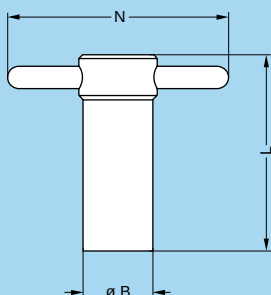


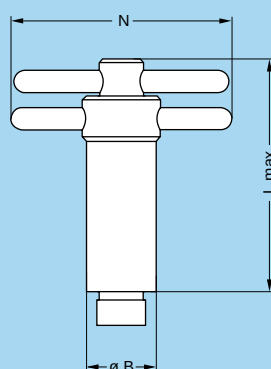
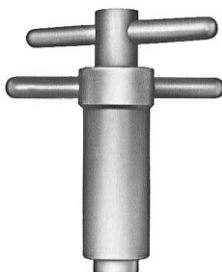
## Tooling



### DCG Spanners for hexagonal nuts

| Part number    | Series | Dim. (mm) |    |    | Part number of the nut |
|----------------|--------|-----------|----|----|------------------------|
|                |        | B         | L  | N  |                        |
| DCG.91.149.0TN | 00     | 14        | 40 | 50 | GEA.00.240.LN          |
| DCG.91.161.1TN | 0B     | 16        | 45 | 52 | GEA.0S.240.LN          |
| DCG.91.231.7TN | 2B     | 23        | 62 | 68 | GEA.2S.240.LN          |
| DCG.91.282.2TN | 3B     | 28        | 76 | 73 | GEA.3S.240.LN          |

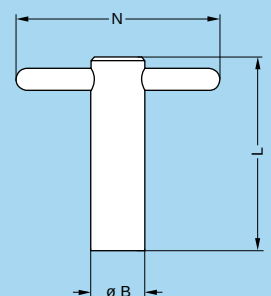
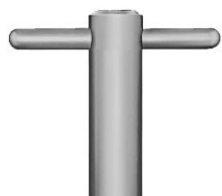
- Material: Blackened steel



### DCA Spanners for hexagonal nuts, with alignment of the sockets by the flats

| Part number    | Series | Dim. (mm) |     |    | Part number of the nut |
|----------------|--------|-----------|-----|----|------------------------|
|                |        | B         | L   | N  |                        |
| DCA.91.149.0TN | 00     | 14        | 65  | 50 | GEA.00.240.LN          |
| DCA.91.161.1TN | 0B     | 16        | 73  | 52 | GEA.0S.240.LN          |
| DCA.91.231.7TN | 2B     | 23        | 100 | 68 | GEA.2S.240.LN          |
| DCA.91.282.2TN | 3B     | 28        | 120 | 73 | GEA.3S.240.LN          |

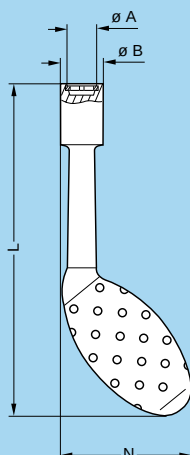
- Material: Blackened steel



### DCB Spanners type wrench for Model 1 round nuts

| Part number    | Series | Dim. (mm) |    |    | Part number of the nut |
|----------------|--------|-----------|----|----|------------------------|
|                |        | B         | L  | N  |                        |
| DCB.91.119.0TN | 00     | 11        | 40 | 50 | GEB.00.240.LN          |
| DCB.91.131.1TN | 0B     | 13        | 45 | 50 | GEB.0S.240.LN          |
| DCB.91.201.8TN | 2B     | 20        | 62 | 65 | GEB.2S.240.LN          |
| DCB.91.242.2TN | 3B     | 24        | 76 | 70 | GEB.3S.240.LN          |

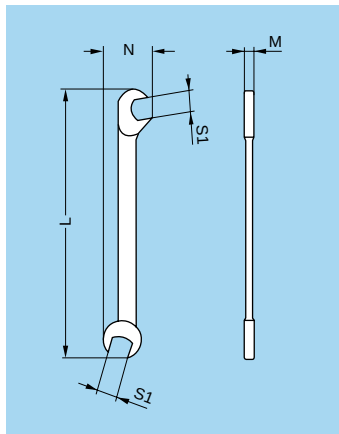
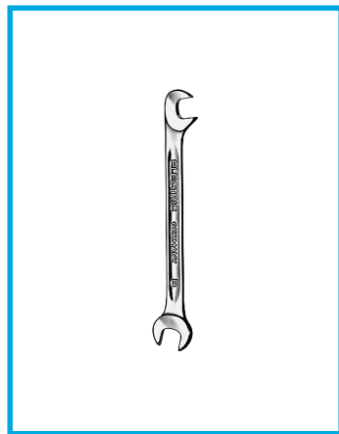
- Material: Blackened steel



