



■ Assembly instructions for cable lugs and connectors

- 1 Strip conductor in line with insertion depth (+ 10 % because of length change of crimp sleeve).
- 2 The conductor ends must be cleaned mechanically prior to assembly.
- 3 Insert conductor fully into cable lug or connector.
- 4 Observing the crimping direction, crimp the cable lug or connector using the appropriate tools. The crimping direction for cable lug and connector is indicated in the diagram opposite.
- 5 Remove excess compound emerging from aluminum cable lugs and connectors.

We recommend the following number of crimps for individual cross sections:

Cross-section mm ²	Tubular cable lugs		Cable lugs to DIN 46235		Al cable lugs	
	5 mm Crimping die	width Crimping dies	5 mm Crimping die	width Crimping dies	7 mm Crimping die	width Crimping dies
6	1		2			
10	1		2			
16	1	1	2	1	4	2
25	2	1	2	1	4	2
35	2	1	2	1	5	2
50	2	1	3	1	5	2
70	2	1	3	1	6	3
95	2	1	4	2	6	3
120	2	1	4	2	6	3
150	2	1	4	2	6	3
185	2	1*	4	2	6	3
240	4	2	5	2	8	3
300	4	2	5	2 (17 mm)** 5 (7 mm)***	8	3
400	4	2		3		4
500				3		4
625				3		
800				3		
1000				3		

* when using quad-point indent crimping (HK60VP, EK 60 VP/FT-L etc.)
Number of crimping operations: 2

** Crimp with crimping dies of Series 25 and Series 45

*** Crimp with crimping dies of Series 13