

**Instructions for use**



**Service Crimp Tool  
09 99 000 0021**

09 99 000 0021 / 99.00

**Handling Instructions Service Crimp Tool 09 99 000 0021**

The service crimp tool 09 99 000 0021 is designed to crimp solid turned HARTING Han D®, Han E® and Han-Yellock® male and female contacts, wire gauge 0.14 - 2.5 mm² (AWG 26 - AWG 14). For this purpose different suitable locators are available, which can be ordered separately.

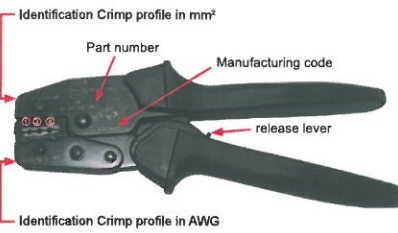
**Products included with tool:**

- Service crimp tool
- Locator Han D® (supplied loose)
- Locator Han E® (mounted)
- Instructions for use

The following crimp contacts / wire gauge sizes can be handled:

Series	Wire gauge in mm²	Wire gauge in AWG	Stripping length
Han D®	0.14 - 1.5 mm²	AWG 26 - 16	8 mm
Han E®	0.5 - 2.5 mm²	AWG 20 - 14	7.5 mm
Han-Yellock®	0.5 - 2.5 mm²	AWG 20 - 14	6.5 mm

**Identification**

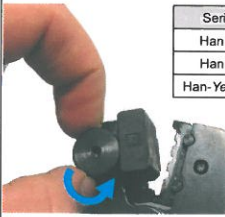


**Crimp profiles:**

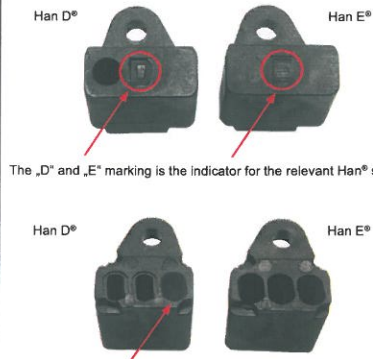
- ① 0.14 - 1 mm² (AWG 26 - 18) Han D®, Han E®, Han-Yellock®
- ② 1.5 mm² (AWG 16) Han D®, Han E®, Han-Yellock®
- ③ 2.5 mm² (AWG 14) Han E®, Han-Yellock®

**Locator**

There are different locators available which are marked with an indicator for the relevant Han® series. The locator ensures that the crimp contact is terminated in the proper position (crimp zone). The locator can be removed and if necessary replaced, for this purpose unscrew the fixing screw on the fixed jaw.



Series	Part Number
Han D®	09 99 000 0022 (Set)
Han E®	09 99 000 0022 (Set)
Han-Yellock®	09 99 000 0343



The „D“ and „E“ marking is the indicator for the relevant Han® series

Locator from rear side (Han D® 2.5 mm² hole is closed)

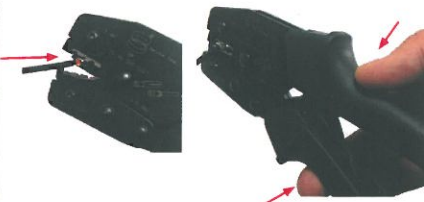
**Crimp Process**

1.) Insert the crimp contact in the proper crimp profile until it comes to a stop at the locator.

- ① Wire gauge 0.14 - 1 mm² (AWG 26 - 18) Han D®, Han E®, Han-Yellock®
- ② Wire gauge 1.5 mm² (AWG 16) Han D®, Han E®, Han-Yellock®
- ③ Wire gauge 2.5 mm² (AWG 14) Han E®, Han-Yellock®



2.) Insert the stripped wire into the contact and crimp by closing the handles until the controlled cycle mechanism releases.



3.) Upon release, the handles will open automatically and the crimped contact can be removed.



It is recommended to check the quality visually after every crimp process.

**Ratchet Mechanism**

In order to ensure a consistent crimp quality, the tool is equipped with a releasable safety catch

- It prevents the tool from closing before the crimping jaws are fully opened
- It prevents the tool from opening before the crimp cycle is completed

**Early Release:**

In case of an operating error it is possible to stop the controlled cycle mechanism and release the tool.

Proceed as follows:

- Relieve ratchet mechanism by slightly pressing handles
- Push forward manual release lever (on movable handle) in direction of the ratchet unit and move it out of the toothed rack
- Open the tool

**HINT:**  
Do not use force to open or close the tool; lubricate all pins, pivot points and bearing surfaces.

**Tensile strength of crimped connections acc. to DIN IEC 60 352-2, A2**

Wire gauge	Tensile strength	Han® Contacts	
mm²	AWG	N	
0.14	26	18	D
0.22	24	28	D
0.25		32	D
0.32	22	40	D
0.50	20	60	D E Yellock
0.75		85	D E Yellock
0.82	18	90	D E Yellock
1		108	D E Yellock
1.30	16	135	D E Yellock
1.50		150	D E Yellock
2.10	14	200	E Yellock
2.50		230	E Yellock

When using the HARTING Service crimp tool and subject to the use in an approved manner the tool will comply with the required extraction forces acc. to DIN IEC 60 352-2, A2.



Pushing Performance

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