

REV. B

AS22520™/2

FEDERAL SUPPLY CLASS  
5120

RATIONALE

REVISION REQUIRED TO ADD NEW CONTACTS TO VARIOUS DATA PLATES AND PERFORM MINOR TECHNICAL OR EDITORIAL CHANGES AS NEEDED.

NOTICE

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

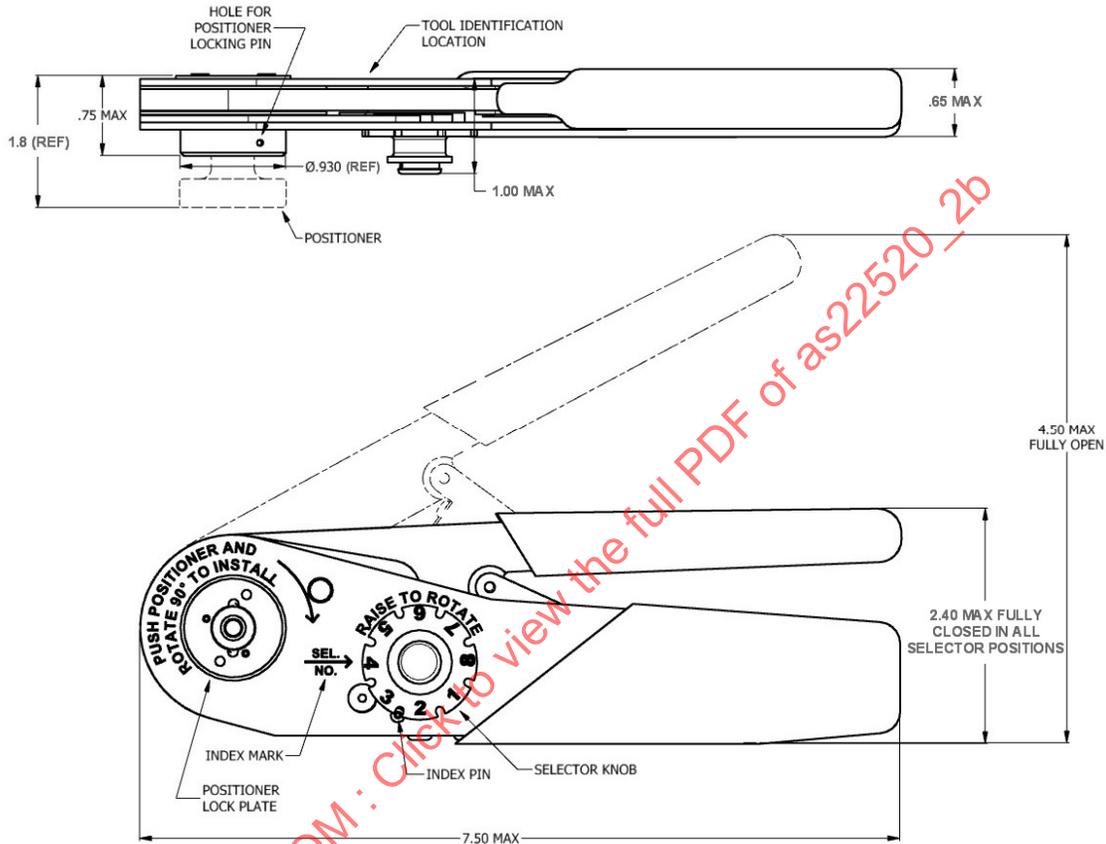
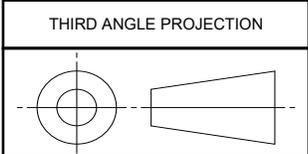


FIGURE 1 - M22520/2-01 TOOL

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CUSTODIAN: AE-8C2

PROCUREMENT SPECIFICATION: AS22520



**AEROSPACE STANDARD**

CRIMPING TOOLS, TYPE 1, TERMINAL, HAND,  
WIRE TERMINATION FOR WIRE BARREL  
SIZES 20 THROUGH 28

AS22520™/2  
SHEET 1 OF 49

REV. B

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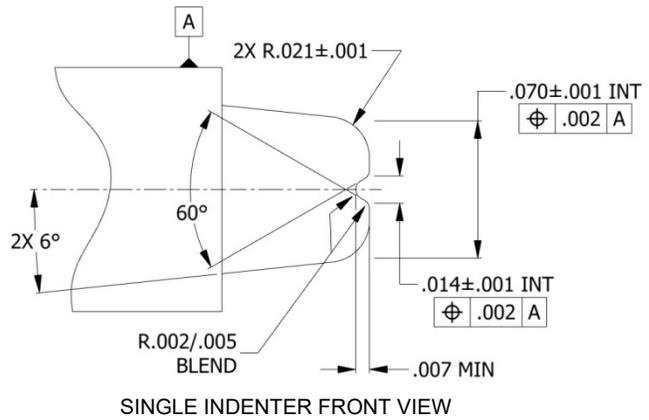
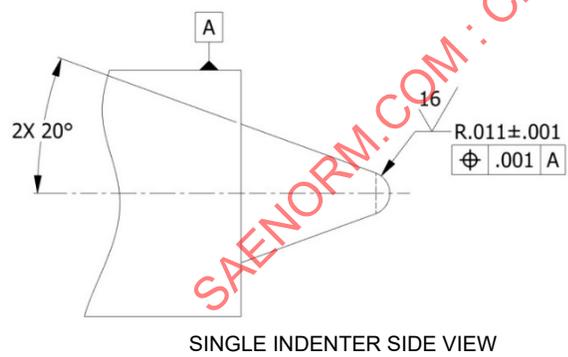
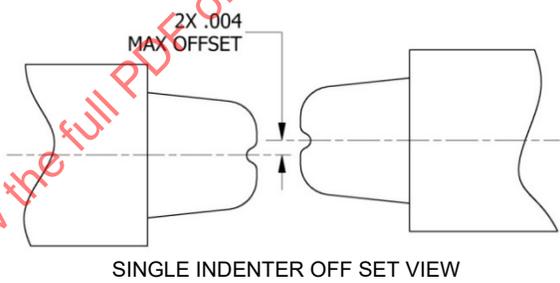
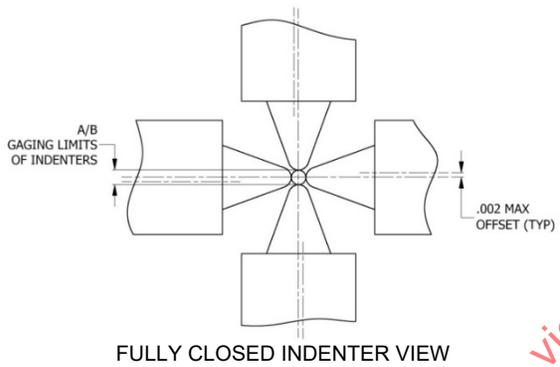
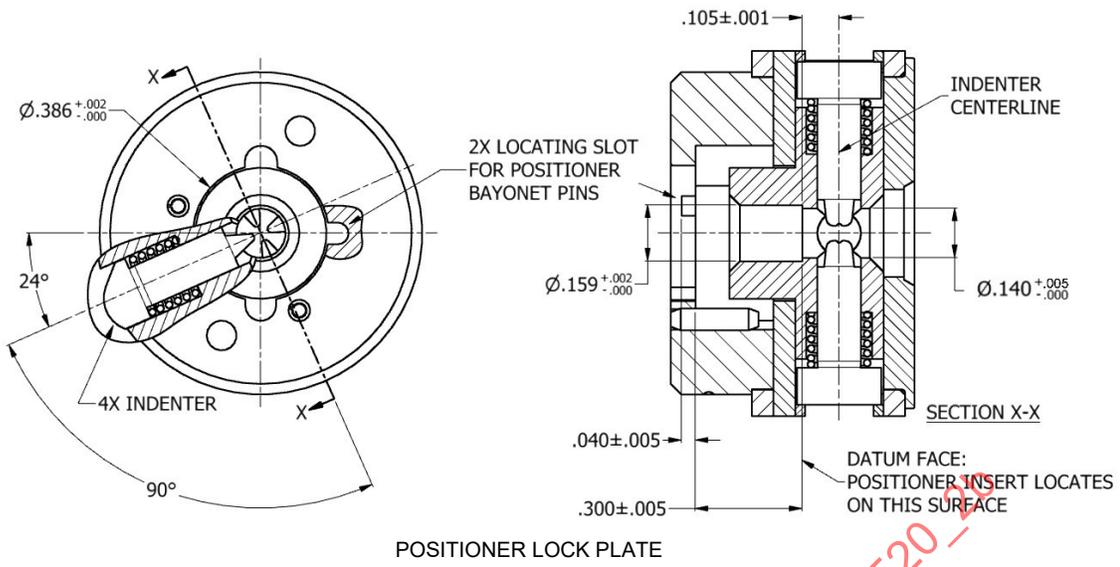


FIGURE 1 (CONTINUED) - M22520/2-01 TOOL

	<b>AEROSPACE STANDARD</b> CRIMPING TOOLS, TYPE 1, TERMINAL, HAND, WIRE TERMINATION FOR WIRE BARREL SIZES 20 THROUGH 28	<b>AS22520™/2</b> SHEET 2 OF 49	<b>REV.</b> <b>B</b>

**BASIC TOOL MARKINGS**

PART NO.	BODY COLOR	HANDLE COLOR (2)	FOR INSPECTION GAGING USE
M22520/2-01	BLUE	BLUE	M22520/3-1 1/

1/ SEE APPLICATION NOTES.