### DCH Spanners for conical nut

| Part number   | Series | Dimensions (mm) |      |     |      | Part number of the nut |
|---------------|--------|-----------------|------|-----|------|------------------------|
|               |        | A               | B    | L   | N    |                        |
| DCH.91.101.PN | 00     | 10.1            | 12.8 | 124 | 48.3 | GEC.00.240.LC          |
| DCH.91.121.PN | 0B     | 12.1            | 14.8 | 124 | 49.3 | GEC.0S.240.LC          |
| DCH.91.201.PN | 2B     | 20.1            | 22.8 | 129 | 53.5 | GEC.2S.240.LC          |

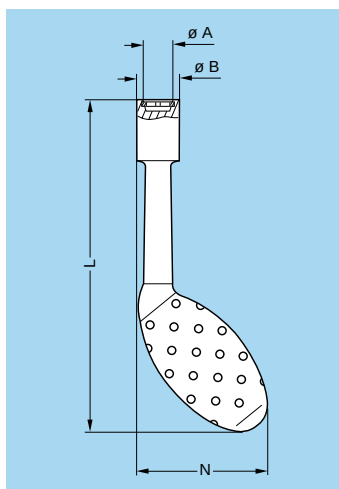
- Material: Dark grey polyurethane



## DCP Flat spanners for collet nut

| Part number   | Series | Dimensions (mm) |   |      |     |
|---------------|--------|-----------------|---|------|-----|
|               |        | L               | M | N    | S1  |
| DCP.99.045.TC | 00     | 70              | 2 | 10.5 | 4.5 |
| DCP.99.050.TC | 00     | 78              | 2 | 12.6 | 5.0 |
| DCP.99.055.TC | 00     | 78              | 2 | 12.6 | 5.5 |
| DCP.99.060.TC | 00     | 78              | 2 | 12.6 | 6.0 |

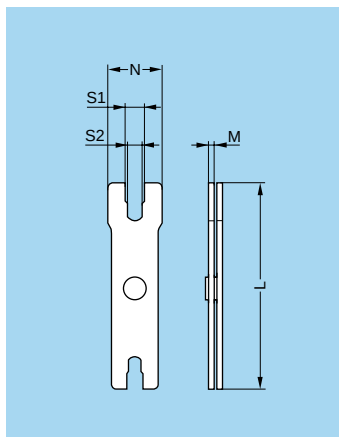
- Material: Chrome-plated steel



## DCH Spanners for notched nuts

| Part number   | Series | Dimensions (mm) |      |     |      | Part number of the nut |
|---------------|--------|-----------------|------|-----|------|------------------------|
|               |        | A               | B    | L   | N    |                        |
| DCH.91.101.PA | 00     | 10.1            | 12.8 | 124 | 48.3 | GEG.00.240.LC          |
| DCH.91.121.PA | 0B     | 12.1            | 14.8 | 124 | 49.3 | GEG.0S.240.LC          |
| DCH.91.181.PA | 0K     | 18.1            | 22.8 | 129 | 53.1 | GEG.0E.240.LC          |
| DCH.91.201.PA | 2B     | 20.1            | 22.8 | 129 | 53.5 | GEG.2S.240.LC          |
| DCH.91.251.PA | 2K     | 25.1            | 32.8 | 134 | 55.5 | GEG.2E.240.LC          |

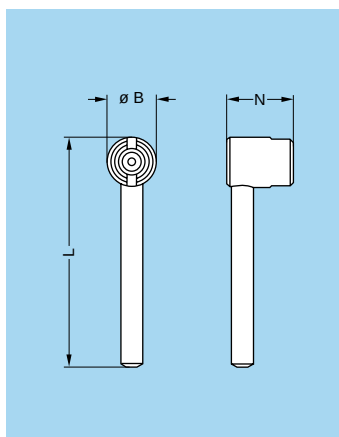
- Material: Blue polyurethane



## DCP Spanners for tightening collet nut

| Part number   | Series | Dimensions (mm) |     |    |      |      |
|---------------|--------|-----------------|-----|----|------|------|
|               |        | L               | M   | N  | S1   | S2   |
| DCP.91.001.TN | 0B     | 95              | 2.5 | 21 | 8.1  | 7.1  |
| DCP.91.023.TN | 2B-2K  | 115             | 3.0 | 30 | 13.1 | 12.1 |
|               | 3B-3K  | 115             | 3.0 | 35 | 15.1 | 14.1 |
| DCP.91.045.TN | 4B     | 130             | 3.5 | 40 | 21.2 | 20.2 |
|               | 5B     | 130             | 3.5 | 45 | 31.2 | 30.2 |

