

DIE SELECTOR CHART

COPPER CONDUCTORS

EXTRA FLEXIBLE
COPPER CONDUCTORS

CONDUCTOR		CONNECTOR		HYDRAULIC TOOLS																	
				B 15	HT 45 - E			HT 51 B 51		RH 50 B 55		HT 81-U RHU 81		HT 120 and tools and heads with 130 kN crimping force			ECW-H3D			RHU 520	
Conductor Size sqmm		TERMINAL	SPLICE	DIE SET	NEST	INDEN- TOR	DIE SET	NEST	INDENTOR	DIE SET	DIE SET	DIE SET	NEST	INDENTOR	DIE SET	NEST	INDENTOR	DIE SET	NEST	INDENTOR	DIE SET
0,25 ÷ 2,5		A 03-M.. A 06-M..	L 03M / L 03P L 06M / L 06P	ME03/2-15 MA03/3-15																	
4 ÷ 6		A 1-M..	L 1-M L 1-P	ME03/2-15 MA03/3-15	MA 1	PA 1	ME 1					ME 1-50									
10		A 2-M.. A 2-P12	L 2-M L 2-P	ME03/2-15 ME2/3-15 MA03/3-15	MA 2.3	PA 5	ME 2			MA 2.3-50		ME 2-50	ME 2.19-U	MA 2-C		ME 2-C					
16		A 3-M.. A 3-P14	L 3-M L 3-P	ME2/3-15 MA03/3-15			ME 3			PA 5-50		ME 3-50	MA 3.5-U	ME 3.14-U	MA 3-C		ME 3-C				
25		A 5-M.. A 5-P16	L 5-M L 5-P		MA 5		ME 5			MA 5-50		ME 5-50		MA 5-C	PA 10-C	ME 5-C					
35	25* 35	A 7-M.. A 7-P20	L 7-M L 7-P		MA 7	PA 10	ME 7			MA 7-50		ME 7-50	MA 7.14-U	MA 7-C		ME 7-C					
50	35* 50	A 10-M.. A 10-P25	L 10-M L 10-P		MA 10		ME 10			MA 10-50	PA 10-50	ME 10-50	MA 10.19-U	ME 10.24-U	MA 10-C		ME 10-C	Adaptor	Adaptor	Adaptor	Adaptor
70	50* 70	A 14-M.. A 14-P30	L 14-M L 14-P				ME 14			MA 14-50	PA 19-50	ME 14-50	MA 7.14-U	ME 3.14-U	MA 14-C		ME 14-C	AU 230-130 D with die set MA..C and indentor PA..C	AU 230-130 D with die set ME..C	AU 520-130 C with die set MA..C and indentor PA..C	AU 520-130 C with die set ME..C
95	70* 95	A 19-M..	L 19-M L 19-P				ME 19			MA 19-50		ME 19-50	MA 10.19-U MA 19-U	ME 2.19-U	MA 19-C	PA 24-C	ME 19-C				
120	95* 120	A 24-M..	L 24-M L 24-P				ME 24			MA 24-50	PA 24-50	ME 24-50	MA 24-U	ME 10.24-U	MA 24-C		ME 24-C				
150	120* 150	A 30-M..	L 30-M L 30-P				ME 30					ME 30-50	MA 30-80-U	ME 30-U	MA 30-C		ME 30-C				
185	150* 185	A 37-M.. A 37-4ESI	L 37-M L 37-P									ME 37-50	MA 37-U	ME 37-U	MA 37-C	PA 48-C	ME 37-C				
240	185* 240	A 48-M.. A 48-4ESI	L 48-M L 48-P									ME 48-50	MA 48-U	ME 48-U	MA 48-C		ME 48-C				
300	240 300	A 60-M.. A 60-4ESI	L 60-M..												MA 60-C	PA 60-C	ME 60-C				
400	300	A 80-M.. A 80-4ESI	L 80-M..														ME 80-C	MA 80-3D	PA 100-3D	ME 80-3D	MA 80-520
500	400	A 100-M.. A 100-4ESI	L 100-M..															MA 100-3D		MA 100-520	PA 120-520
630	500	A 120-M.. A 120-4ESI	L 120-M..															MA 120-3D	PA 120-3D	ME 120-3D	MA 120-520
800	630	A 160-M.. A 160-4ESI	L 160-M..																	MA 160-520	PA 200-520
1000	800	A 200-M..	L 200-M..																	MA 200-520	
	35	A 9-M..			MA 9	PA 10	ME 9			MA 9-50	PA 10-50	ME 9-50	MA 9.17-U	ME 9.20-U	MA 9-C	PA 10-C	ME 9-C				
	50	A 12-M..					ME 12			MA 12-50	PA 19-50	ME 12-50	MA 12.20-U	ME 12.17-U	MA 12-C		ME 12-C				
	70	A 17-M..					ME 17			MA 17-50	PA 19-50	ME 17-50	MA 9.17-U	ME 12.17-U	MA 17-C	PA 24-C	ME 17-C				
	95	A 20-M..					ME 20			MA 20-50	PA 19-50	ME 20-50	MA 12.20-U	ME 9.20-U	MA 20-C		ME 20-C				
	120	A 29-M..										ME 29-50	MA 29.80-U	ME 29-U	MA 29-C		ME 29-C				
	150	A 35-M..										ME 35-50	MA 35-U	ME 35-U	MA 35-C	PA 48-C	ME 35-C				
	185	A 40-M..										ME 40-50	MA 40-U	ME 40-U	MA 40-C		ME 40-C				

