INFO

Instructions

1. The choice of the connector

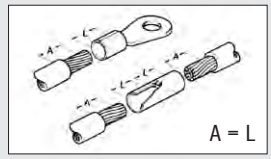
In order to obtain a connection that can be guaranteed for a long time it is necessary to select the connectors suitable to the application field and strictly conform to the section of the cable to be crimped.
In the large range of Haupa products you will certainly find the ideal solution for every requirement.

2. Stripping

Every crimping operation requires first that the cable is stripped without deforming the wires (+10% - since length expansion of crimp sleeve).

3. Cleaning

The conductor ends have to be solidly cleaned from oxidation and every rest of dirt before mounting.

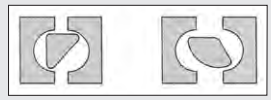


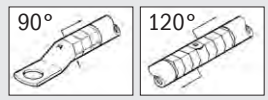
4. Assembling

a) Fit the connector to the cable with a round section in the complete lenght of the stripped area.
b) Verify that there are no wires outside the connector. If you need to use sectoral cables you must arrange a previous rounding crimping operation of the cable.

5. Choice of the crimping tool

All dies and punchings of the Haupa crimp system guarantee a high degree of connection between connector and cable. Exercise the crimping operation as shown in drawing 1 on the terminals and as drawing 2 on the butt connectors. The elevated pressure exerted by dies on terminals cause a uniform deformation on the whole crimping area.





6. Caution

For aluminium cables shoes and connectors, excess, escaped pressing additives must be wiped away.

7. Tensile strength

When correctly processed in accordance with the HAUPA pressing instructions and using HAUPA pressing tools, a tensile strength is ensured in accordance with DIN EN61238-1.

Pressing number for HAUPA conduit terminals and connectors

	HAUPA standard tubular cable lugs "commonly-available version" VDE 0295 class 2		HAUPA F-Type tubular cable lugs Cable class 5 / 6
conductor cross section CSS	quantity crimpings slim 5 mm	quantity crimpings wide > 8 mm	quantity crimpings
0,75	1	-	-
1,5	1	-	-
2,5	1	-	-
4	1	-	-
6	1	-	-
10	1	1	-
16	1	1	1
25	2	1	1
35	2	1	1
50	2	1	1
70	2	1	1
95	2	1	1
120	2	1	1
150	2	1	2
185	2	1*	2
240	4	2	2
300	4	2	2
400	4	2	-
500	4	2	-
625	4	2	-

* when using the four thorn pressing, number of pressings:
AD300-6, SD300-6, HD300-6, KD300-6 /
AD400-6, SD400-6, HD400-6, KD400-6
(page 69 - 70)

Temperature resistance

Connector	Temperature
Cable lugs & connectors copper	max.120° C (in acc. to DIN 46234)
Cable lugs & connectors aluminium	max.120° C (in acc. to IEC 61238)
Cable lugs & connectors of pure nickel	max. 500° C
End sleeves without insulation	max. 120° C (in acc. to DIN 46234)
End sleeves insulated	max. 105° C
Insulated terminals PVC	- 10° C --> + 75° C
Insulated terminals Nylon	- 55° C --> + 105° C
Shrinking terminals	- 55° C --> + 105° C
Socket sleeves male & female, tin-coated brass, uninsulated	- 55° C --> + 100° C

HAUPA cable connections with insulated cables, maximum power loads

Core cross-section mm²	Duct-laid single core cables		Multi-core cables		Exposed air laid single core (gap corresponds to diameter at the least)	
CU	AL	CU	AL	CU	AL	
(A)	(A)	(A)	(A)	(A)	(A)	
0,75	-	-	12	-	15	-
1	11	-	15	-	19	-
1,5	15	-	15	-	19	-
2,5	20	-	26	-	32	-
4	25	-	34	-	42	-
6	33	-	44	-	54	-
10	45	-	61	48	73	57
16	61	48	82	64	98	77
25	83	65	108	85	129	103
35	103	81	135	105	158	124
50	132	103	168	132	198	155
70	165	-	207	163	245	193
95	197	-	250	197	292	230
120	235	-	292	230	344	268
150	-	-	335	263	391	310
185	-	-	383	301	448	353
240	-	-	453	357	528	414
300	-	-	504	409	608	479
400	-	-	-	-	726	569
500	-	-	-	-	830	649

Valid at ambient temperatures of 30 degrees Celsius