

RATIONALE

AS22520/19 PERMITS THE CANCELLATION AND SUPERSESSION OF MIL-C-22520 /19 WITH THIS DOCUMENT. IT INCLUDES ENGINEERING POSITION LETTERS, MILITARY SPECIFICATION AMENDMENTS, AND MINOR TECHNICAL CHANGES REQUIRED TO REFLECT THE APPROVED QUALIFIED TOOLS. QUALIFICATION WAS REMOVED DUE TO LOW USAGE. GOVERNMENT DOCUMENTATION REFERENCES ARE REMOVED AND INDEX ADDED AS TABLE 1.

NOTICE

THE COMPLETE REQUIREMENTS FOR PROCURING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF AS22520.

AS22520/19

TABLE 1 - M22520/19 POSITIONER-CONTACT ACCOMMODATION INFORMATION

POSITIONER PART NUMBER M22520/19	AS39029 OUTER CONTACT APPLICATION (M39029/XX-YYY)		POSITIONER INFORMATION (SHEET NO.)
-02	/19-181	OUTER PIN	4
-03	/21-187	OUTER SOCKET (SHORT)	
-04	/20-184	OUTER SOCKET (LONG)	

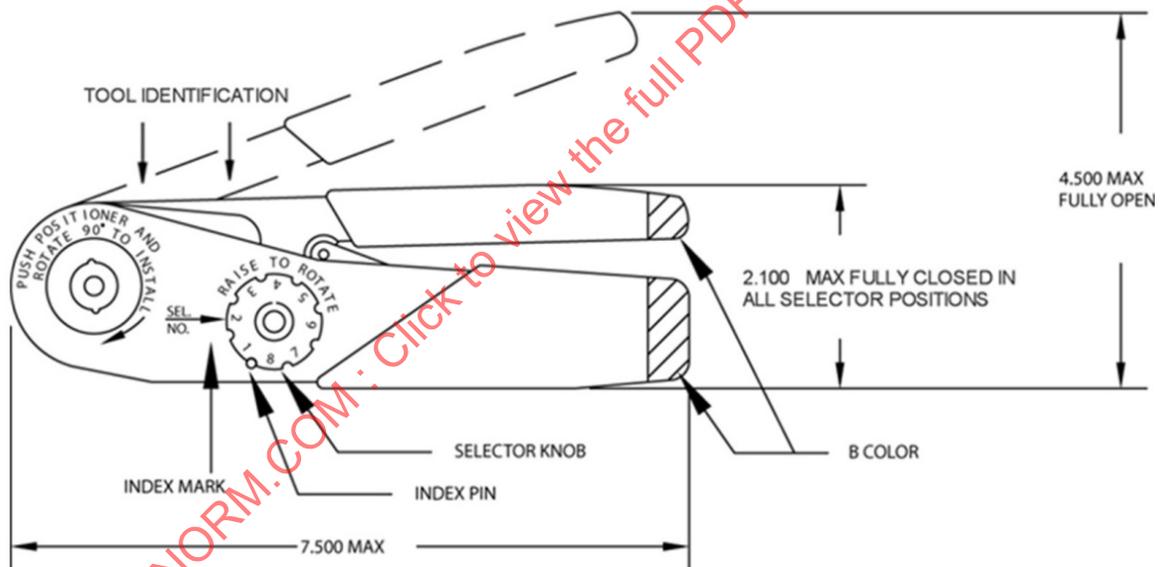
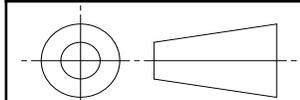


