

Assembly tools

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Crimping tools and inserts for flexible cables

Small crimp tool with fixed inserts



HUBER+SUHNER type	Item no.	Size	Colour code	Square section (centre contact)	Hexagonal section (outer contact)
75_Z-0-3-4	22544613	2 B	orange	1.6 mm /0.063 in	5.5 mm /0.217 in
75_Z-0-4-4	22544612	2 C	yellow	1.6 mm /0.063 in	6.5 mm /0.256 in

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



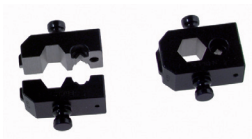
Fig. 1



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 in wooden box (1/2A, 2B, 2C)	2

Interchangeable inserts for small crimp tool



HUBER+SUHNER type	Item no.	Size	Square section (centre contact)	Hexagonal section (outer contact)
76_Z-0-1-1	23000884	0.54/A	0.54 mm /0.021 in	3.3 mm /0.130 in
76_Z-0-2-20	22645153	1/4.95	0.7 mm /0.028 in	4.95 mm /0.195 in
76_Z-0-2-51	22544756	1/2A	0.7/1.6 mm /0.028/0.063 in	3.3 mm /0.130 in
76_Z-0-2-53	22645337	1/2.67	0.7 mm /0.028 in	2.7 mm /0.106 in
76_Z-0-3-51	22544757	2B	1.6 mm /0.063 in	5.5 mm /0.217 in
76_Z-0-4-51	22544758	2C	1.6 mm /0.063 in	6.5 mm /0.256 in

Crimping tools and inserts for flexible cables

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

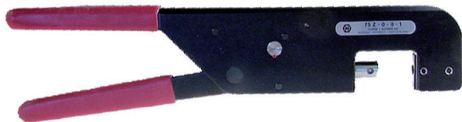


Fig. 1



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 and cutting insert in wooden box (1/2A, 2B, 2C, 3D)	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 480)

Crimping tools and inserts for flexible cables

Interchangeable inserts fitting large crimp tool and table press



HUBER+SUHNER type	Item no.	Size	Colour code	Square section (centre contact)	Hexagonal section (outer contact)
76_Z-0-1-2	23000885	0.54/A		0.54 mm/0.021 in	3.3 mm/0.130 in
76_Z-0-2-1	22543181	1/2 A	red	0.7/1.6 mm/0.028/0.063 in	3.3 mm/0.130 in
76_Z-0-2-8	22544191	1/4.95		0.7 mm/0.028 in	4.95 mm/0.195 in
76_Z-0-3-1	22543185	2 B	orange	1.6 mm/0.063 in	5.5 mm/0.217 in
76_Z-0-3-9	22641133	B 1.22/1.22		1.2 mm/0.047 in	5.5 mm/0.217 in
76_Z-0-4-1	22543189	2 C	yellow	1.6 mm/0.063 in	6.5 mm/0.256 in
76_Z-0-4-8	22543190	C 1.22/1.22		1.2 mm/0.047 in	6.5 mm/0.256 in
76_Z-0-5-8	22543192	8/1.22/1.22		1.2 mm/0.047 in	8.0 mm/0.315 in
76_Z-0-5-21	22543193	2/8.0		1.6 mm/0.063 in	8.0 mm/0.315 in
76_Z-0-6-1	22649051	3/8.65		2.4 mm/0.094 in	8.65 mm/0.341 in
76_Z-0-6-21	22543194	2/9.75		1.6 mm/0.063 in	9.8 mm/0.386 in
76_Z-0-7-1	22543195	3 D	violet	2.4 mm/0.094 in	10.7 mm/0.421 in
76_Z-0-7-7	22543196	2 D		1.6 mm/0.063 in	10.7 mm/0.421 in
76_Z-0-7-8	22660322	2.5/D		2.5 mm/0.098 in	10.7 mm/0.421 in
76_Z-0-7-14	22544524	4 D		3.3 mm/0.130 in	10.7 mm/0.421 in
76_Z-0-10-14	23002630	12.4		-	12.4 mm/0.488 in
76_Z-0-0-26	22645880	1/2.67		0.7 mm/0.028 in	2.7 mm/0.106 in
76_Z-0-3-26	84077169	1.22 / B		1.2 mm/0.047 in	5.5 mm/0.217 in
76_Z-0-4-24	84077171	1.22 / C		1.2 mm/0.047 in	6.5 mm/0.256 in
76_Z-0-5-22	84077161	1.22 / 8.0		1.2 mm/0.047 in	8.0 mm/0.315 in
76_Z-0-0-57	85008389	B		-	5.5 mm/0.217 in
76_Z-0-4-23	84074473	C		-	6.5 mm/0.256 in
76_Z-0-12-1	85009833	14.5		-	14.5 mm/0.570 in

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

Tool sets for semi-rigid cable assembling (solder type)

The tool sets include a solid wooden storage case.
The composition of these sets is as indicated in the list of tools.