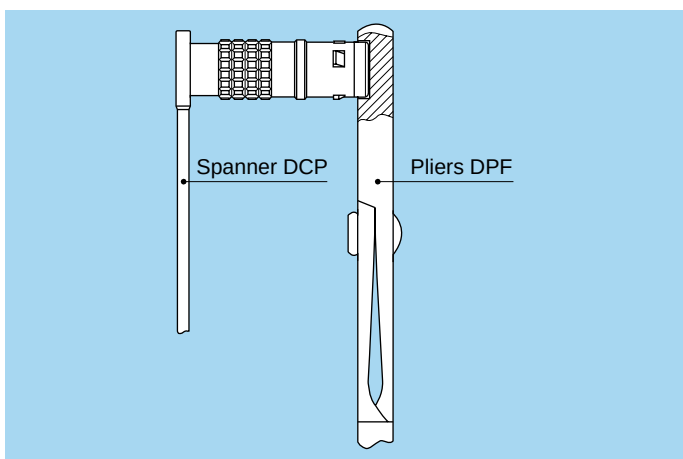
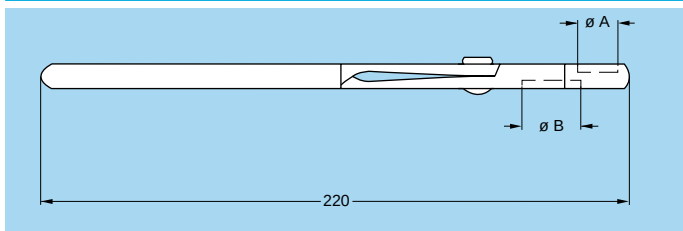
- Material: Blackened steel



## DCL Spanners for securing straight plug with two latching tabs while tightening collet nut

| Part number    | Series | Dimensions (mm) |    |      |
|----------------|--------|-----------------|----|------|
|                |        | B               | L  | N    |
| DCL.91.105.0TK | 00     | 10              | 45 | 13.5 |

- Material: Blackened steel

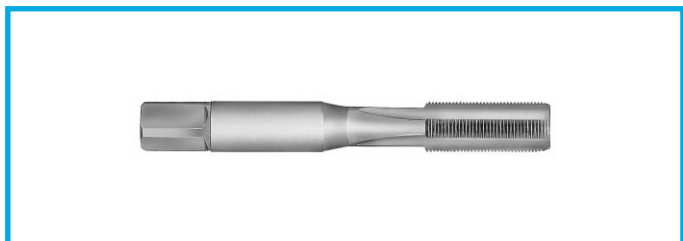


## DPF Pliers for assembling plugs (series K)

| Part number   | Series | Dimensions (mm) |    |
|---------------|--------|-----------------|----|
|               |        | A               | B  |
| DPF.91.001.TA | 0K     | 10              | –  |
| DPF.91.023.TA | 2K     | 15              | –  |
|               | 3K     | –               | 18 |

## Example for use

The plug end must be held in the pliers while the nut is tightened with the spanner.



## DTA Taps

| Part number   | Series | Thread   |
|---------------|--------|----------|
| DTA.99.700.5Z | 00     | M7 x 0.5 |
| DTA.99.900.6Z | 0B     | M9 x 0.6 |

Fig. 1

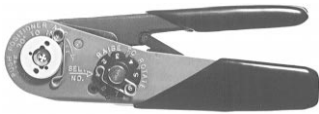
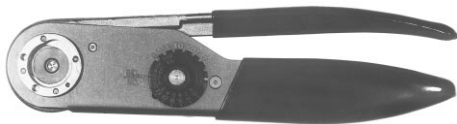


Fig. 2



## Manual crimping tools

| Supplier | Part number                    |                            |
|----------|--------------------------------|----------------------------|
|          | contact ø 0.7-0.9-1.3 (Fig. 1) | contact ø 1.6-2.0 (Fig. 2) |
| LEMO     | DPC.91.701.V <sup>1)</sup>     | DPC.91.101.A <sup>2)</sup> |
| DANIELS  | MH860 <sup>1)</sup>            | AF8 <sup>2)</sup>          |
| BALMAR   | 23-000                         | 55-000                     |
| BUCHANAN | 616336 <sup>1)</sup>           | 615708 <sup>2)</sup>       |

<sup>1)</sup> According to specification MIL-C-22520/7-01.

<sup>2)</sup> According to specification MIL-C-22520/1-01.



male



female

These positioners are suitable for use with manual crimping tool according to the MIL-C-22520/7-01 standard.

