

AS22520/22

RATIONALE

AS22520/22 PERMITS THE CANCELLATION AND SUPERSESION OF MIL-C-22520 /22 WITH THIS DOCUMENT. IT INCLUDES ENGINEERING POSITION LETTERS, MILITARY SPECIFICATION AMENDMENTS, AND MINOR TECHNICAL CHANGES REQUIRED TO REFLECT THE APPROVED QUALIFIED TOOLS. 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.

TABLE 1 - M22520/22 POSITIONER-CONTACT ACCOMMODATION INFORMATION

POSITIONER PART NUMBER M22520/20	AS39029 OUTER CONTACT APPLICATION (M39029/XX-YYY)	POSITIONER INFORMATION (SHEET NO.)
-02	/19-182, /19-183 /21-188, /22-189	SHIELD CRIMP SLEEVE 4
-03	/20-185, /21-186	

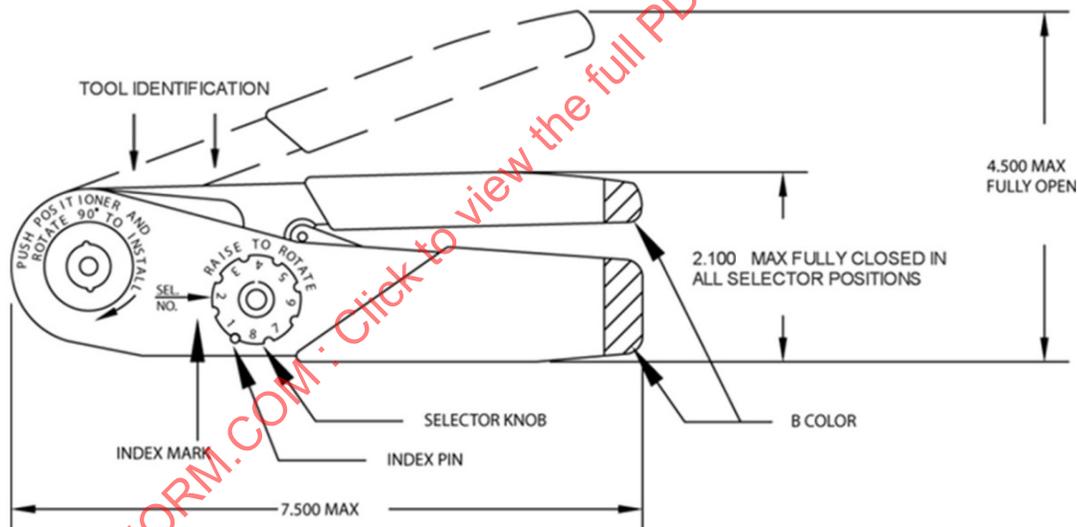
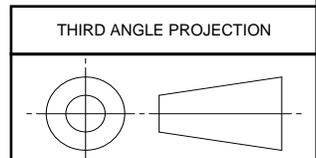