FIGURE 1 - M22520/19-01 TOOL

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THIRD ANGLE PROJECTION



CUSTODIAN: AE-8/AE-8C2

PROCUREMENT SPECIFICATION: AS22520

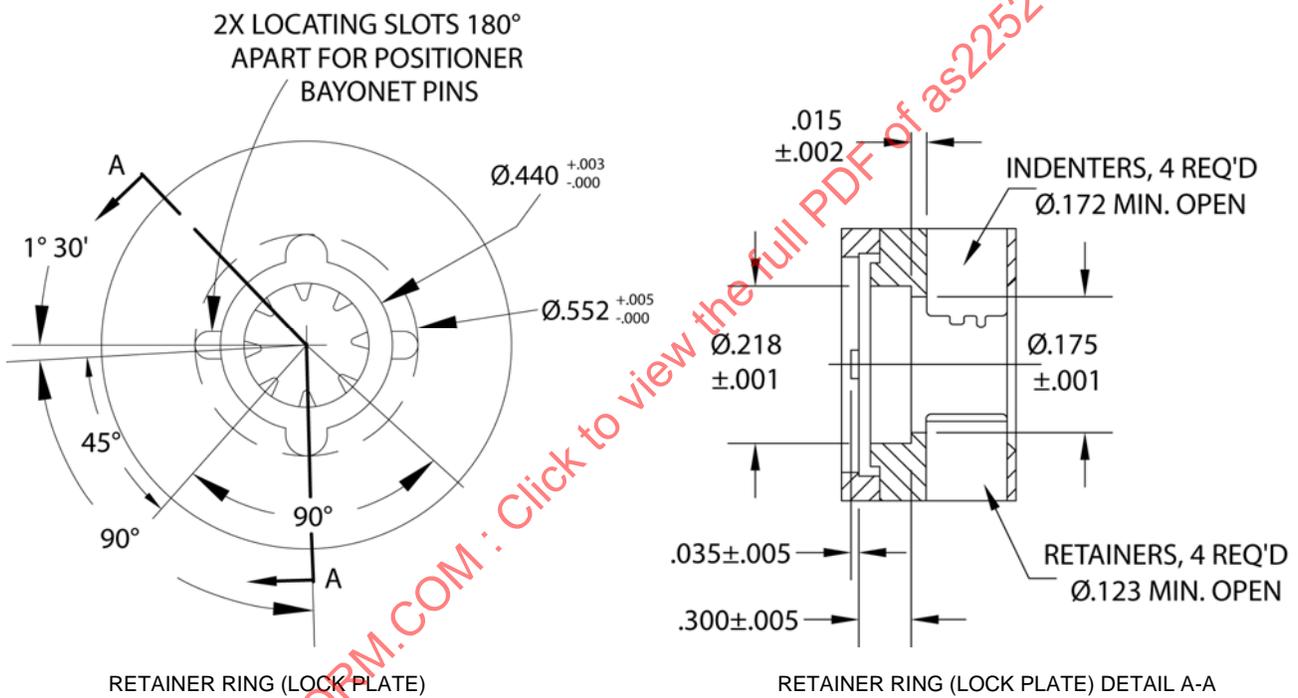
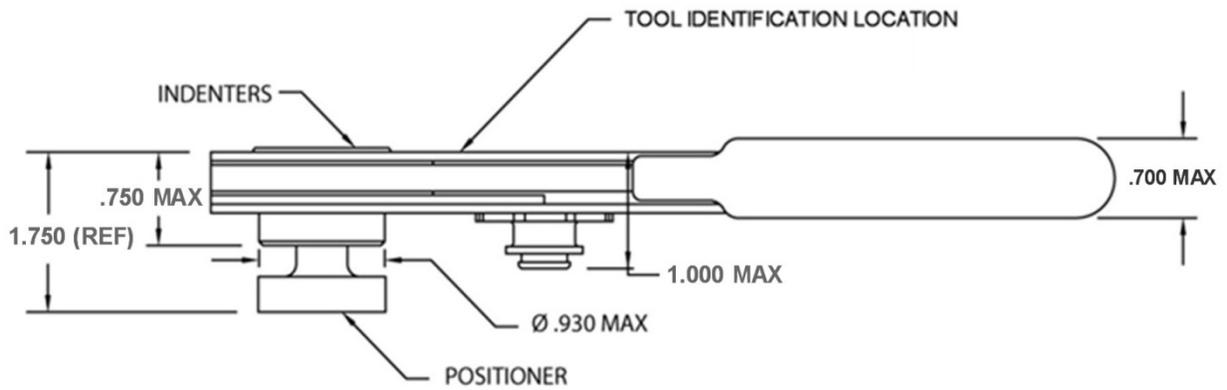


