



# ASSEMBLY TOOLS

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## CRIMPING TOOLS AND INSERTS FOR FLEXIBLE CABLES

small crimp tool with fixed inserts



H+S type	Item no.	Size	Colour code	Square-section (centre contact)	Hexagonal section (outer contact)
75_Z-0-3-4	22544613	2B	orange	1.6 mm / .063 in.	5.5 mm / .217 in.
75_Z-0-4-4	22544612	2C	yellow	1.6 mm / .063 in.	6.5 mm / .256 in.

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



Fig. 1



Fig. 2

H+S 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**



H+S type	Item no.	Size	Square-section (centre contact)	Hexagonal section (outer contact)
76_Z-0-1-1	23000884	0.54/A	0.54 mm / .021 in.	3.3 mm / .130 in.
76_Z-0-2-20	22645153	1/4.95	0.7 mm / .028 in.	4.95 mm / .195 in.
76_Z-0-2-51	22544756	1/2A	0.7/1.6 mm / .028/.063 in.	3.3 mm / .130 in.
76_Z-0-2-53	22645337	1/2.67	0.7 mm / .028 in.	2.7 mm / .106 in.
76_Z-0-3-51	22544757	2B	1.6 mm / .063 in.	5.5 mm / .217 in.
76_Z-0-4-51	22544758	2C	1.6 mm / .063 in.	6.5 mm / .256 in.

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



Fig. 1



Fig. 2

H+S 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 in wooden box (1/2A, 2B, 2C, 3D)	2

## TOOL BOXES



H+S type	Item no.	Description
76_Z-0-9	22644671	large tool box (empty)
76_Z-0-11	22543175	large tool box without tooling but including foam insert for tools and allen key

## table press with interchangeable inserts



H+S type	Item no.	Description
75_Z-0-2	22543158	press without inserts (for inserts see next page)

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**interchangeable inserts fitting large crimp tool  
and table press**



H+S 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 / .021 in.	3.30 mm / .130 in.
76_Z-0-2-1	22543181	1/2 A	red	0.7/1.6 mm / .028 / .063 in.	3.30 mm / .130 in.
76_Z-0-2-8	22544191	1/4.95		0.7 mm / .028 in.	4.95 mm / .195 in.
76_Z-0-3-1	22543185	2 B	orange	1.6 mm / .063 in.	5.50 mm / .217 in.
76_Z-0-3-9	22641133	B 1.22/1.22		1.2 mm / .047 in.	5.50 mm / .217 in.
76_Z-0-4-1	22543189	2 C	yellow	1.6 mm / .063 in.	6.50 mm / .256 in.
76_Z-0-4-8	22543190	C 1.22/1.22		1.2 mm / .047 in.	6.50 mm / .256 in.
76_Z-0-5-8	22543192	8/1.22/1.22		1.2 mm / .047 in.	8.00 mm / .315 in.
76_Z-0-5-21	22543193	2/8.0		1.6 mm / .063 in.	8.00 mm / .315 in.
76_Z-0-6-1	22649051	3/8.65		2.4 mm / .094 in.	8.65 mm / .341 in.
76_Z-0-6-21	22543194	2/9.75		1.6 mm / .063 in.	9.80 mm / .386 in.
76_Z-0-7-1	22543195	3 D	violet	2.4 mm / .094 in.	10.70 mm / .421 in.
76_Z-0-7-7	22543196	2 D		1.6 mm / .063 in.	10.70 mm / .421 in.
76_Z-0-7-8	22660322	2.5/D		2.5 mm / .098 in.	10.70 mm / .421 in.
76_Z-0-7-14	22544524	4 D		3.3 mm / .130 in.	10.70 mm / .421 in.
76_Z-0-10-14	23002630	12.4		–	12.40 mm / .488 in.
76_Z-0-0-26	22645880	1/2.67		0.7 mm / .028 in.	2.70 mm / .106 in.

**special inserts and tools for large crimp  
tool and table press**



H+S type	Item no.	Description
76_Z-0-0-1	22543170	cutting insert for cables up to 12 mm / 4.72 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

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## 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.