## DCE Positioners for crimp contacts ø 0.7, 0.9 and 1.3 mm

| Connector        |         |                   |               | Positioners part number |                    |
|------------------|---------|-------------------|---------------|-------------------------|--------------------|
| Type             |         | ø Contact         | Conductor AWG | For male contact        | For female contact |
| F1               | F2      |                   |               |                         |                    |
| <b>2B<br/>2K</b> | 96A 92A | 0.9               | 20-22-24      | DCE.91.092.BVC          | DCE.91.092.BVM     |
|                  | 96C 92C |                   |               |                         |                    |
|                  | 96E 92E | 0.7               | 22-24-26      | DCE.91.072.BVC          | DCE.91.072.BVM     |
|                  | 96J 92J |                   |               |                         |                    |
| <b>3B<br/>3K</b> | 97C 93B | 0.9               | 20-22-24      | DCE.91.093.BVC          | DCE.91.093.BVM     |
|                  | 97E 93E |                   |               |                         |                    |
|                  | – 87E   |                   |               |                         |                    |
|                  | 97J 93J |                   |               |                         |                    |
|                  | 97R 93R | 0.7               | 22-24-26      | DCE.91.073.BVC          | DCE.91.073.BVM     |
|                  | 96X 92X |                   |               |                         |                    |
| <b>4B<br/>4K</b> | – 95D   | 1.3               | 18-20         | DCE.91.134.BVC          | DCE.91.134.BVM     |
|                  |         | 1.3 <sup>1)</sup> | 18-20         | DCE.91.133.BVCY         | DCE.91.133.BVM     |
|                  | – 93E   | 0.9               | 20-22-24      | DCE.91.094.BVC          | DCE.91.094.BVM     |
|                  |         | 1.3               | 18-20         | DCE.91.134.BVC          | DCE.91.134.BVM     |
|                  | 97F –   | 0.9               | 20-22-24      | DCE.91.094.BVC          | DCE.91.094.BVM     |
|                  | 97R 93R | 0.9               | 20-22-24      | DCE.91.094.BVC          | DCE.91.094.BVM     |
|                  | 97L 93L |                   |               |                         |                    |
|                  | 98L 94L |                   |               |                         |                    |
|                  | 97T 93T |                   |               |                         |                    |
|                  | – 88E   | 0.7               | 22-24-26      | DCE.91.074.BVC          | DCE.91.074.BVM     |
|                  | 99H –   |                   |               |                         |                    |
|                  | 98E 94E |                   |               |                         |                    |

**Note:** <sup>1)</sup> Arrangement with special contact length, special positioners are required.



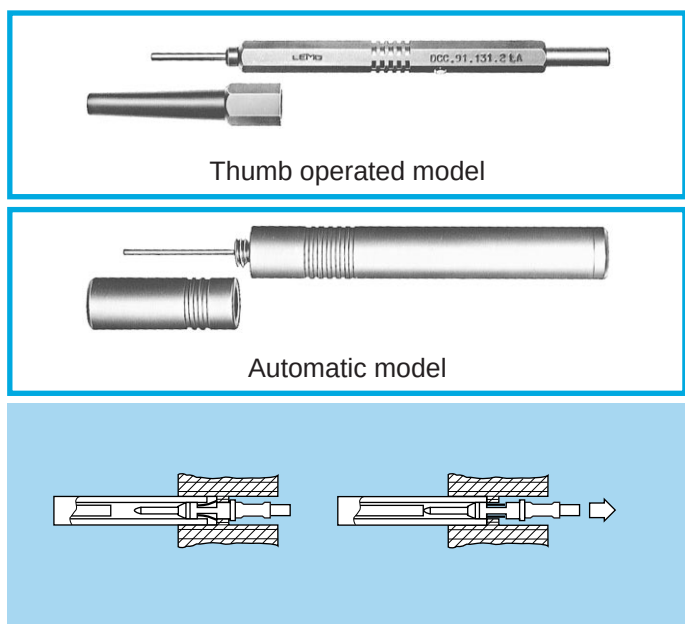
These turrets are suitable for use with manual crimping tool according to the MIL-C-22520/1-01 standard.

**Note:** A wide variation of strand number and diameter combinations are quoted as being AWG, some of which do not have a large enough cross section to guarantee a crimp as per either MIL-C-22520/1 or /7-01. Our technical department is at your disposal to study and propose a solution to all your specific problems.

## DCE Turrets for crimp contacts ø 1.6 and 2.0 mm

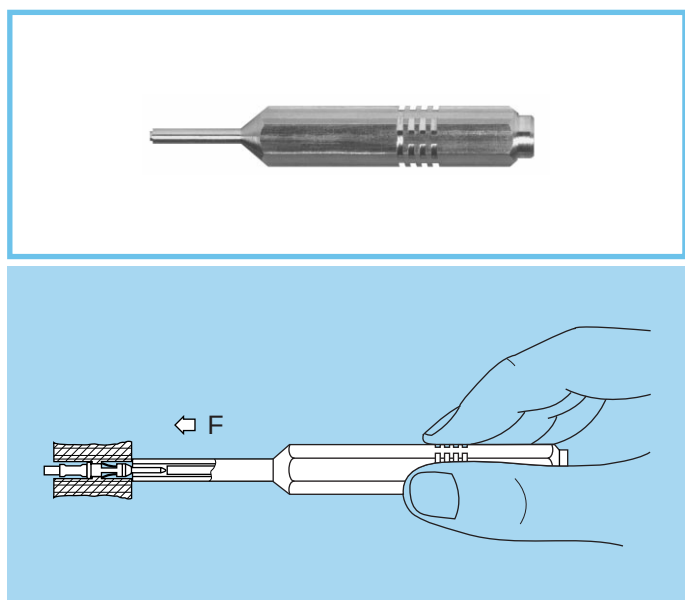
| Connector        |       |                   |               | Turret part number |                    |
|------------------|-------|-------------------|---------------|--------------------|--------------------|
| Type             |       | ø Contact         | Conductor AWG | For male contact   | For female contact |
| F1               | F2    |                   |               |                    |                    |
| <b>5B<br/>5K</b> | – 94B | 2.0               | 12-14-16      | DCE.91.205.BVCM    | DCE.91.205.BVCM    |
|                  |       | 2.0 <sup>1)</sup> | 12-14-16      | DCE.91.203.BVCM    | DCE.91.204.BVCM    |
|                  | – 956 | 1.6 <sup>1)</sup> | 14-16-18      |                    |                    |
|                  | – 90C | 1.6 <sup>1)</sup> | 14-16-18      | DCE.91.164.BVCM    | DCE.91.162.BVCM    |