AEROSPACE STANDARD

CRIMPING TOOL, TYPE 2, TERMINAL, HAND, WIRE TERMINATION FOR SIZE 16 SHIELDED CONTACTS (OUTER CONTACT)

AS22520/19
SHEET 1 OF 7

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TOOL POSITIONER LOCATOR

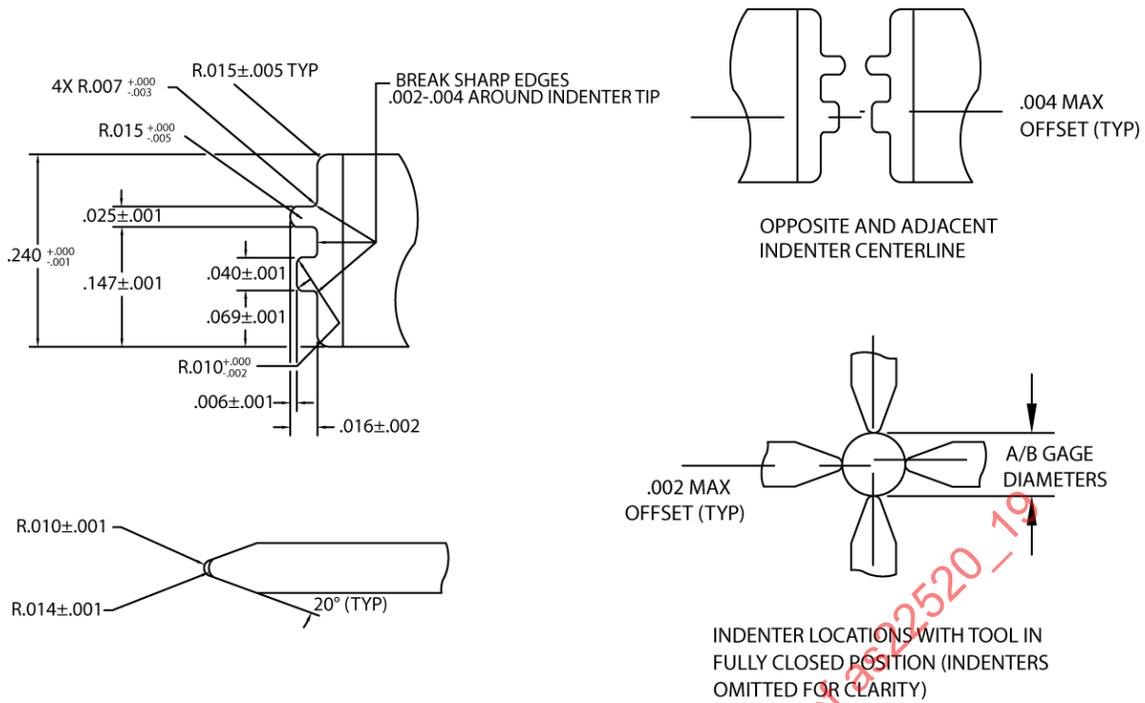
FIGURE 1 - M22520/19-01 TOOL (CONTINUED)