 = Hexagonal crimp (use one size up with fine stranded conductors, E.G.: 95^a fine stranded use A19-.. + ME 19 or A 20-.. + ME 20)

 = Indent crimp

* Contact Cembre for appropriate die set

N.B.: Number inside symbol indicates the number of crimps on A-M barrel

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APPLICATION	CONDUCTOR	CONNECTOR					HYDRAULIC TOOLS												
							B 15	HT 51 B 51	RH 50 B 55	HT 120 and tools and heads with 130 kN crimping force			ECW-H3D						
ANE..M..  ANE..P..  ANE..U.. 	Conductor Size Flex sqmm	TERMINAL						DIE SET		NEST	INDENTOR	DIE SET		NEST	INDENTOR				
	10	ANE 2-M..	ANE 2-P12	ANE 2-U..			NN4-15 	MN 2 RF-50 	MN 2-C 	PN 7-C	MN 2 RF-C 	Adaptor AU 230-130 D with die set MN..C and indentor PN..C or with die set MN..RF-C and die set MN..F-C							
	16	ANE 3-M..	ANE 3-P14	ANE 3-U..				MN 3 RF-50 	MN 3-C 		MN 3 RF-C 								
	25	ANE 5-M..	ANE 5-P16					MN 5 RF-50 	MN 5-C 		MN 5 RF-C 								
	35	ANE 7-M..	ANE 7-P20					MN 7 RF-50 	MN 7-C 		MN 7 RF-C 								
	50	ANE 10-M..					MN 10 RF-50 	MN 10-C 	PN 14-C	MN 10 RF-C 									
	70	ANE 14-M..					MN 14 RF-50 	MN 14-C 		MN 14 RF-C 									
	95	ANE 19-M..						MN 19-C 	PN 24-C	MN 19 RF-C 									
	120	ANE 24-M..						MN 24-C 		MN 24 RF-C 									
	150	ANE 30-M..						MN 30-C 	PN 37-C	MN 30 RF-C 									
ANE..M.. 	35	ANE 9-M..					MN 7 RF-50 	MN 9-C 	PN 14-C	MN 7 RF-C 	Adaptor AU 230-130 D with die set MN..C and indentor PN..C or with die set MN..RF-C and die set MN..F-C								
	50	ANE 12-M..					MN 12 F-50 	MN 12-C 		MN 12 F-C 									
	70	ANE 17-M..					MN 17 F-50 	MN 17-C 	PN 24-C	MN 17 F-C 									
	95	ANE 20-M..						MN 20-C 		MN 20 F-C 									
	120	ANE 29-M..						MN 29-C 	PN 37-C	MN 29 F-C 									
	150	ANE 35-M..						MN 35-C 		MN 35 F-C 									
PK ... 	Conductor Size Flex sqmm	TERMINAL					DIE SET	DIE SET											
	0,3 ÷ 4	PKD 506 ÷ PKD 418	PKE 508 ÷ PKE 418	PKC 508 ÷ PKC 418	KE 506 ÷ KE 412		KE4-15 												
	4 ÷ 16	PKD 410 ÷ PKD 1618	PKE 410 ÷ PKE 1618	PKC 410 ÷ PKC 1618	KE 410 ÷ KE 1616		KE16-15 												
	16	PKD 16..	PKE 16..	PKC 16..	KE 16..		KE35-15 	MTT 16-50 											
	25	PKD 25..	PKE 25..	PKC 25..	KE 25..			MTT 25-50 											
	35	PKD 35..		PKC 35..	KE 35..			MTT 35-50 											
	50	PKD 50..		PKC 50..				MTT 50-50 											