**INDENTER GAGE LIMITS**

GAGING LIMITS OF INDENTERS			
SELECTOR NUMBER	INSPECTION GAGE (INCHES)		
	Ø GO	A + .0001	Ø NO-GO B + .0001
1	.0130		.0180
2	.0160		.0210
3	.0190		.0240
4	.0220		.0270
5	.0260		.0310
6	.0300		.0350
7	.0340		.0390
8	.0390		.0440

**FIGURE 1 (CONTINUED) - M22520/2-01 TOOL**

REQUIREMENTS: ALL REQUIREMENTS SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF AS22520.

1. DIMENSIONS:

UNLESS OTHERWISE SPECIFIED, DIMENSIONS SHALL BE IN INCHES, TOLERANCES (DECIMALS ±.010, ANGLES ±1/2°). OUTLINE CONFIGURATION OPTIONAL WITHIN MAXIMUM DIMENSIONS SHOWN. BREAK ALL SHARP EDGES .005 R MAX. THE TERM "POSITIONER" AND "LOCATOR" USED IN THIS DOCUMENT REFERS TO THE CONTACT HOLDER (ACCESSORY TO THE CRIMP TOOL). THERE IS NO DIFFERENCE IN THEIR MEANING.

2. TOOL MARKING:

TOOL IDENTIFICATION (SEE FIGURE 1) SHALL BE IN ACCORDANCE WITH MIL-STD-130, STAMP AND WHITE FILL OR LASER MARKED. UNLESS OTHERWISE SPECIFIED, THE STAMPED MARKING HEIGHT IS .093 MINIMUM. TOOL IDENTIFICATION SHALL INCLUDE THE SAE M22520/2-01 PART NUMBER AND MANUFACTURER'S IDENTIFICATION OR SYMBOL. IF A SYMBOL IS USED ON THE TOOL FRAME, IT SHALL BE IN ACCORDANCE WITH AIR1351.

3. POSITIONER MARKING:

POSITIONERS SHALL BE MARKED AS SHOWN IN FIGURES 2 THROUGH 41. MARKING SHALL BE IN ACCORDANCE WITH MIL-STD-130, STAMP (LETTERING HEIGHT IS .093 MINIMUM AND WHITE FILL) OR LASER MARKED. POSITIONER COLOR SHALL BE BLUE. IF A SYMBOL IS USED ON THE POSITIONER, IT SHALL BE IN ACCORDANCE WITH AIR1351. OTHER LABEL INFORMATION IS PERMITTED.

4. DATA PLATE MARKING:

DATA PLATE LABELS SHALL BE CLEARLY MARKED AS SHOWN IN FIGURES 2 THROUGH 43. ALL LABELS SHALL HAVE BLACK LETTERS PRINTED ON A CONTRASTING BACKGROUND. LABELS SHALL STILL BE ATTACHED AND LEGIBLE AFTER ALL AS22520 TEST REQUIREMENTS.

5. LABELS:

OTHER LABELS ARE PERMISSIBLE ON TOOL FRAME AND POSITIONERS, PROVIDED THE LABEL IS ATTACHED AND LEGIBLE AFTER ALL REQUIRED AS22520 ENVIRONMENTAL TESTING. ALL LABELS SHALL HAVE BLACK LETTERS PRINTED ON A CONTRASTING BACKGROUND.

6. MATERIALS:

UNLESS OTHERWISE SPECIFIED, MATERIAL SHALL BE IN ACCORDANCE WITH AS22520. SURFACE TEXTURE SHALL BE 63 RMS OVER ALL IN ACCORDANCE WITH ASME B46 1. INDENTERS SHALL BE OIL HARDEN TOOL STEEL, HARDENED TO ROCKWELL "C" 56-58. POSITIONER BODY MATERIAL SHALL BE ALUMINUM AMS-QQ-A-225/6 AND LOCATOR STAINLESS STEEL PER AMS-QQ-S-763, CLASS 304.

	<b>AEROSPACE STANDARD</b>	<b>AS22520™/2</b> SHEET 3 OF 49	<b>REV.</b> <b>B</b>
	CRIMPING TOOLS, TYPE 1, TERMINAL, HAND, WIRE TERMINATION FOR WIRE BARREL SIZES 20 THROUGH 28		

7. WEIGHT:

WEIGHT OF TOOL FRAME WITHOUT POSITIONER SHALL NOT EXCEED 1.0 POUND AND THE POSITIONER SHALL NOT EXCEED .50 POUND.

8. TOOL CRIMP FORCE:

CRIMP FORCE REQUIRED TO MAKE SATISFACTORY CRIMPS SHALL NOT EXCEED 65 POUNDS WHEN CRIMPING AN M39029/56-351 CONTACT TO A SIZE 20 AS22759, NICKEL COATED HIGH STRENGTH COPPER ALLOY CONDUCTOR WIRE OR AN EQUIVALENT CONDUCTOR CONFORMING TO AS29606.

9. TOOL FRAME INDENTER GAGE LIMITS:

INDENTER GAGE LIMITS ARE DEFINED IN FIGURE 1. USE INSPECTION GAGE AS22520/3-1 AT SELECTOR NUMBER 8. OTHER GAGE PINS MAY BE USED PROVIDING THE DIMENSION AND TOLERANCE OF THE INDENTER GAGE LIMITS ARE AS SPECIFIED IN FIGURE 1. TOOL SHALL BE REJECTED IF GO OR NO-GO GAGING TEST FAILS AS DEFINED BY AS22520 .

10. POSITIONER LOCK PLATE:

THE POSITIONER LOCK PLATE SHALL PROVIDE POSITIVE DETENT FOR BAYONET LOCK PINS, AND A MEANS OF SECURING THE POSITIONER SO THAT IT CANNOT BE REMOVED WITHOUT REMOVING A LOCKING PIN OR WIRE. THE CONTACT HOLDER IN THE POSITIONER SHALL BE SPRING LOADED. WHEN THE SPRING IS DEPRESSED .031 INCHES IT SHALL HAVE A FORCE RANGE OF 1 TO 3 POUNDS.

11. CYCLE CONTROL RATCHET:

THE TOOL SHALL BE MADE WITH A TAMPER-PROOF RATCHET WHICH LIMITS THE MOVEMENT OF THE TOOL HANDLE IN BOTH DIRECTIONS AND ASSURES A COMPLETE CLOSURE OF THE TOOL HANDLE PRIOR TO RELEASE PER AS22520.

APPLICATION NOTES:

1. SIZE 16 WIRE CAN BE ACCOMMODATED BY THE TOOL, ONLY WHEN USING M22520/2-15 AND M22520/2-18 POSITIONERS, AND THE SPECIFIED CONTACTS SHOWN ON THE POSITIONER DATAPLATE
2. THE TOOL AND APPLICABLE POSITIONERS CRIMP THE CONTACTS SPECIFIED IN TABLE 1 AND SUCCEEDING PAGES. THE TABLE MAY NOT BE ALL INCLUSIVE AND THE COMPONENT SPECIFICATION TAKES PRECEDENCE IN ALL CASES WHERE THERE IS A DISAGREEMENT.
3. AS22520/2 CONFIGURATION IS FOR HAND CRIMPING ONLY.

NOTICE

USE OF HAND CRIMPING TOOLS COVERED BY THIS SPECIFICATION AS A COMPONENT IN ANY POWERED "PRESS" MAY VIOLATE OCCUPATIONAL SAFETY AND HEALTH ADMINISTRATION (OSHA) REGULATIONS CFR 1910.211.

SPECIFICATION NOTE:

1. REVISION INDICATOR: A CHANGE BAR (I) LOCATED IN THE LEFT MARGIN IS FOR THE CONVENIENCE OF THE USER IN LOCATING AREAS WHERE TECHNICAL REVISIONS, NOT EDITORIAL CHANGES, HAVE BEEN MADE TO THE PREVIOUS ISSUE OF THIS DOCUMENT. AN (R) SYMBOL TO THE LEFT OF THE DOCUMENT TITLE INDICATES A COMPLETE REVISION OF THE DOCUMENT, INCLUDING TECHNICAL REVISIONS. CHANGE BARS AND (R) ARE NOT USED IN ORIGINAL PUBLICATIONS, NOR IN DOCUMENTS THAT CONTAIN EDITORIAL CHANGES ONLY.