FIGURE 1 - M22520/22-01 TOOL

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CUSTODIAN: AE-8/AE-8C2

PROCUREMENT SPECIFICATION: AS22520



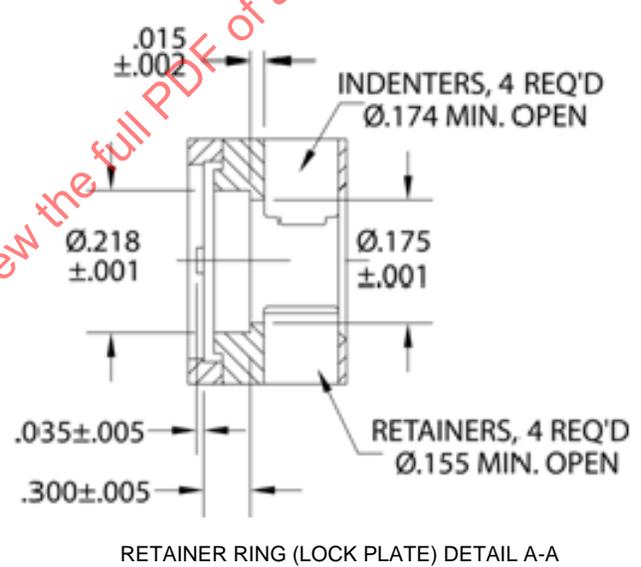
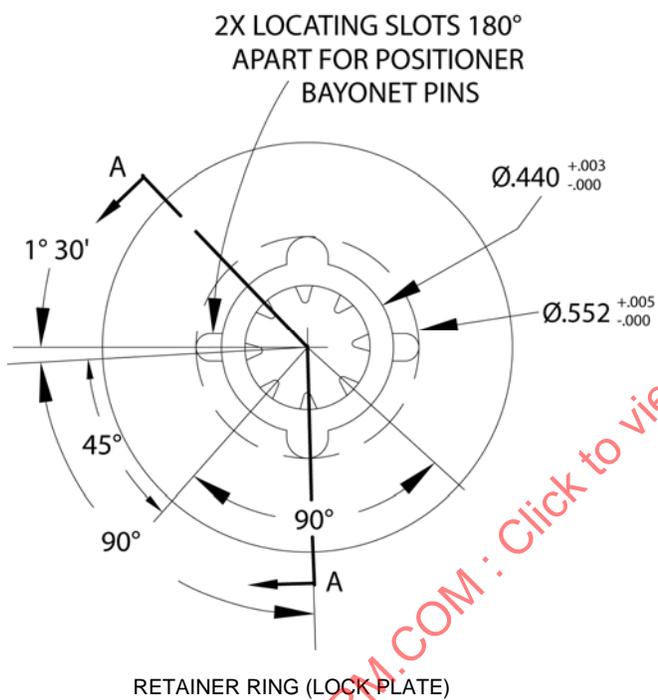
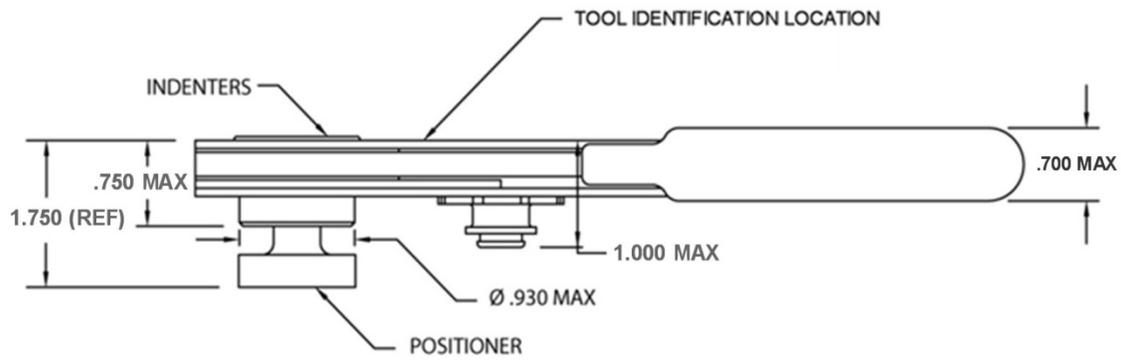
AEROSPACE STANDARD

CRIMPING TOOL, TYPE 2, TERMINAL, HAND, WIRE TERMINATION FOR SIZE 12 SHIELDED CONTACTS (SHIELD CRIMP SLEEVE)

AS22520/22
SHEET 1 OF 7

ISSUED 2014-05

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TOOL POSITIONER LOCATOR

FIGURE 1 - M22520/22-01 TOOL (CONTINUED)

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	AEROSPACE STANDARD	AS22520/22 SHEET 2 OF 7
	CRIMPING TOOL, TYPE 2, TERMINAL, HAND, WIRE TERMINATION FOR SIZE 12 SHIELDED CONTACTS (SHIELD CRIMP SLEEVE)	