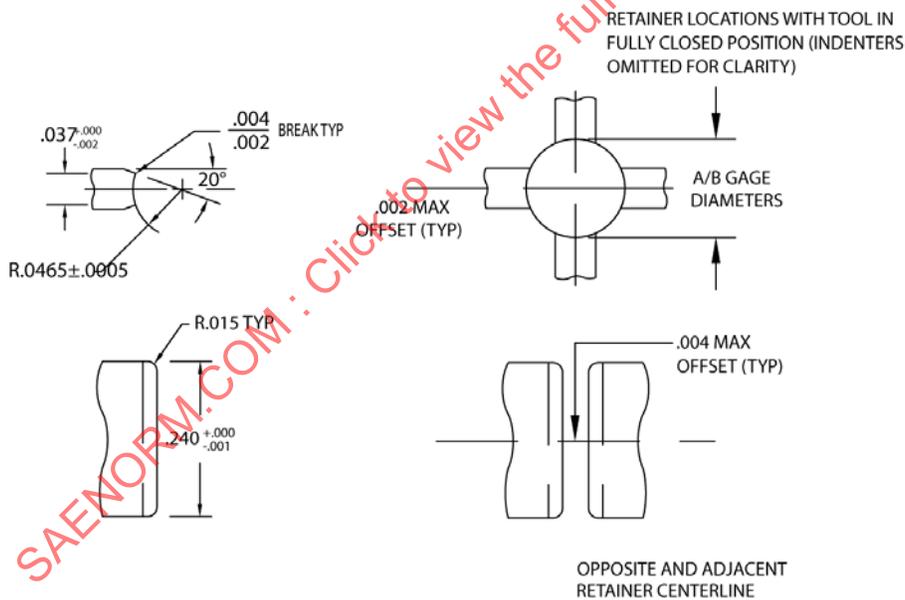
AEROSPACE STANDARD

CRIMPING TOOL, TYPE 2, TERMINAL, HAND, WIRE TERMINATION FOR SIZE 16 SHIELDED CONTACTS (OUTER CONTACT)

AS22520/19
SHEET 2 OF 7



TOOL INDENTERS



TOOL RETAINER

FIGURE 1 - M22520/19-01 TOOL (CONTINUED)

	AEROSPACE STANDARD	AS22520/19 SHEET 3 OF 7
	CRIMPING TOOL, TYPE 2, TERMINAL, HAND, WIRE TERMINATION FOR SIZE 16 SHIELDED CONTACTS (OUTER CONTACT)	