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	<b>AEROSPACE STANDARD</b>	<b>AS22520™/2</b> SHEET 4 OF 49	<b>REV.</b> <b>B</b>
	CRIMPING TOOLS, TYPE 1, TERMINAL, HAND, WIRE TERMINATION FOR WIRE BARREL SIZES 20 THROUGH 28		

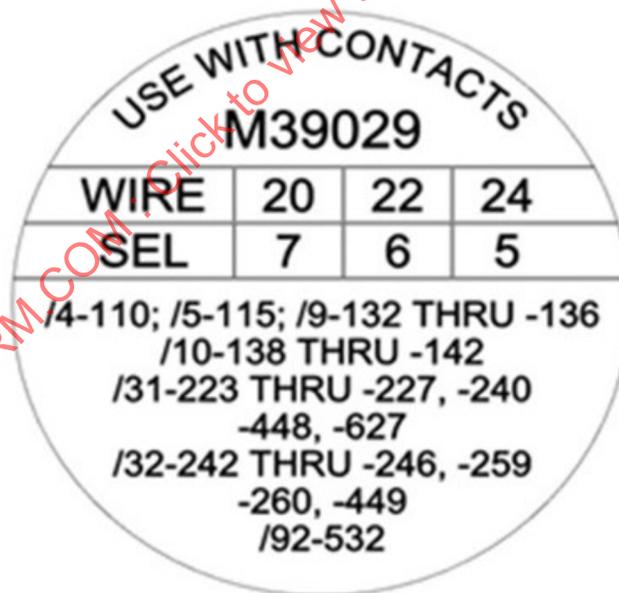
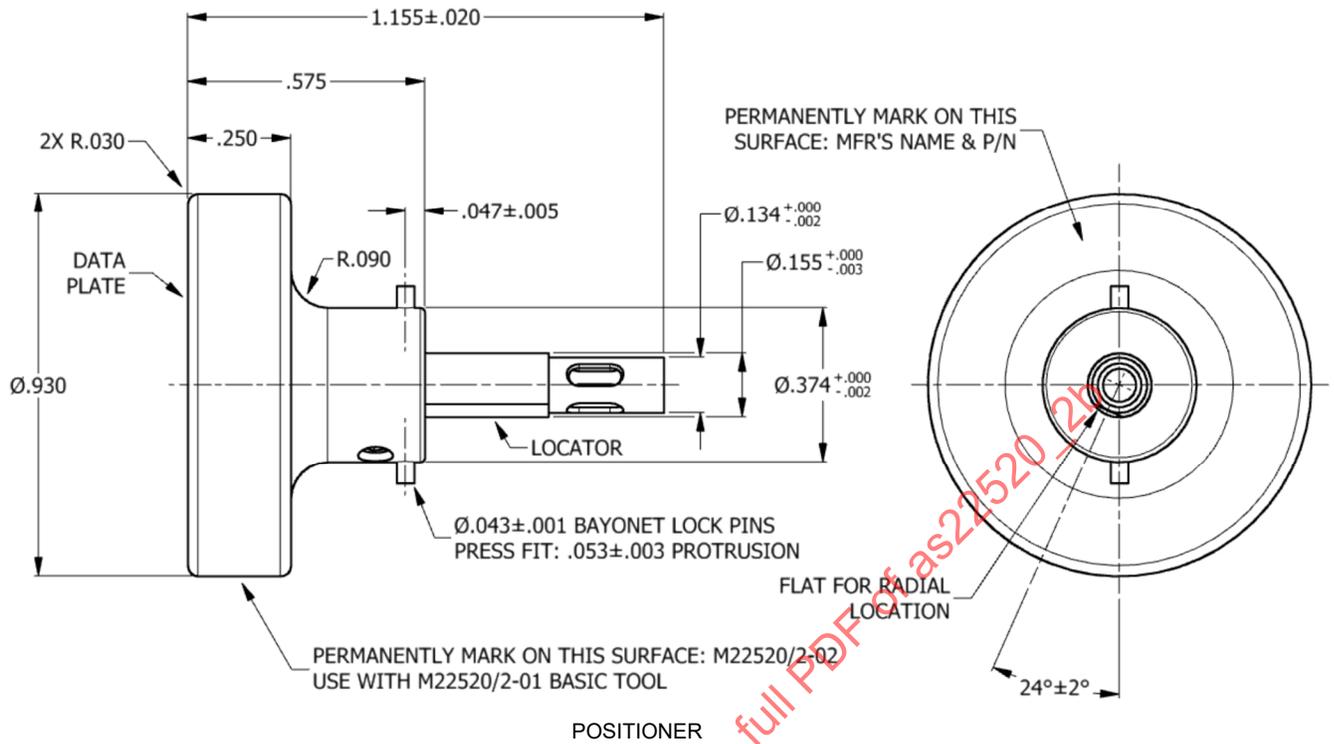
**TABLE 1- TOOL/CONTACT CRIMP APPLICATIONS**

CRIMP TOOL FRAME M22520/2-01	
CONTACT DETAIL SPECIFICATION NUMBER	REQUIRED POSITIONER M22520/2-
AS39029/4, /5, /9, /10, /31, /32, /92	02
AS39029/33, /46, /47	03
AS39029/40, /41, /42, /43 (ALL CANCELED) 1/	04
MIL-DTL-21097/9-01 (CANCELED) 1/	05
AS39029/57, /89,	06
AS39029/56, /88, /106, /117, /121	07
AS39029/11, /12, /63, /64, /93, /94	08
AS39029/58, /87, /107, /118, /122, /123	09
AS39029/56, /57, /58, /87, /88, /89, /106, /107, /117, /118, /121, /123	10
AS39029/1, /2, /3	11
AS39029/65, /66 (CANCELED) 1/	12
AS39029/16, /18, /122	13
AS39029/16, /18	14
AS39029/16, /18	15
AS39029/17, /121	16
AS39029/17-173	17
AS39029/17-174	18
AS39029/22	19
M39029/15-20-20 (CANCELLED) 1/	20
AS39029/15-16-16 (CANCELLED) 1/	21
10215913 (ARMY)	22
AS39029/11, /12, /93, /94	23
FSCM 98230, ONO 89558, AS39029/54 & /55	24
AS39029/6, /13, /14	25
AS39029/6, /13, /14	26
AS39029/7, /8	27
AS39029/19, /20, /21	28
AS39029/19, /20, /21	29
AS39029/50, /51	30
AS39029/59, /60	31
AS39029/1, /25, /26	32
AS39029/54, /55	33
AS39029/27, /28, /75	34
AS39029/76, /77, /78	35
MIL-DTL-28804/9-1, /10-1	36
AS39029/90, /91, /95, /113, /114, /119, /120	37
AS39029/92-531	38
AS39029/102 (CARLISLE ONLY) 2/	39
AS39029/103 (CARLISLE ONLY) 2/	40
AS39029/34-440, /35-441	41

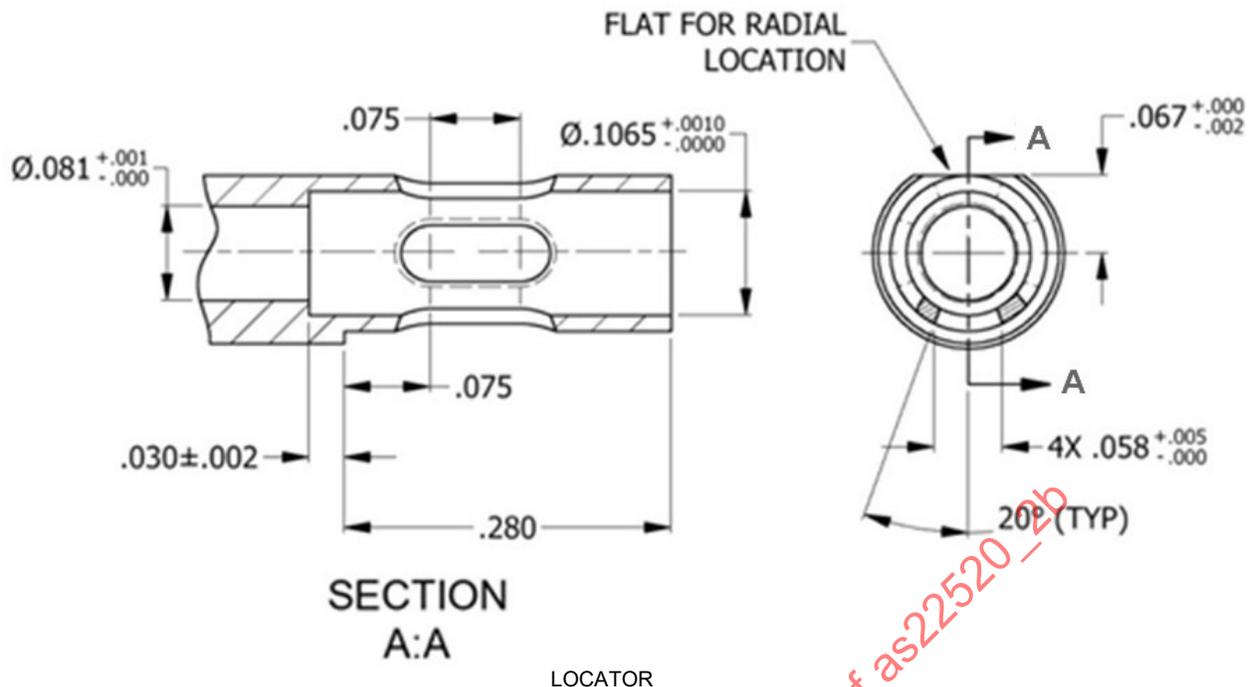
- 1/ DESIGNATED CONTACT SPECIFICATION(S) FOR THE POSITIONER HAS BEEN CANCELED.  
 2/ FOR CONTACT BRANDS OTHER THAN CARLISLE, REFER TO AS22520/46.