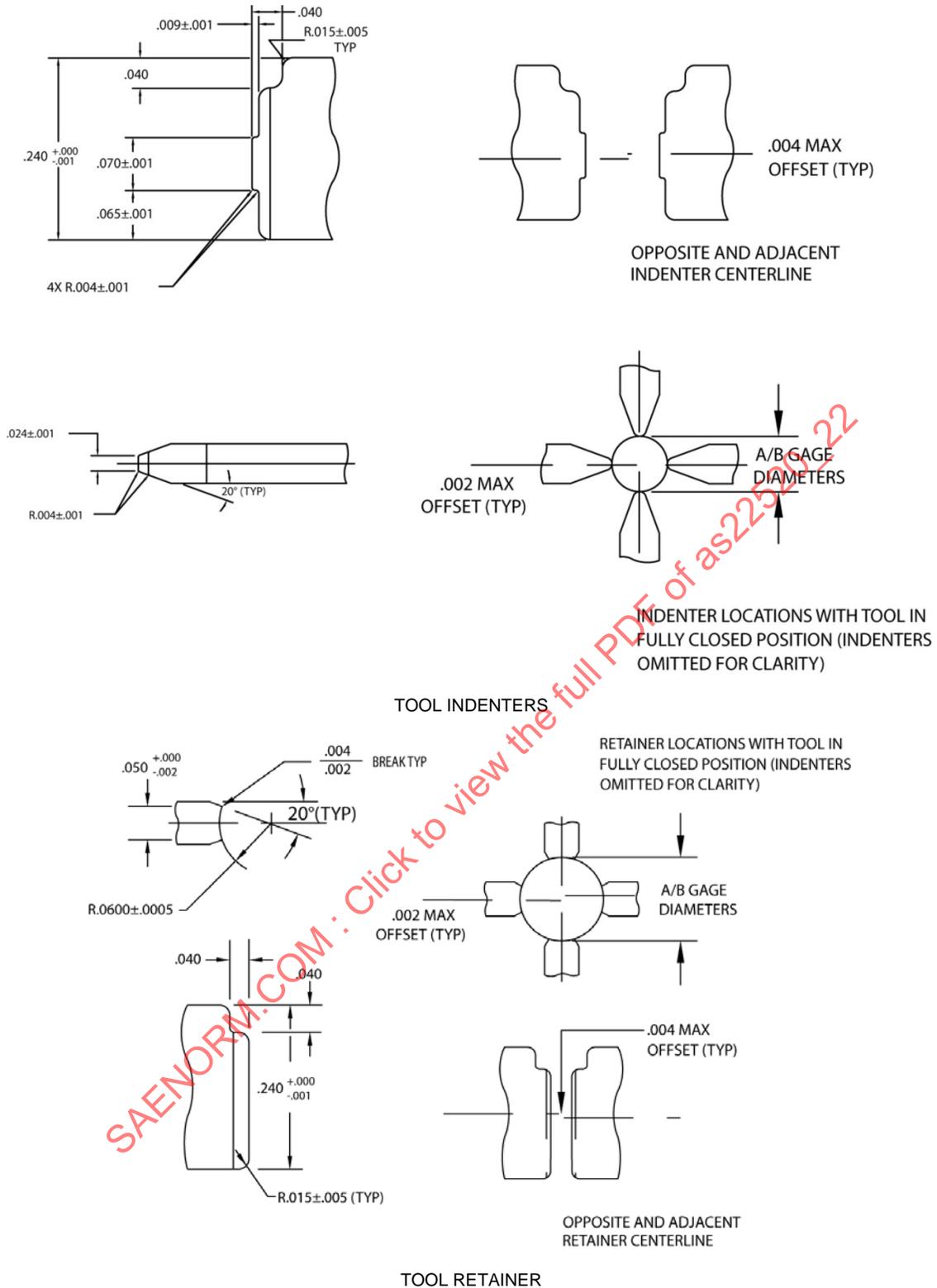


FIGURE 1 - M22520/22-01 TOOL (CONTINUED)

	AEROSPACE STANDARD	AS22520/22 SHEET 3 OF 7
	CRIMPING TOOL, TYPE 2, TERMINAL, HAND, WIRE TERMINATION FOR SIZE 12 SHIELDED CONTACTS (SHIELD CRIMP SLEEVE)	