H+S type	Item no.	Series	Description
74_Z-0-70	22544725	SMA	includes all tools required for economic and reliable assembling of SMA connectors
74_Z-0-71	22641350	N	includes all tools required for assembling of N connectors to semi-rigid cables
74_Z-0-72	22544747	SMA	includes only the minimum of tools required for assembling of SMA connectors

## SELECTION OF COMMON AND HELPFUL ASSEMBLY TOOLS

H+S type	Item no.	W-no.	for series	Description	Tool set 74 Z-0-			
					70	71	72	
74_Z-0-10	22543120	W10		"Soldomat" soldering device for center contacts				
74_Z-0-14	22543124	W14	SMA	locator tools for contact and insulators	●		●	
74_Z-0-21	22543130	W21	SMA	torque wrench 1 Nm	●			
74_Z-0-24	22543133		SMA	tap drill for SMA (1/4-36 UNS-2B thread)				
74_Z-0-29	22543138	W29	N	dielectric insertion tool for insulators series N		●		

H+S type	Item no.	W-no.	for series	Description	Tool set 74 Z-0-			Image
					70	71	72	
74_Z-0-35	22544282	W35	N	soldering gauge 0.45 mm / .018 in.		●		
74_Z-0-52	22544553	W52	SMA	dielectric insertion tool for SMA-plugs	●		●	
74_Z-0-53	22544554	W53	SMA	dielectric insertion tool for SMA-jacks	●		●	
74_Z-0-54	22544555	W54	SMA	contact holder for pins and sockets	●		●	
74_Z-0-55	22544516	W55	SMA	soldering gauge 0.25 mm / .010 in.	●		●	
74_Z-0-56	22544517	W56	SMA	soldering gauge 0.4 mm / .016 in.	●		●	
74_Z-0-58	22544557	W58	BMA, SK, N SMA	soldering fixture (works with W374)	●	●	●	
74_Z-0-59	22544558	W59	BMA N SMA	inserts for EZ 141 (works with W58 and W442)	●	●	●	
74_Z-0-60	22544559	W60	BMA N SMA	inserts for EZ 86 (works with W58 and W442)	●	●	●	
74_Z-0-61	22544560	W61	SMA	locator tool (works with W58 and W442)				
74_Z-0-62	22544561	W62	SMA	locator tool for SMA-plugs without pin (works with W58 and W442)				
74_Z-0-63	22544562	W63	SMA	trim tool for SMA-plugs without pin	●			
74_Z-0-66	22544616	W66	N	locator tool (works with W58 and W442)			●	
74_Z-0-67	22544640	W67	N	contact holder for pins and sockets series N		●		

H+S type	Item no.	W-no.	for series	Description	Tool set 74 Z-0-0-			
					70	71	72	
74_Z-0-0-68	22544715	W68	BMA SK, N SMA	1 set of blades with protector	●	●	●	
74_Z-0-0-73	22544688	W73		adaptor				
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 jig for EZ 47, EZ 86, EZ 141, SUCOFORM 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	22645359 22645360 22645361			replacement support cover for EZ 47 EZ 86 EZ 141 (works with W 157)				
74_Z-0-0-207 74_Z-0-0-208	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)				

H+S type	Item no.	W-no.	for series	Description	Tool set 74 Z-0-0-			Image
					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)				

H+S type	Item no.	W-no.	for series	Description	Tool set 74 Z-0-			
					70	71	72	
74_Z-0-375	23022145	W375	BMA SK SMA N	soldering fixture for centre contacts (works with W374)				
74_Z-0-441	23024586	W441	BMA SK SMA N	collecting tank for coolant or flux (works with W374)				
74_Z-0-442	23024588	W442	BMA SK SMA N	soldering fixture (works with W374)				
74_Z-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 in- sulation EZ 141	●	●		
74_Z-0-3-4	22543150	W3-4	N	trim tool for EZ 141		●		

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## ASSEMBLY TOOLS FOR BMA CONNECTORS WITH HERMETIC SEAL

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

## ASSEMBLY TOOLS FOR SK CONNECTORS

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

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## SPANNERS

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H+S type	Item no.	Opening
74_Z-0-0-1	22543111	3/8"
74_Z-0-0-2	22543112	11.0 mm / .433 in.
74_Z-0-0-3	22543113	16.0 mm / .630 in.
74_Z-0-0-16	22543126	8.0 mm / .315 in.
74_Z-0-0-17	22644234	1/4" (6.35 mm / .250 in.)
74_Z-0-0-18	22543127	9.0 mm / .354 in.
74_Z-0-0-19	22543128	5.5 mm / .217 in.
74_Z-0-0-37	22543732	13.0 mm / .512 in.
74_Z-0-0-38	22543733	7.0 mm / .276 in.