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M22520/2-02 POSITIONER



POSITIONER DATA PLATE  
FIGURE 2 - M22520/2-02 POSITIONER



M22520/2-02 POSITIONER INFORMATION

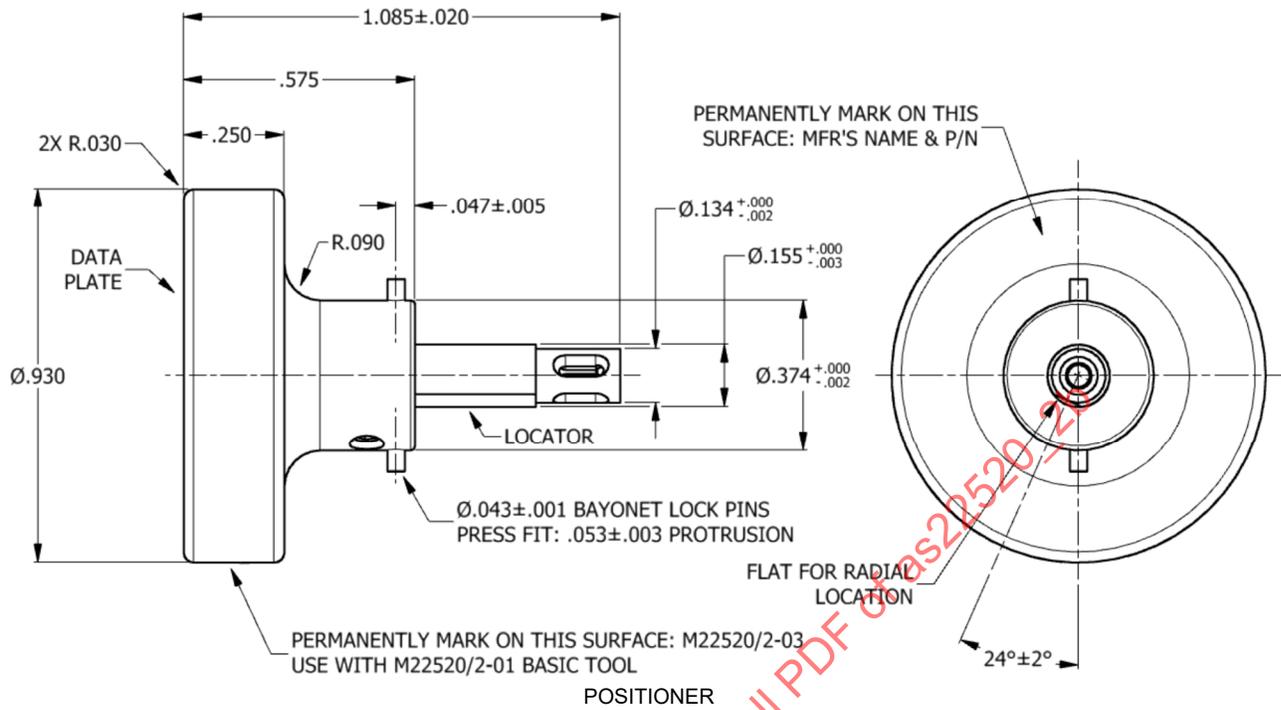
POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-02	M39029/4-110, M39029/5-115, M39029/9-132 THROUGH -136, M39029/10-138 THROUGH -142, M39029/31-223 THROUGH -227, -240, -448 & 627, M39029/32-242 THROUGH -246, -259, -260 & -449, M39029/92-532

TOOL/POSITIONER OBSOLETE CONTACT INFORMATION

POSITIONER PART NO.	OBSOLETE CONTACT PART NO.S
M22520/2-02	M39029/4-20-20 & -001, /5-20-20 & -001, /9-20-20 C1 THROUGH C5, /10-20-20 C1 THROUGH C5, /31-20-20 & -241, /32-20-20, M83723/33-20, /34-20, MS3192-20-20A & -20C1 THROUGH C4, MS3192A20, MS3193-20-20A & -20C1 THROUGH C4, MS24254-20P, MS24255-20S, MS3193A20-20A

FIGURE 2 (CONTINUED) - M22520/2-02 POSITIONER

M22520/2-03 POSITIONER

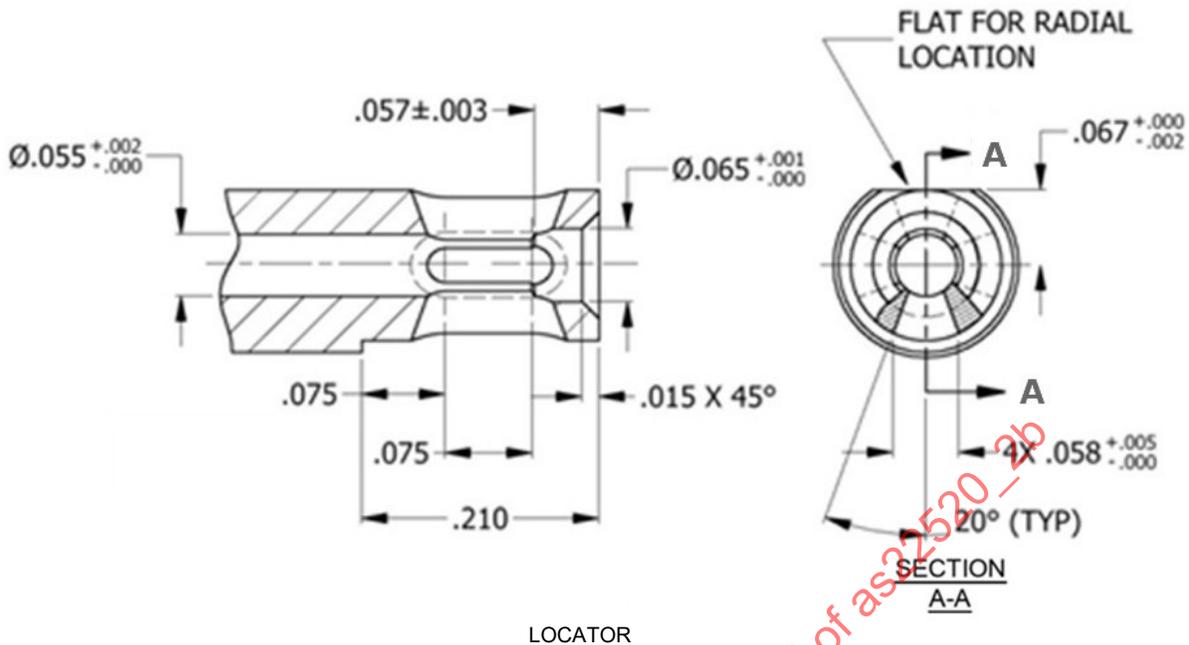


USE WITH CONTACTS

M39029	WIRE	SEL
/33-264	22	5
/46-304	24	4
/47-314	26	3
/33-262	28	5
/46-302	30	5
/47-312	32	4

POSITIONER DATAPLATE

FIGURE 3 - M22520/2-03 POSITIONER



LOCATOR

M22520/2-03 POSITIONER INFORMATION

POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-03	M39029/33-262 & -264, M39029/46-302 & -304, M39029/47-312 & -314

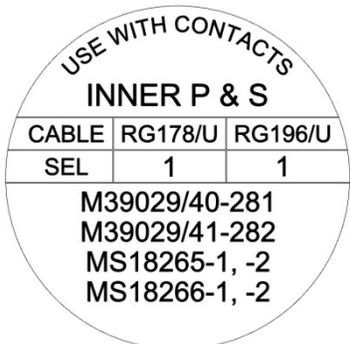
TOOL/POSITIONER CONTACT OBSOLETE INFORMATION

POSITIONER PART NO.	OBSOLETE CONTACT PART NO.S
M22520/2-03	M39029/33-261 & -263, M39029/46-301 & -303, M39029/47-311 & -313, MS3343A23-28 & -22, MS3343B23-28 & -22, MS90460A23-28 & -22, MS90460B23-28 & -22, MS90461A23-28 & -22, MS90461B23-28 & -22,

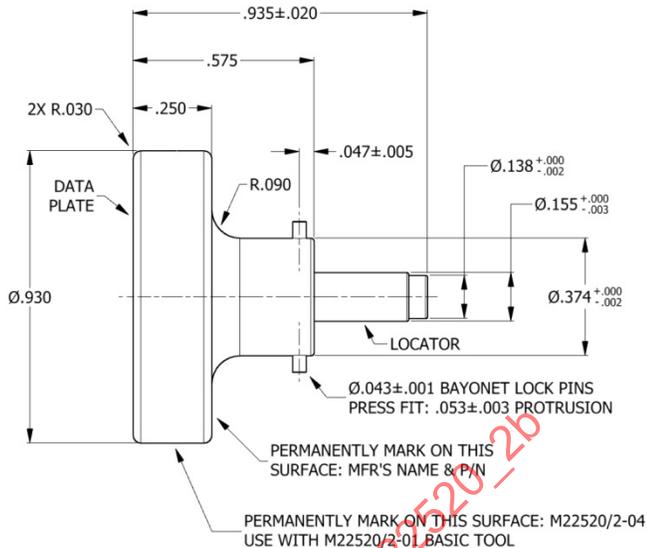
FIGURE 3 (CONTINUED) - M22520/2-03 POSITIONER

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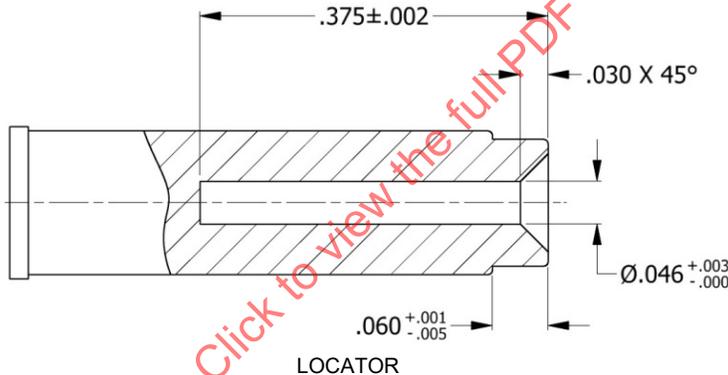
M22520/2-04 POSITIONER 1/