HUBER+SUHNER type	Item no.	Size	Colour code
74_Z-0-0-70	22544725	SMA	includes all tools required for economic and reliable assembling of SMA connectors
74_Z-0-0-71	22641350	N	includes all tools required for assembling of N connectors to semi-rigid cables
74_Z-0-0-72	22544747	SMA	includes only the minimum of tools required for assembling of SMA connectors

Selection of common and helpful assembly tools

HUBER+SUHNER type	Item no.	W-no. *	For series	Description	Tool set 74 Z-0-0-			
					70	71	72	
74_Z-0-0-14	22543124	W14	SMA	locator tools for contact and insulators	•		•	
74_Z-0-0-21	22543130	W21	SMA	torque wrench 1 Nm	•			
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 series N		•		

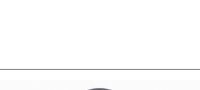
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Selection of common and helpful assembly tools

HUBER+SUHNER type	Item no.	W-no.*	For series	Description	Tool set 74 Z-0-0-			
					70	71	72	
74_Z-0-0-35	22544282	W35	N	soldering gauge 0.45 mm /0.018 in		•		
74_Z-0-0-52	22544553	W52	SMA	dielectric insertion tool for SMA plugs	•		•	
74_Z-0-0-53	22544554	W53	SMA	dielectric insertion tool for SMA jacks	•		•	
74_Z-0-0-54	22544555	W54	SMA	contact holder for pins and sockets	•		•	
74_Z-0-0-55	22544516	W55	SMA	soldering gauge 0.25 mm /0.010 in	•		•	
74_Z-0-0-56	22544517	W56	SMA	soldering gauge 0.4 mm /0.016 in	•		•	
74_Z-0-0-58	22544557	W58	BMA, SK, N, SMA	soldering fixture (works with W374)	•	•	•	
74_Z-0-0-59	22544558	W59	BMA, N, SMA	inserts for EZ_141 (works with W58 and W442)	•	•	•	
74_Z-0-0-60	22544559	W60	BMA, N, SMA	inserts for EZ_86 (works with W58 and W442)	•	•	•	
74_Z-0-0-133	22643022	W133	BMA, N, SMA	insert for EZ_47 (works with W58 and W442)				
74_Z-0-0-62	22544561	W62	SMA	locator tool for SMA plugs without pin (works with W58 and 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 (works with W58 and W442)		•		

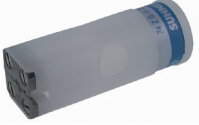
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Selection of common and helpful assembly tools

HUBER+SUHNER type	Item no.	W-no.*	For series	Description	Tool set 74 Z-0-0-			
					70	71	72	
74_Z-0-0-67	22544640	W67	N	contact holder for pins and sockets series N		•		
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-0-0-142	22643462	W142	SMA	rebore tool	•		•	
74_Z-0-0-157	22643029	W157	BMA, SK, N, SMA	cable stripping tool for EZ_47, EZ_86, EZ_141, SUCO-FORM_86 and 141	•	•	•	
74_Z-0-0-160	22643514			replacement cutting wheels; set for EZ_47, EZ_86, EZ_141 (works with W157)	•	•	•	
74_Z-0-0-164	22643028	W164	BMA, N, SMA	trim tool for centre contacts	•	•		
74_Z-0-0-196 74_Z-0-0-197 74_Z-0-0-198 74_Z-0-0-397	22645359 22645360 22645361 84005300			replacement support cover for EZ_47, EZ_86, EZ_141, EZ_118 (works with W157)				
74_Z-0-0-206 74_Z-0-0-207 74_Z-0-0-208	22645364 22645363 22645362			replacement cutting wheels for EZ_47, EZ_86, EZ_141, (works with W157)				
74_Z-0-0-209	22645585	W209	BMA	locator tool used with W58 and W442 (for BMA plug)				
74_Z-0-0-210	22645586	W210	BMA	locator tool used with W58 and W442 (for BMA jack)				
74_Z-0-0-213	22645593	W213	BMA	removal tool for receptacles with snap-in mechanism				
74_Z-0-0-231	22646131	W231	SK	locator tool for SK plugs (works with W58 and W442)				

