mm ²			
12647	Single	10 - 16 mm ²		230 mm	0,55
	Twin	6 - 10 mm ²			

Remark: Tools with high precision crimping and an excellent power gear ration.



05140
Square crimping



05141
Tool with case



05144
Square crimping

Part-No.	cross-section range		description	length	weight kg/pcs.
05140	Single	0,25 - 6 mm ²	Crimping tool without tool case	130 mm	0,42
	Twin	0,5 - 4 mm ²			
05141	Single	0,25 - 6 mm ²	Part-No. 05144 , but with tool case	130 mm	0,42
	Twin	0,5 - 4 mm ²			
05144	Single	0,08 - 16 mm ²	Crimping tool with ratchet and square crimping. One switchable die with front insertion.	190 mm	0,48
	Twin	0,5 - 10 mm ²			

Remark: Part-No. 05140/41: Perfect in ergonomics and design. The design with the optimized power gear ratio realize a fatigue-proof work. Max. ferrule length in one crimping operation 12 mm and 18 mm in two crimping operations.

Part-No. 05144 High quality crimping tool. Only with one crimping die for cable end sleeves in a cross-section range of 0,08-16 mm² and a length up to 15 mm. With switchable crimping range (working range 1 = 0,08-10 mm², working range 2 = 16 mm²).

Crimping tools for cable end sleeves

acc. to DIN 46228 page 1 and 4



05184

12648/12649

Part-No.	cross-section range		description	length	weight kg/pcs.
12648	Single	10 - 25 mm ²	Crimping tool with ratchet and double W-crimping	260 mm	0,63
12649	Single	35 - 50 mm ²	Crimping tool with ratchet and double W-crimping	260 mm	0,63
	Twin	16 mm ²			
05184	Single	10 - 50 mm ²	Crimping tool with ratchet and trapezoid crimping	300 mm	0,60

Remark: Part-No. 12648/12649 high quality crimping tools with optimized power gear ratio enable fatigue proof work also when working with bigger cross-sections.

Part-No. 05184 universal tool with a wide cross-section range and a good ratio in price and performance. Five crimping profiles with ferrule insertion from the side.

Multifunction crimping tool Quadro

for insulated cable end sleeves in stripform design



12510



12512

Only one tool
4 in 1
for
1. Cutting
2. Stripping
3. Twisting
4. Crimping

Part-No.	cross-section range	description
12510	0,5 - 2,5 mm ²	Quadro-Set consisting out of Quadro-tool, 3 magazine, 1 case for cable end sleeves, 1 tool-case
12512	0,5 - 2,5 mm ²	Quadro without magazine and without tool-case
12514	Replacement magazine for Quadro	

Remark: Only one tool for cutting and stripping of leadings, twisting of the wire strands and crimping of insulated cable end sleeves in stripform design according catalogue page 69. Quick change sleeve magazine enables an easy and ergonomic work in a very short time.