POSITIONER DATA PLATE



POSITIONER SIDE VIEW



LOCATOR

M22520/2-04 POSITIONER INFORMATION

POSITIONER PART NO.	CONTACTS ACCOMMODATED 1/
M22520/2-04	M39029/40-281, /41-282, MS18265-1, -2, MS18266-1, -2

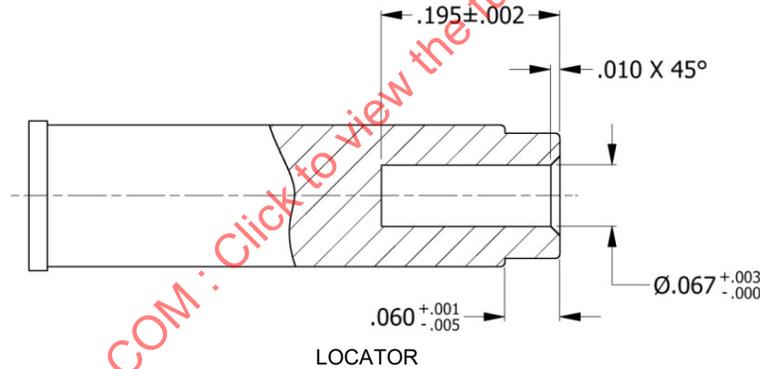
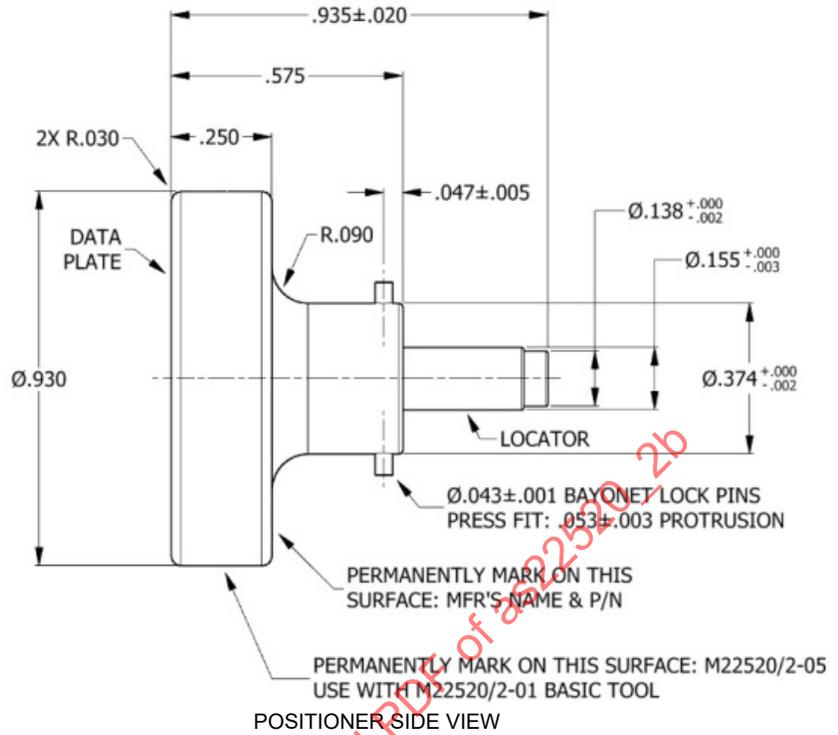
1/ AS39029/40 AND /41 SPECIFICATION IS CANCELED WITHOUT REPLACEMENT (REFER TO AS39029/34 AND /35).

TOOL/POSITIONER CONTACT OBSOLETE INFORMATION

POSITIONER PART NO.	OBSOLETE CONTACT PART NO.
M22520/2-04	M39029/40-281, /41-282, /42-283 & -284, MS18265-1 & -2, MS18266-1 & -2

FIGURE 4 - M22520/2-04 POSITIONER

M22520/2-05



M22520/2-05 POSITIONER INFORMATION

POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-05	M21097/9-01

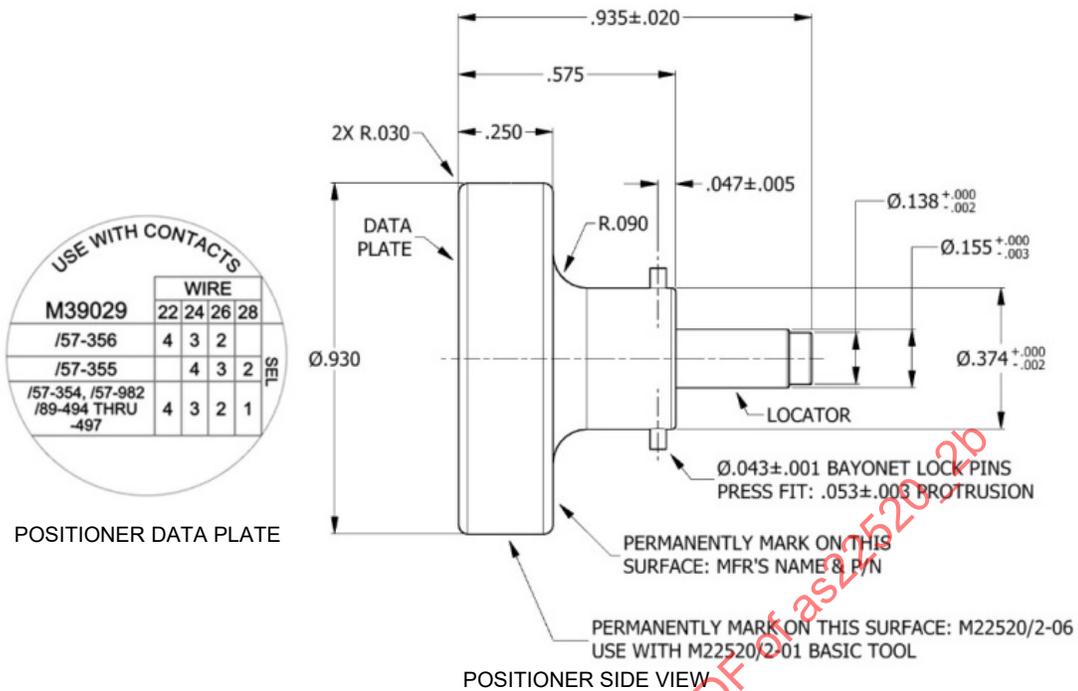
TOOL/POSITIONER SUPERSESSSION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-05	M21097/9-01 1/

1/ MIL-C-21097/9 SPECIFICATION WAS CANCELED WITHOUT REPLACEMENT

FIGURE 5 - M22520/2-05 POSITIONER

M22520/2-06 POSITIONER



M22520/2-06 POSITIONER INFORMATION

POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-06	M39029/57-354 THROUGH -356 & -982, /89-494 THROUGH -497

TOOL/POSITIONER SUPERSESION INFORMATION

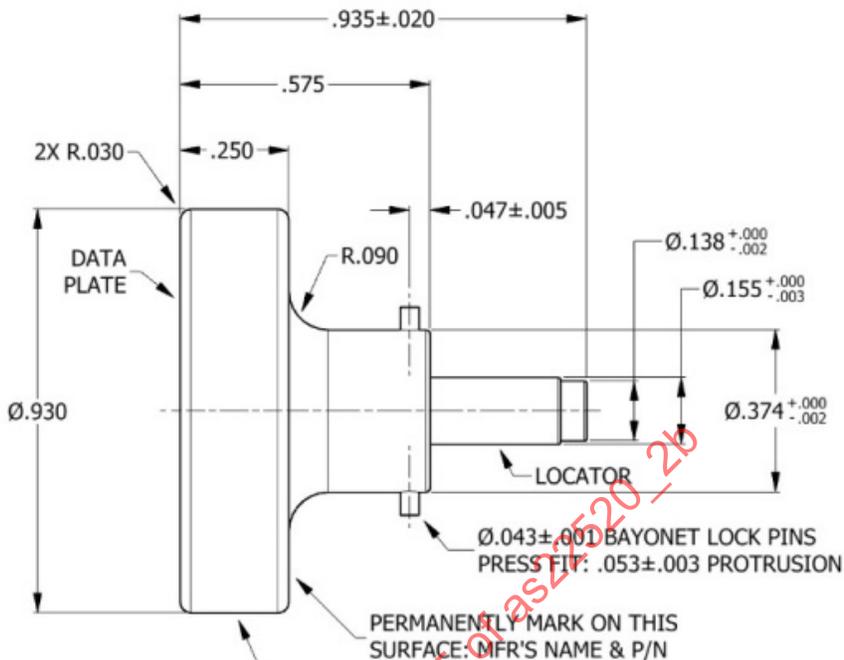
POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-06	M27491-22D, -22M, -22

FIGURE 6 - M22520/2-06 POSITIONER

M22520/2-07 POSITIONER



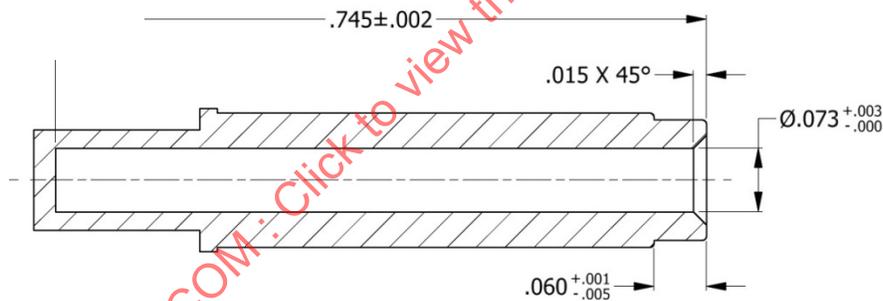
POSITIONER DATA PLATE



PERMANENTLY MARK ON THIS SURFACE: MFR'S NAME & P/N

PERMANENTLY MARK ON THIS SURFACE: M22520/2-07  
USE WITH M22520/2-01 BASIC TOOL

POSITIONER SIDE VIEW



LOCATOR

M22520/2-07 POSITIONER INFORMATION

PART NO.	CONTACTS ACCOMMODATED
M22520/2-07	M39029/56-348 THROUGH -350, /88-482 THROUGH -485, /106-614, /117-632, -638, /121-664