 = Hexagonal crimp

 = Indent crimp

 = Radial crimp

 = circular crimp

 = Trapezium crimp

DIE SELECTOR CHART

APPLICATION	CONDUCTOR		CONNECTOR			HYDRAULIC TOOLS							
						HT 45-E	HT 51 B 51	RH 50 B 55	HT 81-U RHU 81	HT 120 and tools and heads with 130 kN crimping force	ECW-H3D	RHU 520	
C.-C.-ST C.-C.	Conductor Size sqmm		CONNECTOR	CONNECTOR		DIE SET	DIE SET	DIE SET	DIE SET	DIE SET	DIE SET		
	Run	Tap											
	6 ÷ 2,5	6 ÷ 1,5	C 6 - C 6 ST	C 6 - C 6		MC 6	MC 6-50	MC 6.25-U		Adaptor AU 230-130 D with die set MC.-C			
	10	10 ÷ 1,5	C 10 - C 10 ST	C 10 - C 10		MC 10	MC 10-50	MC 10-U	MC 10-C				
	16	16 ÷ 1,5	C 16 - C 16 ST	C 16 - C 16		MC 25	MC 25-50	MC 6.25-U MC 25-U	MC 25-C				
	25 ÷ 16	10 ÷ 1,5	C 25 - C 10 ST	C 25 - C 10									
	25	25 ÷ 16	C 25 - C 25 ST	C 25 - C 25									
	40 ÷ 35	16 ÷ 1,5	C 35 - C 16 ST	C 35 - C 16		MC 35	MC 35-50	MC 35-U	MC 35-C			Adaptor AU 520-130 C with die set MC.-C	
	40 ÷ 35	40 ÷ 25	C 35 - C 35 ST	C 35 - C 35									
	50	25 ÷ 10											
	70 ÷ 63	25 ÷ 1,5	C 70 - C 25N ST	C 70 - C 25N			*MC 70-50	MC 70-80U	MC 70-C	MC 70-3D			
	50	25 ÷ 4	C 50 - C 25 ST	C 50 - C 25									
	*50	50 ÷ 35	C 50 - C 50 ST	C 50 - C 50									
	*70 ÷ 50	40 ÷ 4	C 70 - C 35 ST	C 70 - C 35									
	*70 ÷ 50	70 ÷ 35	C 70 - C 70 ST	C 70 - C 70				MC 95-80U	MC 95-C	MC 95-3D			
	100 ÷ 95	40 ÷ 4	C 95 - C 35 ST	C 95 - C 35									
	100 ÷ 95	70 ÷ 40	C 95 - C 70 ST	C 95 - C 70									
	100 ÷ 95	100 ÷ 63	C 95 - C 95 ST	C 95 - C 95					MC 185-C	MC 185-3D			
	125 ÷ 110	125 ÷ 25	C 120 - C 120 ST	C 120 - C 120									
	160 ÷ 150	125 ÷ 25	C 150 - C 120 ST	C 150 - C 120									
	150	150 ÷ 63	C 150 - C 150 ST	C 150 - C 150									
	185	100 ÷ 16	C 185 - C 95 ST	C 185 - C 95						MC 240-3D			
185 ÷ 120	185 ÷ 120	C 185 - C 185 ST	C 185 - C 185										
240 ÷ 150	120 ÷ 95	C 240 - C 120 ST	C 240 - C 120										