**Note:** <sup>1)</sup> Arrangement with special contact length, turret from another series are required.



## DCC Extraction tools for crimp contacts

| FO Contact Types |         | ø A Contact | Extractor            |                 |
|------------------|---------|-------------|----------------------|-----------------|
|                  |         |             | Thumb operated model | Automatic model |
| <b>2B<br/>2K</b> | 96A 92A | 0.9         | DCC.91.090.5LA       | DCF.91.090.2LT  |
|                  | 96C 92C | 0.7         | DCC.91.070.5LA       | DCF.91.070.2LT  |
|                  | 96E 92E |             |                      |                 |
|                  | 96J 92J |             |                      |                 |
| <b>3B<br/>3K</b> | 97C 93B | 0.9         | DCC.91.090.5LA       | DCF.91.093.5LT  |
|                  | 97E 93E |             |                      |                 |
|                  | – 87E   |             |                      |                 |
|                  | 97J 93J | 0.7         | DCC.91.070.5LA       | DCF.91.073.5LT  |
|                  | 97R 93R |             |                      |                 |
|                  | 96X 92X |             |                      |                 |
|                  | – 87R   |             |                      |                 |
| <b>4B<br/>4K</b> | – 95D   | 1.3         | DCC.91.131.5LA       | DCF.91.133.5LT  |
|                  | – 93E   | 1.3         | DCC.91.131.5LA       | DCF.91.133.5LT  |
|                  |         | 0.9         | DCC.91.090.5LA       | DCF.91.093.5LT  |
|                  | 97F –   | 1.3         | DCC.91.131.5LA       | DCF.91.133.5LT  |
|                  |         | 0.9         | DCC.91.090.5LA       | DCF.91.093.5LT  |
|                  | 97R 93R | 0.9         | DCC.91.090.5LA       | DCF.91.093.5LT  |
|                  | 97L 93L |             |                      |                 |
|                  | 98L 94L |             |                      |                 |
|                  | 97T 93T |             |                      |                 |
|                  | – 88E   |             |                      |                 |
|                  | 99H –   |             |                      |                 |
|                  | 98E 94E |             |                      |                 |
| <b>5B<br/>5K</b> | – 94B   | 2.0         | DCC.91.202.5LA       | DCF.91.203.5LT  |
|                  | – 956   | 2.0         | DCC.91.202.5LA       | DCF.91.203.5LT  |
|                  |         | 1.6         | DCC.91.162.5LA       | DCF.91.163.5LT  |
|                  | – 90C   | 1.6         | DCC.91.162.5LA       | DCF.91.163.5LT  |

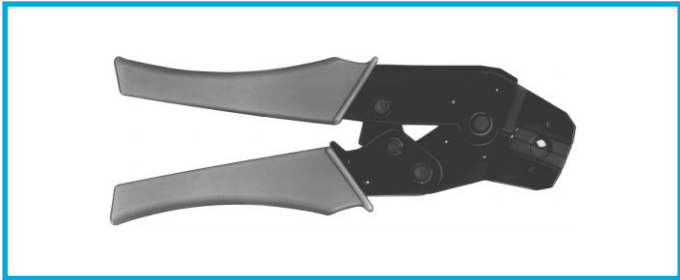


## DCK Retention testing tools for crimp contacts ø 0.7, 0.9 and 1.3 mm

| Contact ø A | Test force (N) | Testing tool part number |                    |
|-------------|----------------|--------------------------|--------------------|
|             |                | For male contact         | For female contact |
| 0.7         | 14             | DCK.91.071.4LRC          | DCK.91.071.4LRM    |
| 0.9         | 14             | DCK.91.091.4LRC          | DCK.91.091.4LRM    |
| 1.3         | 25             | DCK.91.132.5LRC          | DCK.91.132.5LRM    |

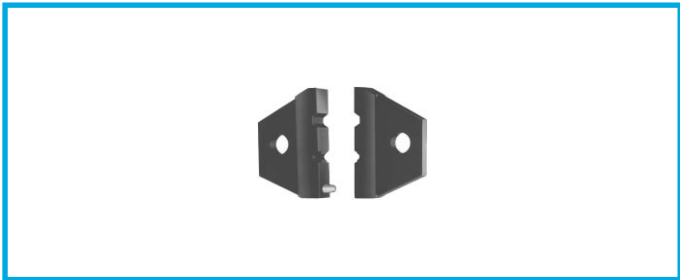


## Tools for type C Coaxial Contacts

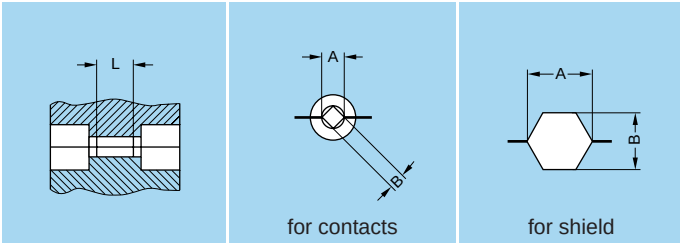


### DPE Crimping tool with die

| Part number   | Cable group |
|---------------|-------------|
| DPE.99.103.1K | 2           |
| DPE.99.103.8K | 1, 3        |