TOOL/POSITIONER SUPERSESION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-07	M27490-22D, -22M, -22

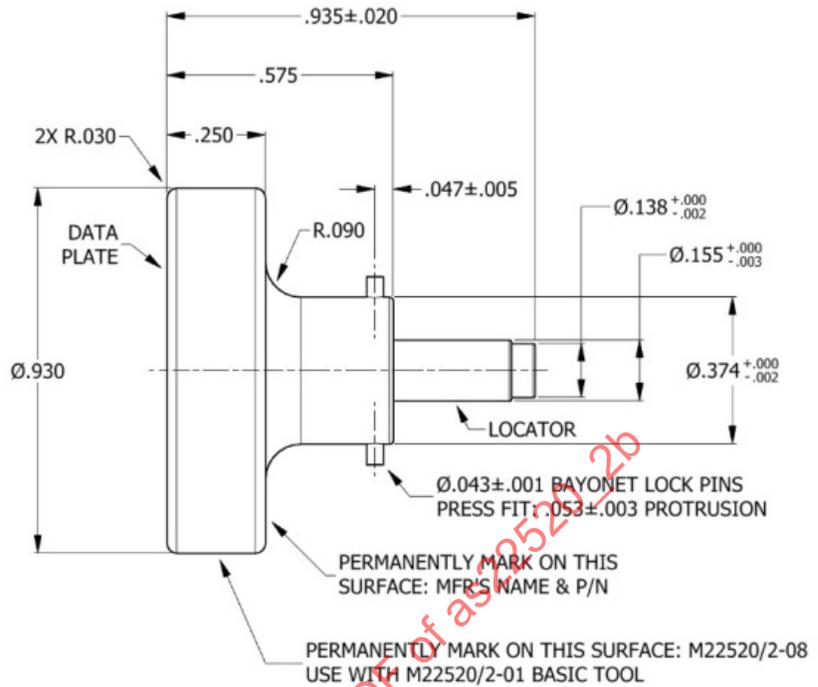
FIGURE 7 - M22520/2-07 POSITIONER

M22520/2-08 POSITIONER

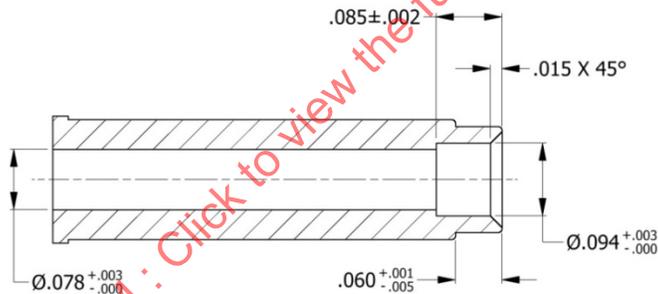
USE WITH CONTACTS  
M39029

SEL		
	/11-145, /12-149 /63-368, /63-928 /64-369, /64-968 /93-598, /94-602	
4		RG141A, 142A, 142B 178B, 180B, 188, 195A 196A, 303, 316/U
5	24	RG55B, 58C, 223/U
6	22	
7	20	

POSITIONER DATA PLATE



POSITIONER SIDE VIEW



LOCATOR

M22520/2-08 POSITIONER INFORMATION

POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-08	M39029/11-145, M39029/12-149, M39029/63-368 & -928, M39029/64-369 & -968, /93-598, /94-602

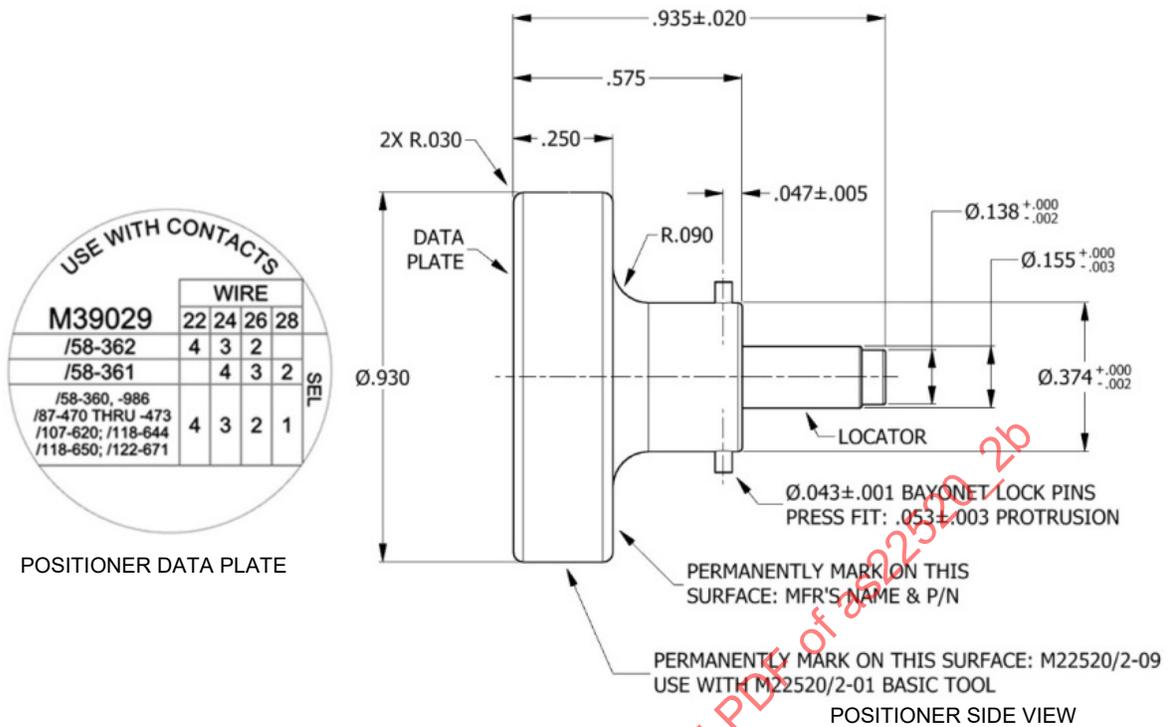
TOOL/POSITIONER SUPERSESSON INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-08	M39029/11-20-20, /12-20-20, M24306/10-1, /11-1, M24308/16 & /17-1 THROUGH -5 INNER P & S

FIGURE 8 - M22520/2-08 POSITIONER

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M22520/2-09 POSITIONER



M22520/2-09 POSITIONER INFORMATION

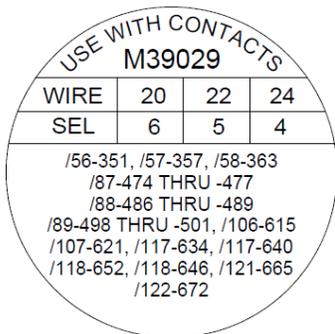
POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-09	M39029/58-360 THROUGH -362 & -986, /87-470 THROUGH -473, /107-620, /118-644, 650 & /122-671

TOOL/POSITIONER SUPERSESSION INFORMATION

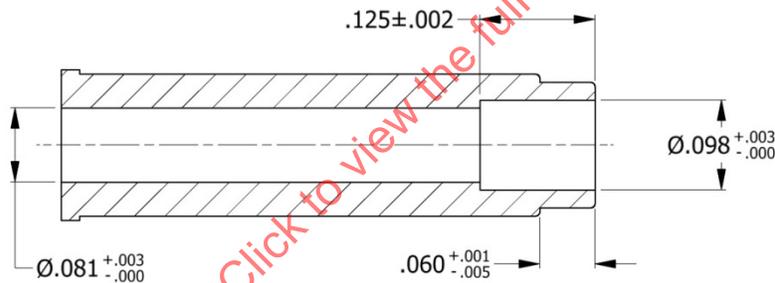
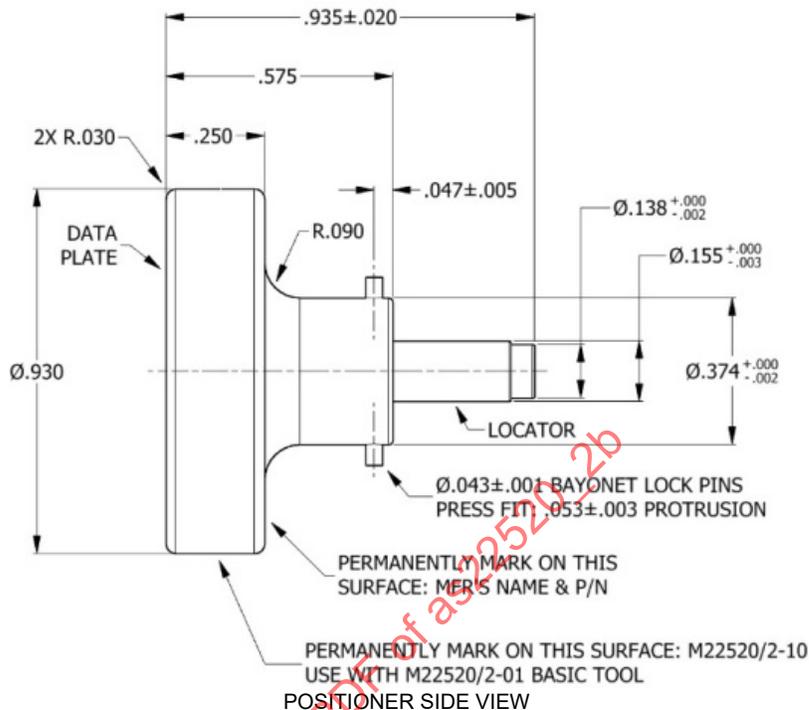
POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-09	MS27493-22D, -22M, -22