MT.-TD MT.-GC CA.-M., CA.-2M.. MT.-C.	Conductor Size sqmm		SPLICE		TERMINALS			DIE SET	DIE SET	DIE SET	DIE SET	DIE SET	
	25 R		MT 25 - TD	MT 25 - GC	CA 25 - M..	CA 25 - 2M..	MT 25 - C..		MMT 25-50	MMT 25-U	MMT 25-C	Adaptor AU 230-130 D with die set MMT.-C	Adaptor AU 520-130 C with die set MMT.-C
	35 RC/S ÷ 40 S		MT 40 S - TD	MT 40 S - GC	CA 40 S - M..	CA 40 S - 2M..	MT 40 S - C..		MMT 50-50	MMT 50-U	MMT 50-C		
	50 RC		MT 50 R - TD	MT 50 R - GC	CA 50 R - M..	CA 50 R - 2M..	MT 50 R - C..						
	50 S		MT 50 S - TD	MT 50 S - GC	CA 50 S - M..	CA 50 S - 2M..	MT 50 S - C..		MMT 95-50	MMT 95-U	MMT 95-C		
	63 S ÷ 70 S		MT 70 S - TD	MT 70 S - GC	CA 70 S - M..	CA 70 S - 2M..	MT 70 S - C..						
	80 S ÷ 95 RC		MT 95 R - TD	MT 95 R - GC	CA 95 R - M..	CA 95 R - 2M..	MT 95 R - C..						
	95 S ÷ 100 S		MT 95 S - TD	MT 95 S - GC	CA 95 S - M..	CA 95 S - 2M..	MT 95 S - C..						
	120 RC/S ÷ 150 RC		MT 150 R - TD	MT 150 R - GC	CA 150 R - M..	CA 150 R - 2M..	MT 150 R - C..		MMT 200-50	MMT 200-U	MMT 200-C		
	150 S ÷ 160 RC		MT 150 S - TD	MT 150 S - GC	CA 150 S - M..	CA 150 S - 2M..	MT 150 S - C..						
	160 S ÷ 200 RC		MT 200 R - TD	MT 200 R - GC	CA 200 R - M..	CA 200 R - 2M..	MT 200 R - C..						
	200 S ÷ 240 RC		MT 240 R - TD	MT 240 R - GC	CA 240 R - M..	CA 240 R - 2M..	MT 240 R - C..				MMT 315-C		
	240 S ÷ 315 RC		MT 315 R - TD	MT 315 R - GC	CA 315 R - M..	CA 315 R - 2M..	MT 315 R - C..						
	315 S		MT 315 S - TD	MT 315 S - GC	CA 315 S - M..	CA 315 S - 2M..	MT 315 S - C..						
	400 R		MT 400 - TD		2A 80 - M..	2A 80 - 2M..				ME 80-C	ME 80 - 3D	ME 80 - 520	
	500 R		MT 500 - TD		2A 100 - M..	2A 100 - 2M..					ME 100 - 3D	ME 100 - 520	
	600 R ÷ 630 R		MT 630 - TD		2A 120 - M..	2A 120 - 2M..					ME 120 - 3D	ME 120 - 520	

 = Hexagonal crimp = Oval crimp = circular crimp

* When using die set type MC70-50, the conductors marked with a star must be annealed.