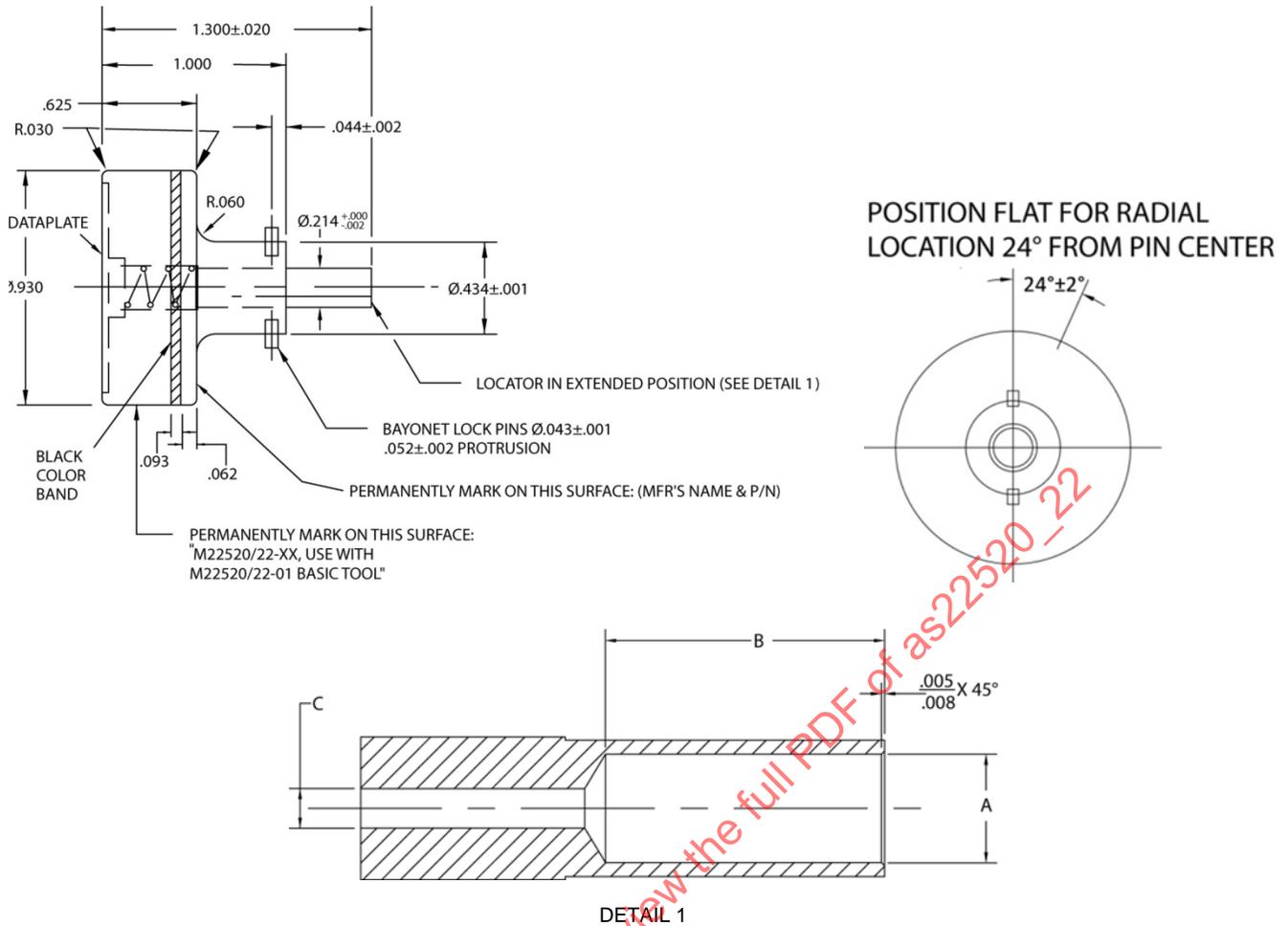
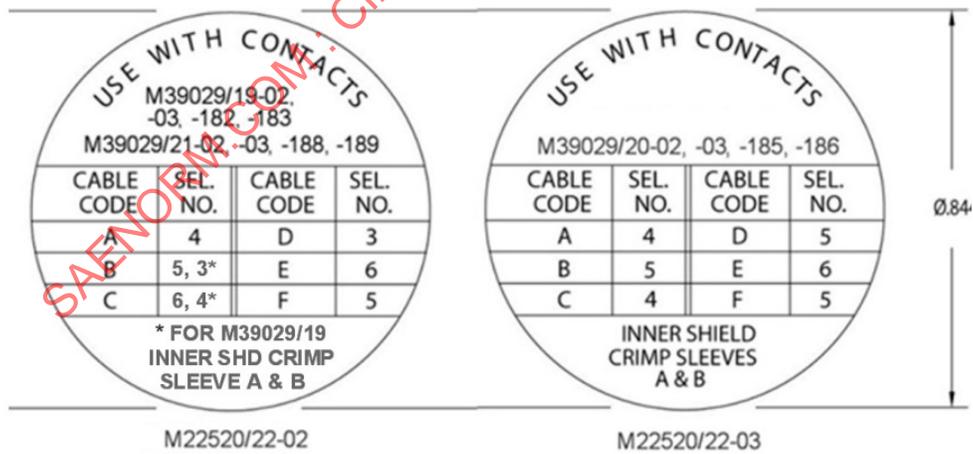
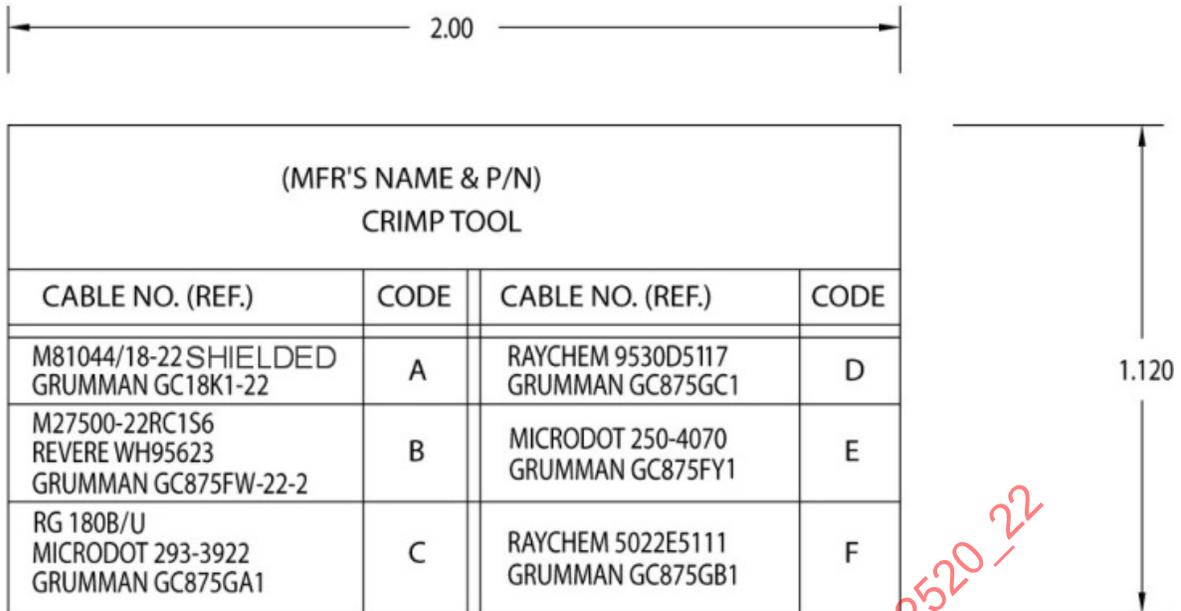


FIGURE 2 - M22520/22 POSITIONER CONSTRUCTION



M22520/22-02 AND -04 POSITIONER DATA PLATES

FIGURE 3 - DATA PLATE MARKING REQUIREMENTS



M22520/22-01 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
M22520/22-01	BLUE	GREEN	BLACK	M22520/3-4 1/	M22520-3-8 2/

- 1/ INSPECTION GAGE ONLY APPLICABLE FOR THE TOOL SET AT SELECTOR POSITION NUMBER 1 (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	.0640	.0670
2	.0670	.0700
3	.0700	.0730
4	.0730	.0760
5	.0770	.0800
6	.0810	.0840
7	.0850	.0880
8	.0900	.0930

1/ SEE FIGURE 1 TOOL INDENTER AND RETAINER.

TABLE 4 - RETAINER GAGE LIMITS

SELECTOR NUMBER	INSPECTION GAGE DIAMETERS (INCHES)	
	Ø GO A ± .0001	Ø NO-GO B ± .0001
8	.1210	.1240