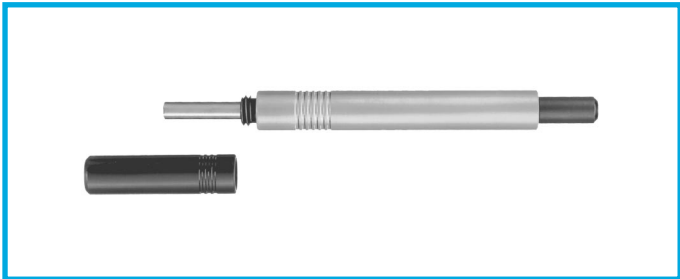


### DPN Dies



| Part number   | Cable group | Die dimensions |      |     |            |      |  |
|---------------|-------------|----------------|------|-----|------------|------|--|
|               |             | For contacts   |      |     | For shield |      |  |
|               |             | A              | B    | L   | A          | B    |  |
| DPN.99.103.1K | 2           | 1.09           | 0.77 | 2.0 | 3.10       | 2.70 |  |
| DPN.99.103.8K | 1, 3        | 1.09           | 0.77 | 2.0 | 3.80       | 3.30 |  |

- Die material: Blackened steel



### DCC Extractors

| Part number    | Cable group |
|----------------|-------------|
| DCC.91.384.5LA | 1, 2, 3     |

## Fibre Optic Tooling

We propose a complete range of tools for fibre optic connector cable assembly. Some tools are specific to each fibre optic contact type. When selecting necessary tooling, make sure you identify correctly the contact type used in the selected product.



### DRV Complete workstation for fibre optic contact

#### Description

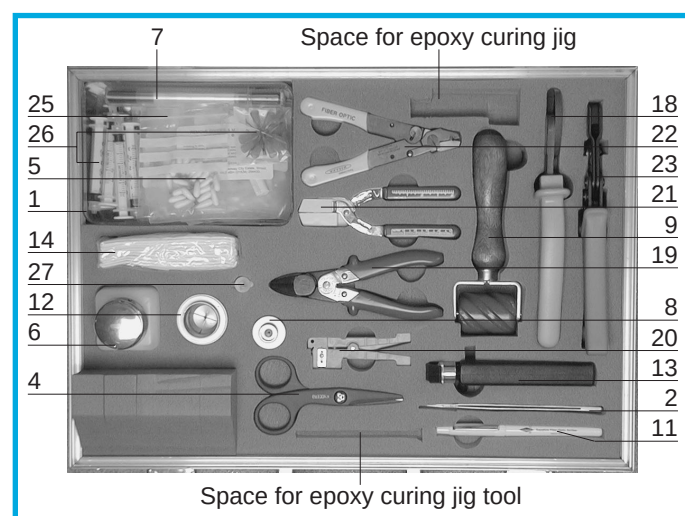
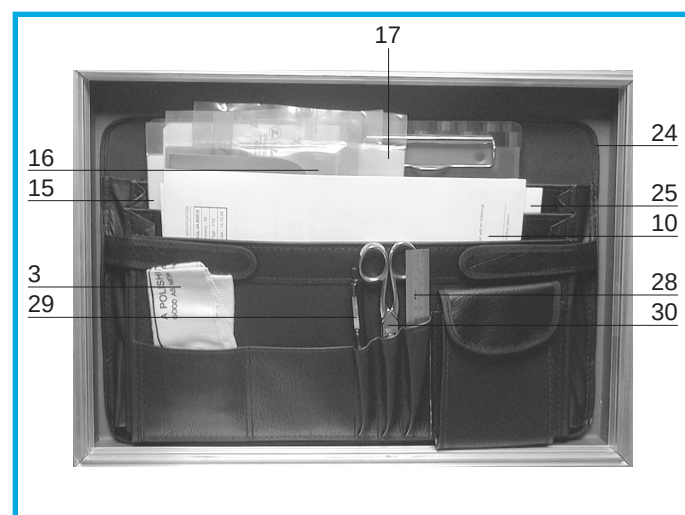
Comprehensive range of tools for terminating both single-mode and multi-mode fibres. Includes specific tools for F2 and F4 fibre optic contacts. Detachable termination case lid for use as polishing platform during field termination. Rugged but aesthetically pleasing termination case which is ideal for field use or in-house terminations. Curing oven and inspection microscope shall be ordered separately.