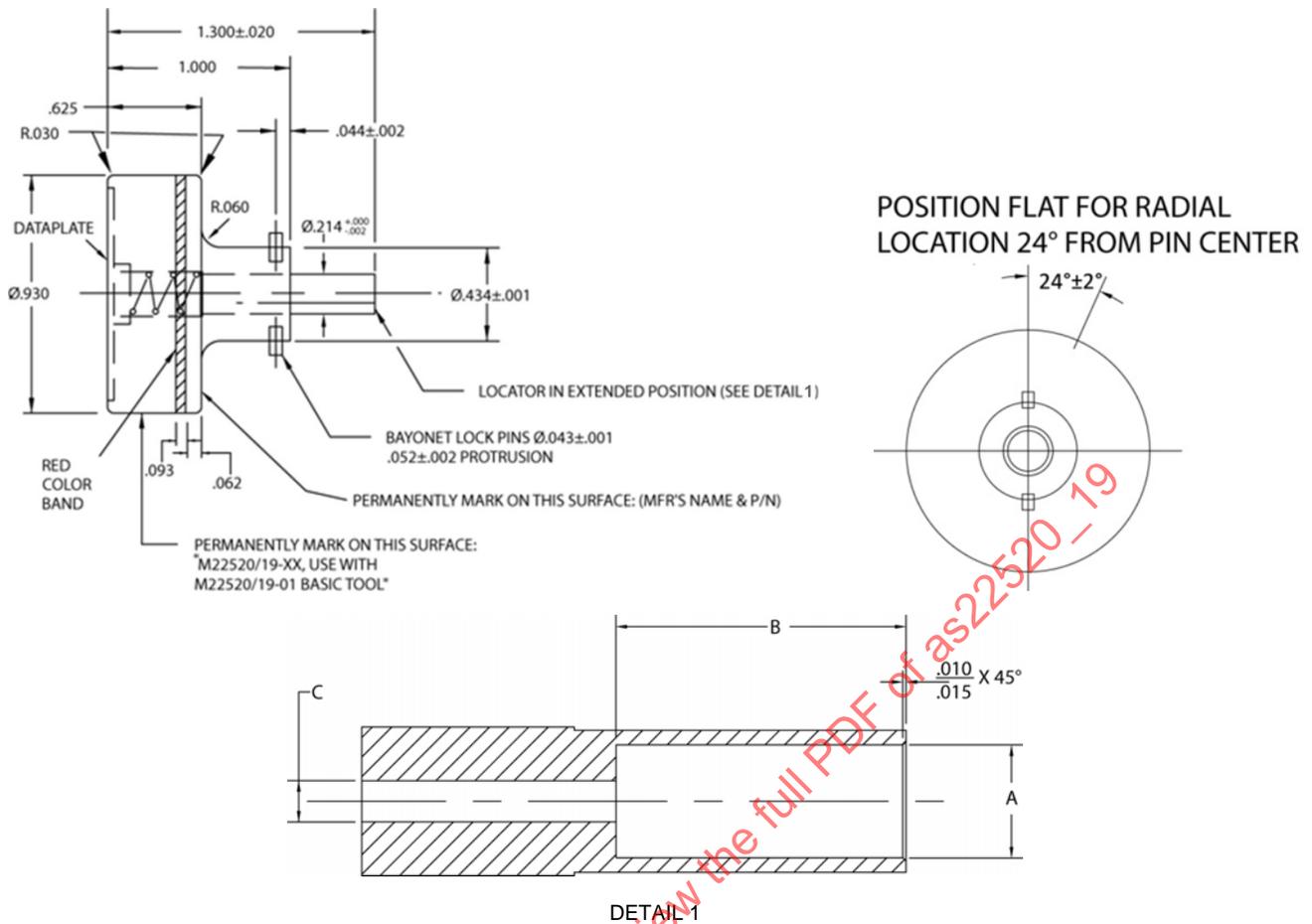
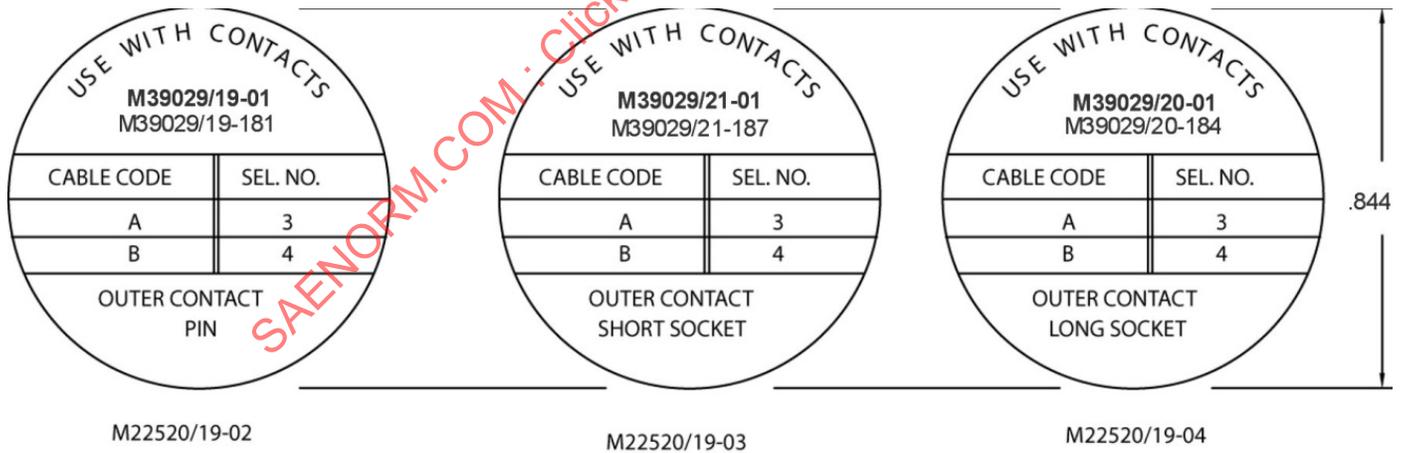
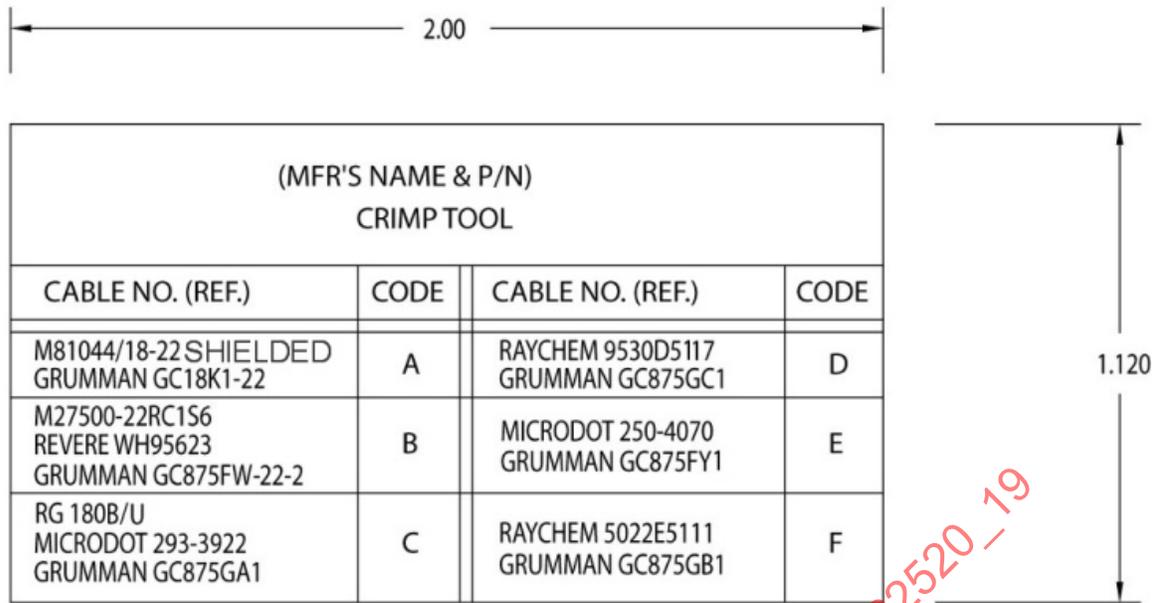