## TORQUE WRENCHES



box-spanner



torque wrench (standard style)

H+S type	Item no.	for series	Torque	Opening	Notes
74_Z-0-0-21	22543130	SMA / PC 3.5	1.00 Nm	8.0 mm / .315 in.	standard style
74_Z-0-0-45	22544232	SMC	0.35 Nm	6.0 mm / .236 in.	standard style
74_Z-0-0-77	22544820	SMA	1.00 Nm	8.0 mm / .315 in.	box-spanner
74_Z-0-0-78	22641379	SMA economic	0.45 Nm	8.0 mm / .315 in.	box-spanner
74_Z-0-0-79	22642374	SMA economic	0.45 Nm	8.0 mm / .315 in.	standard style
74_Z-0-0-80	22544821	SMA hermetic	1.95 Nm	7.0 mm / .276 in.	standard style
74_Z-0-0-147	22644235	SMC	0.35 Nm	6.0 mm / .236 in.	box-spanner
74_Z-0-0-174	22643898	SK	1.30 Nm	8.0 mm / .315 in.	standard style
74_Z-0-0-189	22644368	SK hermetic	2.00 Nm	8.0 mm / .315 in.	standard style
74_Z-0-0-192	22645084	TNC	1.00 Nm	15.0 mm / .591 in.	standard style
74_Z-0-0-193	22645085	N	1.00 Nm	20.0 mm / .787 in.	standard style
74_Z-0-0-321	22651994	N	1.00 Nm	19.0 mm / .748 in.	standard style
74_Z-0-0-373	23021864	TNC	1.00 Nm	14.0 mm / .551 in.	standard style

## COMBINATION TOOL FOR MMBX/MMCX/MCX-RIGHT ANGLE CONNECTORS

for protective cap mounting and decoupling



H+S 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-0-0-276	22648710	decoupling tool for bulkhead jacks (MCX 75 Ω)
74_Z-0-0-350	23004135	removal tool (16_MMCX)

## SPECIAL TOOLS FOR QMA CONNECTORS

decoupling tool for high density applications



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

assembly tool



H+S 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)

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## SPECIAL TOOLS FOR QN CONNECTORS

### decoupling tool



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

### locator tool



H+S 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)

### locator tool



H+S 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)

### decoupling tool for MMPX



H+S 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	MMPX	distance washers (for replacement)

## TAP DRILL



H+S type	Item no.	Thread
74_Z-0-0-24	22543133	1/4-36 UNS-2B
74_Z-0-0-82	22643835	3/8-32 UNEF-2B
74_Z-0-0-229	22646139	1/4-36 UNS (for blind hole threads)
74_Z-0-0-236	22646069	2-56 UNC
74_Z-0-0-237	22646070	10-56 UNS
74_Z-0-0-238	22646071	5/8-24 UNEF

## VARIOUS TOOLS



H+S 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-0-0-25	22543134	face spanner for fastening nut (22 + 24 QLA)
74_Z-0-0-89	22644721	screw driver for female centre contacts (Series 7/16)
74_Z-0-0-115	22642492	syringe for casting compound
74_Z-0-0-116	22642493	casting compound (resin 6.75 cm <sup>3</sup> and accelerator 3.0 cm <sup>3</sup> ), 2 containers
74_Z-0-0-177	22644541	cover insertion tool for 16 SMB/C/S connectors

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## TOOLS FOR HUBER+SUHNER QUICK-FIT® CONNECTORS

cable stripping tools for easy cable preparation  
in one single operation  
(can be used manually or with electrical power tool)



H+S type	Item no.	Cable type	Assembly instructions
74_Z-0-8-15	23000296	3/8": Andrew LDF 2-50	0000180713
74_Z-0-9-15	23001006	1/2" Highflex: SUCOFEED®, Andrew, NK cables, RFS (Kabelmetal)	0000179418/ 0000201603
74_Z-0-12-15	23000319	1/2": SUCOFEED®, Andrew, NK cables, RFS (Kabelmetal)	0000179113
74_Z-0-23-16	23007928	7/8": SUCOFEED®, Andrew, NK cables, RFS (Kabelmetal) 7/8" Highflex: SUCOFEED®, Andrew	0000180164/ 0000201645 0000233737
74_Z-0-23-17	84017918	7/8" Low attenuation: SUCOFEED®, Andrew	0000243692/0000236366
74_Z-0-32-14	23010533	1 1/4": SUCOFEED®, Andrew, NK cables, RFS (Kabelmetal)	0000179128
74_Z-0-42-14	23010534	1 5/8": SUCOFEED®, Andrew, NK cables, RFS (Kabelmetal)	0000179128

## HUBER+SUHNER® QUICK-FIT installation kit

Tool kit for all QUICK-FIT Connectors  
(with additional space for other auxiliary tools and spare parts)

Stripping tools can be accommodated but are not included



H+S type	Item no.	Description	Content	Size
74_Z-0-0-600	23002174	tool box	all tools of the following table marked with *	620 × 430 × 140 mm/ 24.4 × 17 × 1.5 in.