FIGURE 9 - M22520/2-09 POSITIONER

M22520/2-10 POSITIONER



POSITIONER DATA PLATE



M22520/2-10 POSITIONER INFORMATION

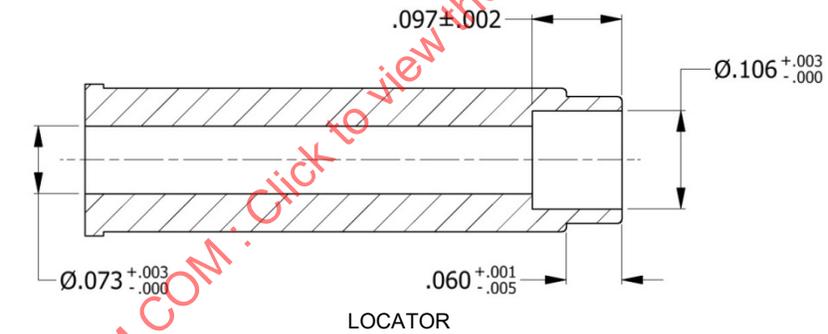
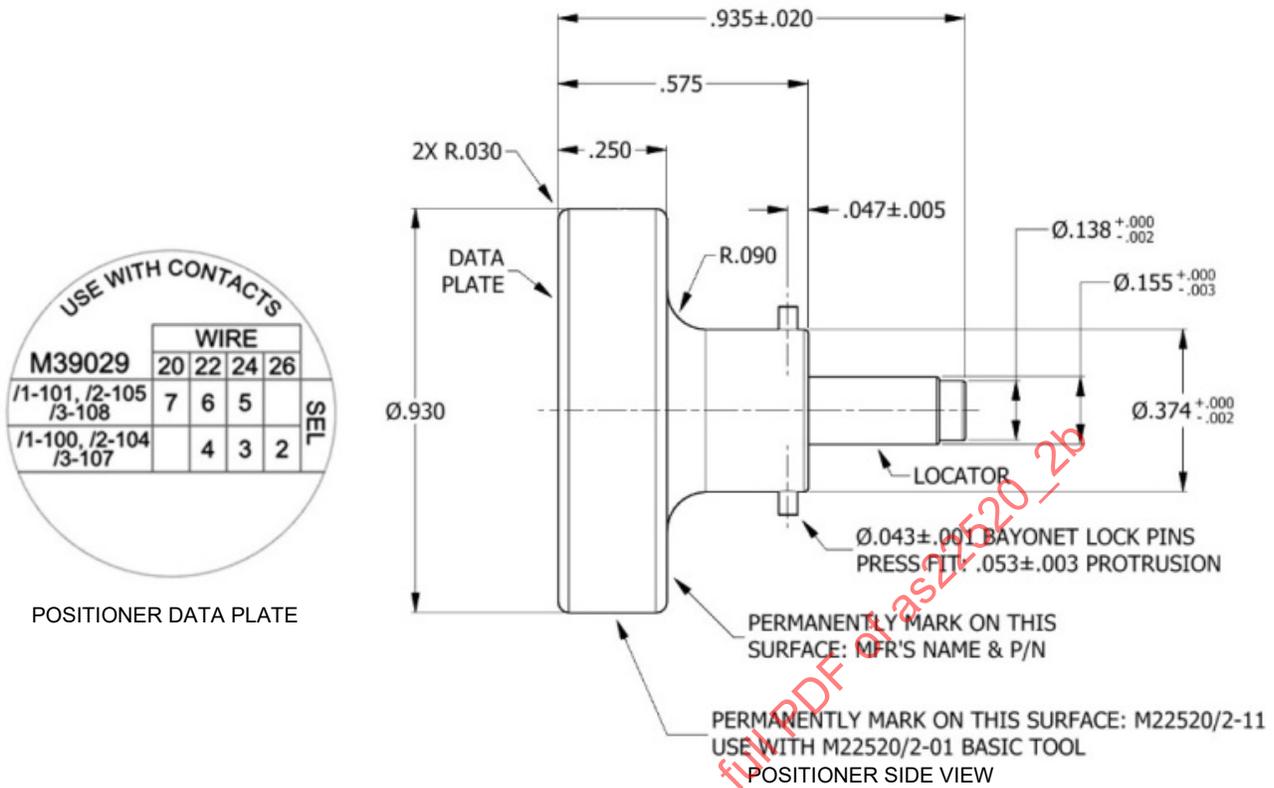
POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-10	M39029/56-351, /57-357, /58-363, /87-474 THROUGH -477, /88-486 THROUGH -489, /89-498 THROUGH -501, /106-615, /107-621, /117-634 & -640, /118-652 & -646, /121-665, /122-672

TOOL/POSITIONER SUPERSESSION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-10	MS27490-20, MS27491-20, MS27493-20

FIGURE 10 - M22520/2-10 POSITIONER

M22520/11 POSITIONER



M22520/2-11 POSITIONER INFORMATION

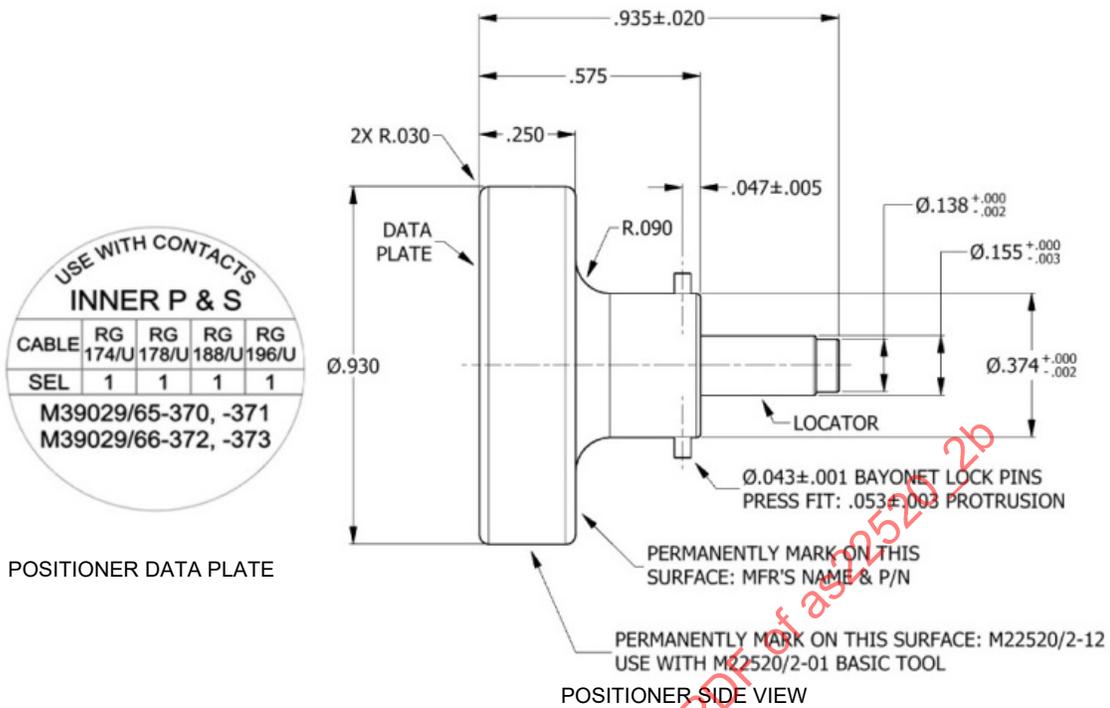
POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-11	M39029/1-100 & -101, /2-104 & -105, /3-107 & -108

TOOL/POSITIONER SUPERSESSSION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-11	M39029/1-16-22 & /1 -16-20, /2-22-22 & /2-20-20, /3-22-22 & /3-20-20