* marking on tool

Selection of common and helpful assembly tools

HUBER+SUHNER type	Item no.	W-no.*	For series	Description	Tool set 74 Z-0-0-			
					70	71	72	
74_Z-0-0-232	22646132	W232	SK	locator tool for SK jacks (works with W58 and W442)				
74_Z-0-0-233	22646133	W233	SK	inserts for semi-rigid cable EZ_118 (works with W58 and W442)				
74_Z-0-0-234	22646134	W234	SK	replacement cutting wheels for EZ_118 (works with W157)				
74_Z-0-0-246	22646873	W246	SMA	jacket remover for semi-rigid and SUCOFORM cables. After cutting and breaking of jacket with tool W-157, remove separated piece with tool W-246.				
74_Z-0-0-264	22646290	W264	SK	trim tool for centre conductor of semi-rigid cable EZ_118				
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-0-0-368	23021264	W368	SMA	locator tool for SMA female (works with W58 and W442)	•		•	
74_Z-0-0-369	23021266	W369	SMA	locator tool for SMA male (works with W58 and W442)	•		•	
74_Z-0-0-374	23022146	W374	BMA, SK, SMA, N	support for soldering fixture (works with W58 and W442)				
74_Z-0-0-375	23022145	W375	BMA, SK, SMA, N	soldering fixture for centre contacts (works with W374)				

* marking on tool

Selection of common and helpful assembly tools

HUBER+SUHNER type	Item no.	W-no.*	For series	Description	Tool set 74 Z-0-0-			
					70	71	72	
74_Z-0-0-441	23024586	W441	BMA, SK, SMA, N	collecting tank for coolant or flux (works with W374)				
74_Z-0-0-442	23024588	W442	BMA, SK, SMA, N	soldering fixture (works with W374)				
74_Z-0-0-443	23024584	W443	BMA, SK, SMA, N	for positioning locator tools (works with W442)				
74_Z-0-3-2	22543148	W3-2	SMA, N	stripping gauge for insulation EZ_141	•	•		
74_Z-0-3-4	22543150	W3-4	N	trim tool for EZ_141		•		

* marking on tool

Assembly tools for BMA connectors with hermetic seal

HUBER+SUHNER type	Item no.	W-no. *	Description	
74_Z-0-0-211	22645591		soldering fixture for hermetic seal (12_BMA-50-0-3 and 22_BMA-50-0-3)	
74_Z-0-0-214	22645579		torque wrench (box spanner) torque 2.00 Nm, 8 mm hex.	
74_Z-0-0-215	22645580		screwdriver for 12_BMA-50-0-3 to use with 74_Z-0-0-214	

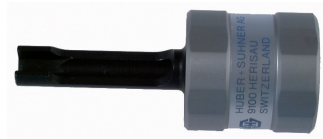
* marking on tool

Assembly tools for SK connectors

HUBER+SUHNER type	Item no.	W-no. *	Description	
74_Z-0-0-226	22646136	W226	soldering fixture for glass bead	
74_Z-0-0-227	22646137	W227	soldering fixture for glass bead	
74_Z-0-0-228	22646138	W228	assembling tool for dielectric bead	
74_Z-0-0-230	22646130	W230	step drill (only if sliding contacts are not used)	
74_Z-0-0-235	22646135	W235	step drill (only if sliding contacts are used)	

* marking on tool

Torque wrenches



Box-spanner



Torque wrench (standard style)

HUBER+SUHNER type	Item no.	For series	Torque	Opening	Notes
74_Z-0-0-21	22543130	SMA / PC 3.5	1.00 Nm	8.0 mm/0.315 in	standard style
74_Z-0-0-45	22544232	SMC	0.30 Nm	6.0 mm/0.236 in	standard style
74_Z-0-0-77	22544820	SMA	1.00 Nm	8.0 mm/0.315 in	box-spanner*
74_Z-0-0-79	22642374	SMA economic	0.45 Nm	8.0 mm/0.315 in	standard style
74_Z-0-0-80	22544821	SMA hermetic	1.95 Nm	7.0 mm/0.276 in	standard style
74_Z-0-0-174	22643898	SK	1.30 Nm	8.0 mm/0.315 in	standard style
74_Z-0-0-189	22644368	SK hermetic	2.00 Nm	8.0 mm/0.315 in	standard style
74_Z-0-0-192	22645084	TNC	1.00 Nm	15.0 mm/0.591 in	standard style
74_Z-0-0-193	22645085	N	1.00 Nm	20.0 mm/0.787 in	standard style
74_Z-0-0-321	22651994	N	1.00 Nm	19.0 mm/0.748 in	standard style
74_Z-0-0-373	23021864	TNC	1.00 Nm	14.0 mm/0.551 in	standard style
74_Z-0-0-504	85020152	4.3-10	5.00 Nm	22.0 mm/0.866 in	standard style