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## Overview necessary tools for the assembly of QUICK-FIT connectors

H+S type	Item no.	Part description	Corrugated copper tube cables							1 1/4"	1 5/8"
			3/8" LFD 2-50	1/2" HF	1/2"	7/8"	7/8" HF	7/8" LA			
74_Z-0-8-15	23000296	stripping tool (3/8" LFD 2-50)	X								
74_Z-0-9-15	23001006	stripping tool (1/2" HF)		X							
74_Z-0-12-15	23000319	stripping tool (1/2")			X						
74_Z-0-23-16	23007928	stripping tool (7/8" + 7/8" HF)				optional	optional				
74_Z-0-23-17	84017918	stripping tool (7/8" LA)						optional			
74_Z-0-32-14	23010533	stripping tool (1 1/4")							optional		
74_Z-0-42-14	23010534	stripping tool (1 5/8")								optional	
74_Z-0-0-359	23014976	handle (for stripping tools)	X <sup>4)</sup>	X <sup>4)</sup>	X <sup>4)</sup>	optional	optional	optional	optional	optional	optional
74_Z-0-0-402	22652193	* abrasive paper 320	X	X	X						
74_Z-0-0-424	23001952	* spanner AF 17 mm	X								
74_Z-0-0-425	23001953	* spanner AF 18 mm	X								
74_Z-0-0-426	23001954	* spanner AF 19 mm	X								
74_Z-0-0-427	23001955	* spanner AF 21 mm	X	X							
74_Z-0-0-428	23001956	* spanner AF 22 mm		X	X						
74_Z-0-0-429	23001957	* spanner AF 24 mm			X						
74_Z-0-0-430	23001958	* spanner AF 30 mm				X	X	X			
74_Z-0-0-431	23001959	* spanner AF 36 mm				X	X	X			
74_Z-0-0-415	22652206	* counter sink				X <sup>1)</sup>					
74_Z-0-0-418	22652209	* Stanley knife	X	X	X	X	X	X	X	X	X
74_Z-0-0-420	22652211	* steel brush			X	X	X	X	X	X	X
74_Z-0-0-422	22652213	* steel measure 200 mm	X <sup>2)</sup>	X <sup>2)</sup>	X <sup>2)</sup>	X <sup>2)</sup>	X <sup>2)</sup>	X <sup>2)</sup>	X <sup>2)</sup>	X <sup>2)</sup>	X <sup>2)</sup>
74_Z-0-0-432	23002005	* screw driver (2)	X		X						
74_Z-0-0-433	23002007	* screw driver (4)				X	X	X	X	X	X
74_Z-0-0-12	22642718	small metal saw	X	X	X	X	X	X	X	X	X
74_Z-0-0-434	23002166	monkey wrench <sup>3)</sup> (min.65mm)							X	X	
		small file	X <sup>2)</sup>	X <sup>2)</sup>	X <sup>2)</sup>						

\* = tools included in the HUBER+SUHNER QUICK-FIT installation kit 74\_Z-0-0-600, (can be ordered with item no. 23002174)

- 1) for assembly use either the Stanley knife or the counter sink
- 2) only necessary without HUBER+SUHNER stripping tool
- 3) 2 wrenches are needed for assembling
- 4) handle included in QUICK-FIT stripping tool delivery

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## Spare parts for QUICK-FIT cable stripping tools



H+S type	Item no.	Description	Application	Function
74_Z-0-346	23000936	blade	74_Z-0-8-15 74_Z-0-8-16 74_Z-0-9-15 74_Z-0-12-15	stripping jacket
74_Z-0-347	23000937	blade	74_Z-0-8-15 74_Z-0-8-16 74_Z-0-12-15	cutting corrugated copper tube
74_Z-0-348	23000938	triangle knife	74_Z-0-8-15 74_Z-0-8-16 74_Z-0-9-15 74_Z-0-12-15	deburring inner conductor
74_Z-0-349	23001008	blade	74_Z-0-9-15	cutting corrugated copper tube
74_Z-0-297	22650531	blade	74_Z-0-23-16 74_Z-0-23-17	cutting corrugated copper, foam and inner conductor
74_Z-0-355	23008264	blade	74_Z-0-23-16 74_Z-0-32-14 74_Z-0-32-17	stripping jacket
74_Z-0-356	23010537	blade	74_Z-0-42-14	stripping jacket

## Additional tools for HUBER+SUHNER® QUICK-FIT cable stripping tools

H+S type	Item no.	Tool description	Function
74_Z-0-416	22652207	* allen wrench AF 2.5 mm/.098 in.	spare blades for the stripping tools 74_Z-0-8-15, 74_Z-0-8-16, 74_Z-0-9-15, 74_Z-0-12-15, 74_Z-0-23-16, 74_Z-0-23-17, 74_Z-0-32-14 and 74_Z-0-42-14
74_Z-0-423	23000311	* allen wrench AF 4 mm/.157 in.	for removing the BIT adaptor
74_Z-0-421	22652212	* screwdriver, Torx 1 (Torx T7)	for changing the triangle knife 74_Z-0-348

\* = not included in the HUBER+SUHNER QUICK-FIT installation kit 74\_Z-0-600

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