DIE SELECTOR CHART FOR DEEP STEPPED INDENTING WITH CONTAINING DIES

APPLICATIONS	CONDUCTOR	CONNECTORS			HYDRAULIC TOOLS			
					HT 131-UC RHU 131-C B 131-UC			
CAA.-M.. MTA.-C	Conductor Size sqmm	LUGS			DIE HOLDER	DIE		INDENTOR
	10	CAA 10 - M..			AU 130-150	MV 35 	MUA 35 	PS 130-35/E
	16	CAA 16 - M..	MTA 16 - C			MV 95 	MUA 95 	PS 130-95/E
	25	CAA 25 - M..	MTA 25 - C					
	35	CAA 35 - M..	MTA 35 - C					
	50	CAA 50 - M..	MTA 50 - C					
	70	CAA 70 - M..	MTA 70 - C..					
	95	CAA 95 - M..	MTA 95 - C..			MV 150 	MUA 150 	PS 130-150/E
	120	CAA 120 - M..	MTA 120 - C..					
	150	CAA 150 - M..	MTA 150 - C..			AU 130-240	MV 240 	MUA 240 
	185	CAA 185 - M..	MTA 185 - C..		MUA 300-34 			
	240	CAA 240 - M..	MTA 240 - C..					
	300	CAA 300 - 34 - M..						
	AA.-M..	Conductor Size sqmm	LUGS			DIE HOLDER	DIE	
16		AA 16 - M..			AU 130-150	MUA 35 		PS 130-35/E
25		AA 25 - M..				MUA 95 	PS 130-95/E	
35		AA 35 - M..						
50		AA 50 - M..						
70		AA 70 - M..						
95		AA 95 - M..						MUA 150 
120		AA 120 - M..						
150		AA 150 - M..				AU 130-240	MUA 240 	
185		AA 185 - M..			MUA 300-34 			
240		AA 240 - M..						
300		AA 300 - 34 - M..						

 Indent crimp

DIE SELECTOR CHART FOR DEEP STEPPED INDENTING WITH CONTAINING DIES

Conductor Size sqmm	SPICES		Conductor Size sqmm		SPICES	HYDRAULIC TOOLS HT 131-UC RHU 131-C B 131-UC			
			Al	Al/Cu		DIE HOLDER	DIE	INDENTOR	
10	MTMA 10-GC					AU 130-150	MVM 35 	MUA 35 	PS 130-35/E
16	MTMA 16-GC	MTMA 16/1	16	10	MTMA 16-10 GC				
25	MTMA 25-GC	MTMA 25/1	25	10	MTMA 25-10 GC				
			25	16	MTMA 25-16 GC				
35	MTMA 35-GC	MTMA 35/1							
50	MTMA 50-GC	MTMA 50/1	50	25	MTMA 50-25 GC				
			50	35	MTMA 50-35 GC				
70	MTMA 70-GC	MTMA 70/1	70	35	MTMA 70-35 GC				
			70	50	MTMA 70-50 GC				
95	MTMA 95-GC	MTMA 95/1	95	50	MTMA 95-50 GC				
			95	70	MTMA 95-70 GC				
120	MTMA 120-GC	MTMA 120/1	120	70	MTMA 120-70 GC				
			120	95	MTMA 120-95 GC				
150	MTMA 150-GC	MTMA 150/1	150	70	MTMA 150-70 GC				
			150	95	MTMA 150-95 GC				
			150	120	MTMA 150-120 GC				
185	MTMA 185-GC	MTMA 185/1	185	120	MTMA 185-120 GC	AU 130-240	MVM 240 	MUA 240 	PS 130-240/E
			185	150	MTMA 185-150 GC				
240	MTMA 240-GC	MTMA 240/1	240	150	MTMA 240-150 GC				
			240	185	MTMA 240-185 GC				
300	MTMAD 300-GC	MTMAD 300/1	300	185	MTMAD 300-185 GC				
			300	240	MTMAD 300-240 GC		MUA 300-34 		

MTMA...GC

PRE-ROUNDERS SELECTION

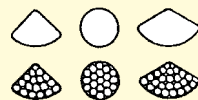
DIES DESCRIPTION

DIES SEQUENCE

ALUMINIUM CONDUCTOR SIZE sqmm

PRE-ROUNDER

DIE-SUPPORT



1) AU 130-.. DIE-HOLDER

Used to house dies and pre-rounders.

2) UP 130-.. PRE-ROUNDERS

Used to round aluminium sectoral conductors in order to introduce them into circular connectors.

Each pre-rounder is made of two parts: the upper part is housed in die-holder AU 130-.. and the lower part is locked onto AC 130-P.. die support.

3) AC 130-P.. DIE SUPPORT

Houses lower part of pre-rounder UP 130-..

4) MUA... DIES

Containing dies.

5) PS 130-../E INDENTORS

Such indentors are specifically engineered for deep indentation of aluminium conductors of any stranding configuration.

CONDUCTOR ROUNDING

CRIMPING

1



1



2



4



3



5