* suitable at high packing density

Precision torque wrench

- In plastic box
- With calibration certificate



HUBER+SUHNER type	Item no.	For series	Torque	Opening	Notes
74_Z-0-0-492	84104509	SMA, SK, PC3.5, PC2.4 and PC1.85	0.9 Nm	8.0 mm/0.315 in	90 ° deflection

Combination tools for MMBX/MMCX/MCX

For protective cap mounting and decoupling



HUBER+SUHNER type	Item no.	Description
74_Z-0-0-30	22543139	assembly tool for 16_MCX and MMBX right angle connectors (decoupling and cap mounting)
74_Z-0-0-225	22645861	16_MMCX-50-1-1, 16_MMCX-50-1-2, 16_MMCX-50-2-1 (decoupling and cap mounting)
74_Z-0-0-272	22648614	all 11_MMCX- and 16_MMCX-connectors (decoupling and cap mounting)
74_Z-0-0-350	23004135	removal tool (16_MMCX)

Special tools for QMA connectors

Decoupling tool for high density applications



HUBER+SUHNER type	Item no.	W-no.*	Description
74_Z-0-0-459	84032400	W459	decoupling tool for high density application (for QMA and QN)

* marking on tool

Assembly tool



HUBER+SUHNER type	Item no.	W-no.*	For series	Description
74_Z-0-0-360	23023444	W360	QMA	locator tools for QMA connectors (suitable for semi-rigid cables)
74_Z-0-0-461	84029787	W461	QMA waterproof	

* marking on tool

Special tools for QN and MMPX connectors

Decoupling tool



HUBER+SUHNER type	Item no.	W-no.*	For series	Description
74_Z-0-0-459	84032400	W459	QN/QMA	decoupling tool for high density application

* marking on tool

Locator tool



HUBER+SUHNER type	Item no.	W-no.*	For series	Description
74_Z-0-0-390	23035218	W390	QN	locator tool for 11 QN and 16 QN connectors (works with W58 and W442)

* marking on tool

Locator tool



HUBER+SUHNER type	Item no.	W-no.*	For series	Description
74_Z-0-0-391	23035220	W391	QN	locator tool for 24 QN connectors (works with W58 and W442)

* marking on tool

Locator tool for MMPX



HUBER+SUHNER type	Item no.	W-no.*	For series	Description
74_Z-0-0-555_---_E	84020011	W555	MMPX	decoupling tool (distance washers included)
74_Z-0-0-556_---_E	84031617	W556		distance washers (for replacement)

* marking on tool

Special tools for MBX and MMBX connectors

Assembly and disassembly tool for MBX



HUBER+SUHNER type	Item no.	Packaging	Operating instruction
74_Z-0-0-488	84101887	single	-

Assembly and disassembly tool for MMBX



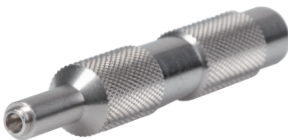
Fig.1



Fig. 2

HUBER+SUHNER type	Item no.	Packaging	Operating instruction	Fig.
74_Z-0-0-437	23023494	single	0000189947	1 (assembly tool)
74_Z-0-0-557	84032418		0000246815	2 (disassembly tool)

Assembly tool for MFBX



HUBER+SUHNER type	Item no.	Packaging	Operating instruction
74_Z-0-0-622	85022707	single	0000470325

Various tools



HUBER+SUHNER type	Item no.	Description
74_Z-0-0-12	22642718	small saw
74_Z-0-0-13	22644241	replacement saw blade for 74_Z-0-0-12
74_Z-0-0-24	22543133	tap drill (thread 1/4-36 UNS-2B)
74_Z-0-0-89	22644721	screwdriver for female centre contacts (series 7/16)
74_Z-0-0-115	22642492	syringe for casing compound
74_Z-0-0-116	22642493	casting compound (resin 6.75 cm ³ and accelertor 3.0 cm ³) 2 containers
74_Z-0-0-177	22644541	tool for cap mounting (16_SMB/C/S connectors)
74_Z-0-0-229	22646139	tap drill (thread 1/4-36 UNS for blind hole thread)
74_Z-0-0-238	22646071	tap drill (thread 5/8-24 UNEF)