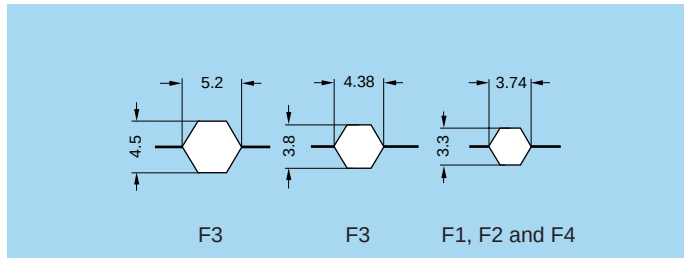
| Part number   | Contact type |
|---------------|--------------|
| DRV.91.CF2.PN | F2, F4       |

### Workstation Contents

| Part Number     | Description                              | Quantity | Number |
|-----------------|------------------------------------------|----------|--------|
| WST.BT.175.55PT | Plastic box                              | 1        | 1      |
| WST.BR.150.8AC  | Tweezers                                 | 1        | 2      |
| WST.CH.252.5SR  | Lint-free Cloth                          | 1        | 3      |
| WST.CS.125.CE   | Kevlar cutters                           | 1        | 4      |
| WST.CO.020.52   | Cotton bud (sachet of 20 pcs)            | 1        | 5      |
| WST.DS.290.PT   | Alcohol dispenser (supplied empty)       | 1        | 6      |
| DCC.91.312.5LA  | Extraction tool for F1 and F2 contacts   | 1        | 7      |
| DCS.91.G20.0C   | Microscope adapter for F2 and F4 cont.   | 1        | 8      |
| WST.ME.354.8R   | Epoxy mixer and pad                      | 1        | 9      |
| DOC.FO.CF2.0000 | Terminating instructions for F2 contacts | 1        | 10     |
| WST.OU.135.10SZ | Fibre scribe                             | 1        | 11     |
| DCS.91.F24.LC   | Polishing tool for F2 and F4 contacts    | 1        | 12     |
| WST.OU.452.5MN  | Large cable stripper                     | 1        | 13     |
| WST.PA.105.5525 | Cleaning tissues                         | 1        | 14     |
| WST.PA.012.AOJ  | Lapping film 12µm (yellow)               | 20       | 15     |
| WST.PA.005.AOM  | Lapping film 5µm (brown)                 | 20       | 16     |
| WST.PA.001.AOV  | Lapping film 1µm (green)                 | 20       | 17     |
| WST.PN.210.AS   | Armoured cable cutter                    | 1        | 18     |
| WST.PN.145.AR   | Cable cutter                             | 1        | 19     |
| WST.PN.103.0PG  | Outer jacket stripper                    | 1        | 20     |
| WST.PN.203.CR   | Buffer coating stripping tool            | 1        | 21     |
| WST.PN.102.3CR  | Primary coat stripper                    | 1        | 22     |
| DPE.99.524.337K | Crimp tool                               | 1        | 23     |
| WST.PL.322.5PT  | Polishing platform                       | 1        | 24     |
| WST.RE.353.EPO  | Epoxy resin + safety instructions        | 10       | 25     |
| WST.SE.305.8PH  | Syringe with needle                      | 10       | 26     |
| WST.TU.191.LN   | Fibre shield for F2 and F4 contacts      | 4        | 27     |
| WST.RG.150.AZ   | Steel rule 6"                            | 1        | 28     |
| WST.SY.135.PA   | Fibre length marking pen                 | 1        | 29     |
| WST.CS.155.AZ   | Scissors                                 | 1        | 30     |

**Note:** The interior of the case is fitted with pre-formed plastic foam to provide secure storage of the tools.





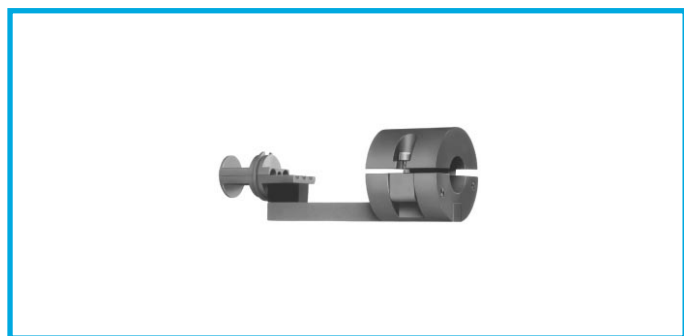
## DPE Crimping tool for fibre optic contact

### Description

Crimping tool for capturing KEVLAR® strand on contact body

| Part number                   | Contact type   |
|-------------------------------|----------------|
| DPE.99.524.337K <sup>1)</sup> | F1, F2, F3, F4 |

**Note:** <sup>1)</sup> Included in the LEMO F2 workstation.



## DCS Epoxy curing jig

### Description

Curing positioning jig specifically designed to ease assembly of the 3K.93C series with associated camera cable

| Part number    | Contact type |
|----------------|--------------|
| DCS.91.F12.3LA | F2           |