FIGURE 2 - M22520/19 POSITIONER CONSTRUCTION



M22520/19-02 THRU -04 POSITIONER DATA PLATES

FIGURE 3 - DATA PLATE MARKING REQUIREMENTS (SEE APPLICATION NOTE)



M22520/19-01 TOOL DATA PLATE (SEE APPLICATION NOTE)

FIGURE 3 - DATA PLATE MARKING REQUIREMENTS (CONTINUED)

TABLE 2 - BASIC TOOL MARKINGS

PART NO.	BODY COLOR	HANDLE GRIP COLOR	HANDLE GRIP B COLOR	FOR INSPECTION GAGING USE	
				INDENTER	RETAINER
M22520/19-01	BLUE	GREEN	RED	M22520/3-4 ^{1/}	M22520-3-5 ^{2/}

- ^{1/} INSPECTION GAGE ONLY APPLICABLE FOR THE TOOL SET AT SELECTOR POSITION NUMBER 7 (SEE APPLICATION NOTES).
^{2/} INSPECTION GAGE ONLY APPLICABLE FOR THE TOOL SET AT SELECTOR POSITION NUMBER 8 (SEE APPLICATION NOTES).

TABLE 3 - INDENTER GAGE LIMITS

SELECTOR NUMBER	INSPECTION GAGE DIAMETERS (INCHES) ^{1/}	
	Ø GO A ± .0001	Ø NO-GO B ± .0001
1	.0430	.0460
2	.0460	.0490
3	.0490	.0520
4	.0520	.0550
5	.0560	.0590
6	.0600	.0630
7	.0640	.0670
8	.0690	.0720

^{1/} SEE FIGURE 1 TOOL INDENTER AND RETAINER.