## WST Epoxy curing oven

### Description

Oven for assisting in curing epoxy

| Part number   | Voltage   | Contact type   |
|---------------|-----------|----------------|
| WST.FR.220.VA | 220 volts | F1, F2, F3, F4 |
| WST.FR.110.VA | 110 volts |                |



## DCS Polishing tool for fibre optic contacts

### Description

Precision spring loaded tool for polishing terminated fibre optic contacts.

| Part number                 | Contact type |
|-----------------------------|--------------|
| DCS.91.F13.LC               | F1, F3       |
| DCS.91.F24.LC <sup>1)</sup> | F2, F4       |

**Note:** <sup>1)</sup> Included in the LEMO F2 workstation.



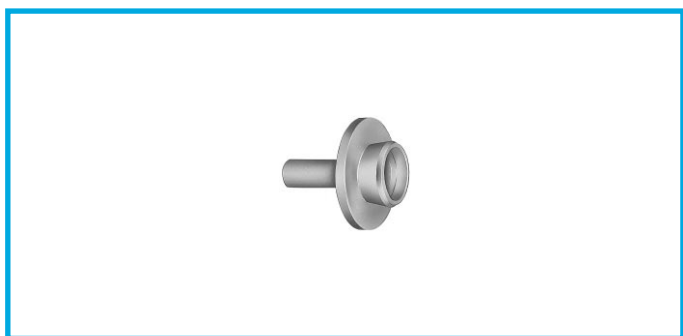


## WST Fibre Inspection Microscope

### Description

Microscope to assist in viewing termination operations and verifying fibre end finish.  
See adaptor below.

| Part number   | Contact type   |
|---------------|----------------|
| WST.FB.G10.4N | F1, F2, F3, F4 |



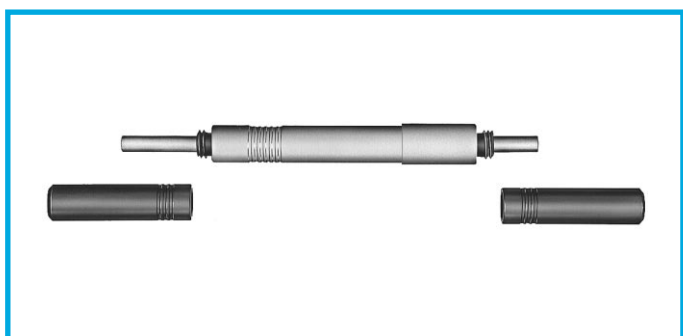
## DCS Microscope adaptor for fibre optic contacts

### Description

Adaptor for final inspection of fibre optic contacts.  
To be used with microscope WST.FB.G10.4N

| Part number                 | Contact type |
|-----------------------------|--------------|
| DCS.91.G24.0C               | F1, F3       |
| DCS.91.G20.0C <sup>1)</sup> | F2, F4       |

**Note:** <sup>1)</sup> Included in the LEMO F2 workstation.



## DCC Extractor for fibre optic contact

### Description

One side of the tool is the extractor for the F1 or F2 contact. The other threaded end is for installation/extraction of the F2 contact alignment device

| Part number                  | Contact type |
|------------------------------|--------------|
| DCC.91.312.5LA <sup>1)</sup> | F1, F2       |

**Note:** <sup>1)</sup> Included in the LEMO F2 workstation.

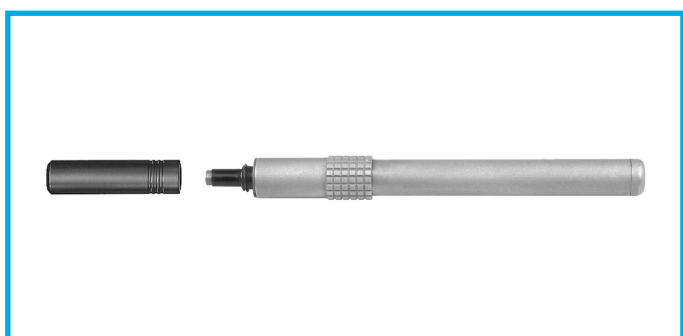


## DCS F2 contact alignment device installation/extraction tool

### Description

Simple tool with two threaded end for installation/extraction of the F2 contact alignment device

| Part number   | Contact type |
|---------------|--------------|
| DCS.F2.035.PN | F2           |



## DCC F4 contact alignment device extraction tool

### Description

This tool is for extraction/reinstallation of the F4 contact alignment device. It is necessary for contact cleaning only

| Part number    | Contact type |
|----------------|--------------|
| DCC.F4.125.7LA | F4           |



## DCS Cleaning tool

### Description

Used for maintenance cleaning. The tool is made with an alcohol spongy reservoir (supplied empty).  
16 dry cotton buds are included.

The threaded end allows extraction/reinstallation of the F2 contact alignment device.

| Part number   | Contact type |
|---------------|--------------|
| DCS.91.F23.LA | F2           |



## WST Cleaning kit

### Description

Kit that includes 2 cotton buds one of them moistened with alcohol

| Part number   | Contact type   |
|---------------|----------------|
| WST.KI.125.34 | F1, F2, F3, F4 |

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