FIGURE 11 - M22520/2-11 POSITIONER

M22520/2-12 POSITIONER 1/



M22520/2-12 POSITIONER INFORMATION

POSITIONER PART NO.	CONTACTS ACCOMMODATED 1/
M22520/2-12	M39029/65-370, -371 & M39029/66-372, -373

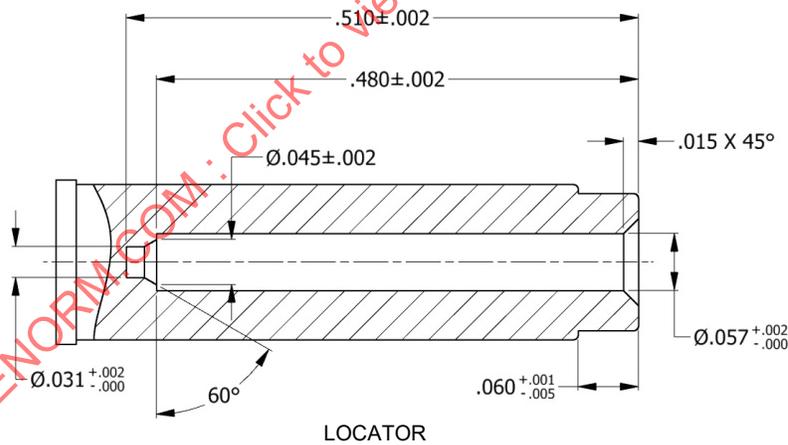
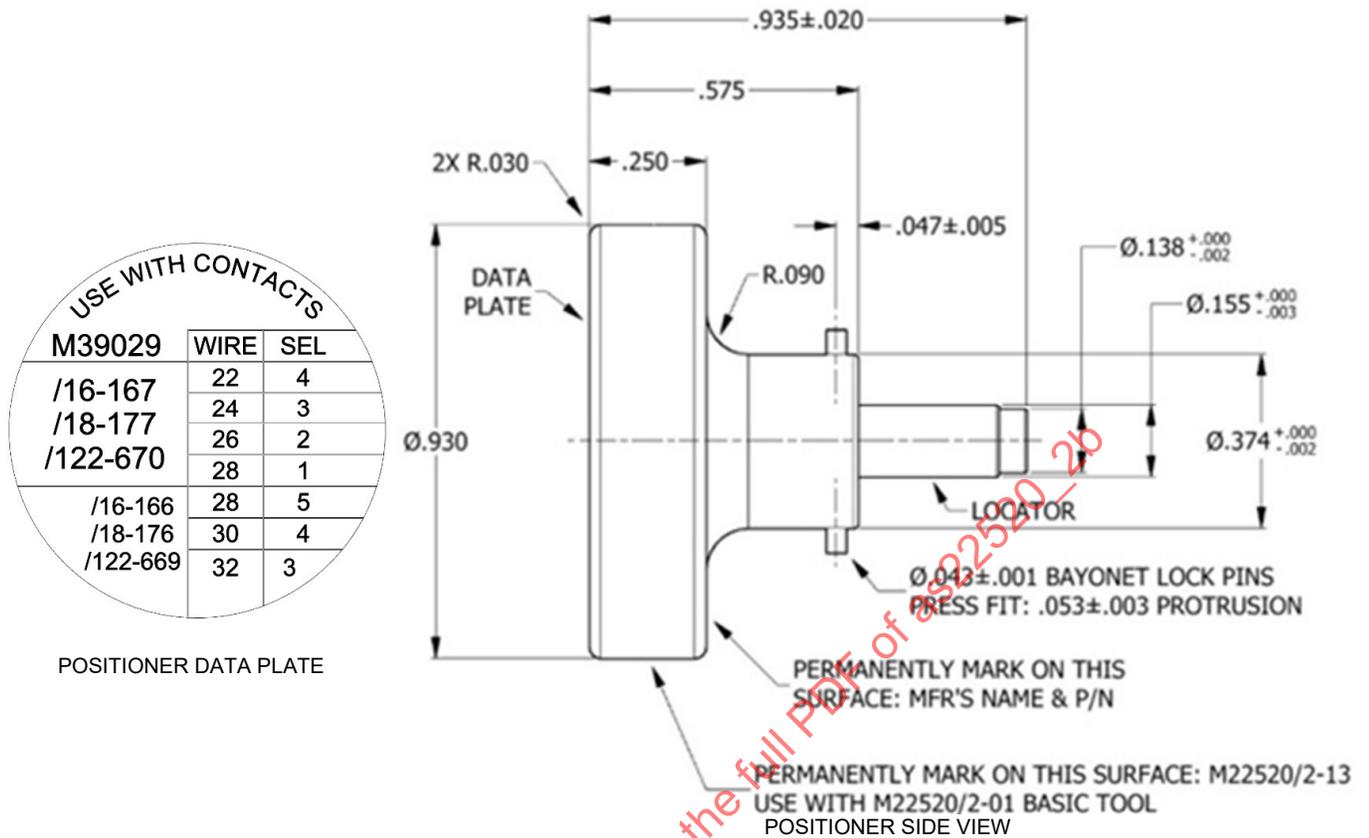
1/ POSITIONER CONTACTS ARE CANCELED WITHOUT REPLACEMENT.

TOOL/POSITIONER SUPERSESION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-12	M24308/14-1, -2, /15-1, -2

FIGURE 12 - M22520/2-12 POSITIONER

M22520/2-13 POSITIONER



M22520/2-13 POSITIONER INFORMATION

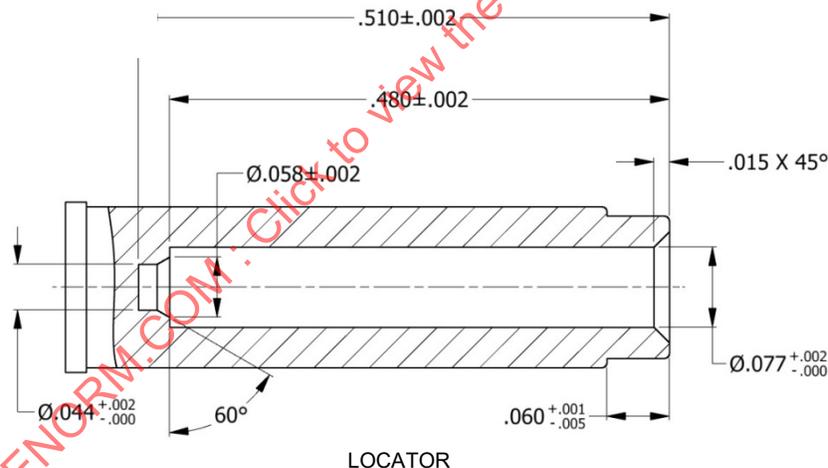
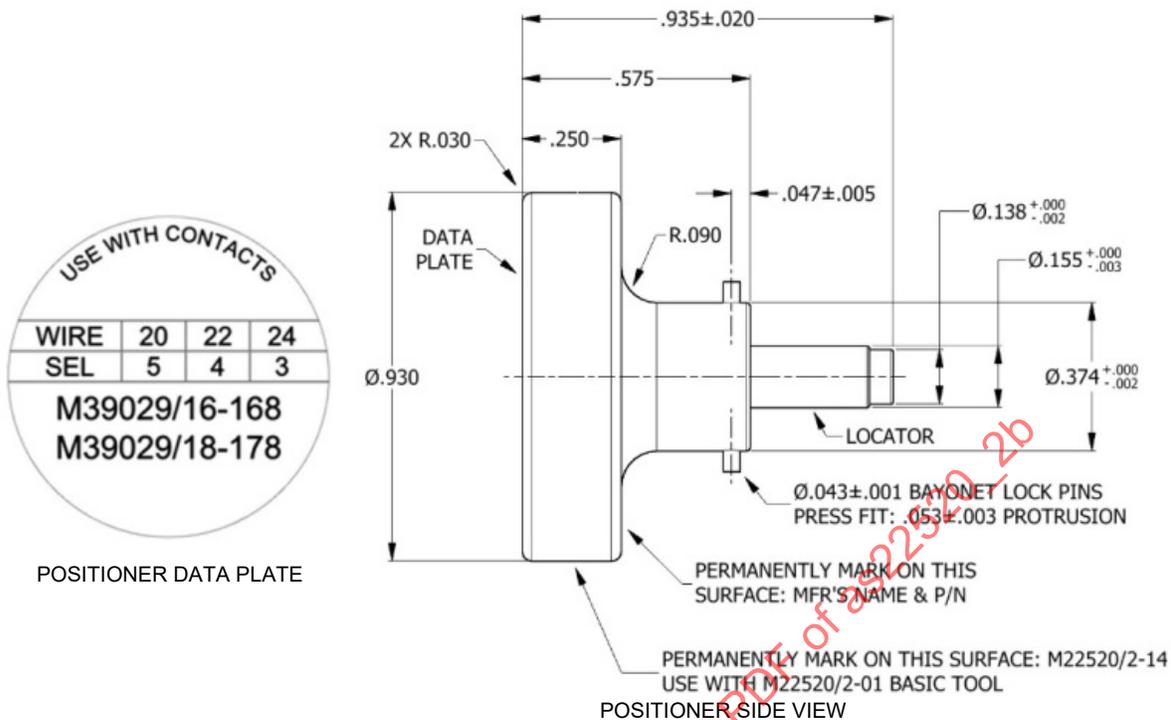
POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-13	M39029/16-166 & -167, /18-176 & -177, /122-669 & -670

TOOL/POSITIONER SUPERSESION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-13	M39029/16-23-28, -23-22, /18-23-28, -23-22

FIGURE 13 - M22520/2-13 POSITIONER

M22520/2-14 POSITIONER



M22520/2-14 POSITIONER INFORMATION

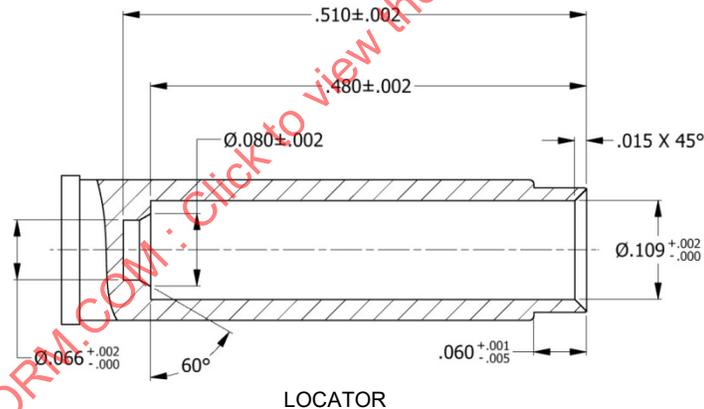
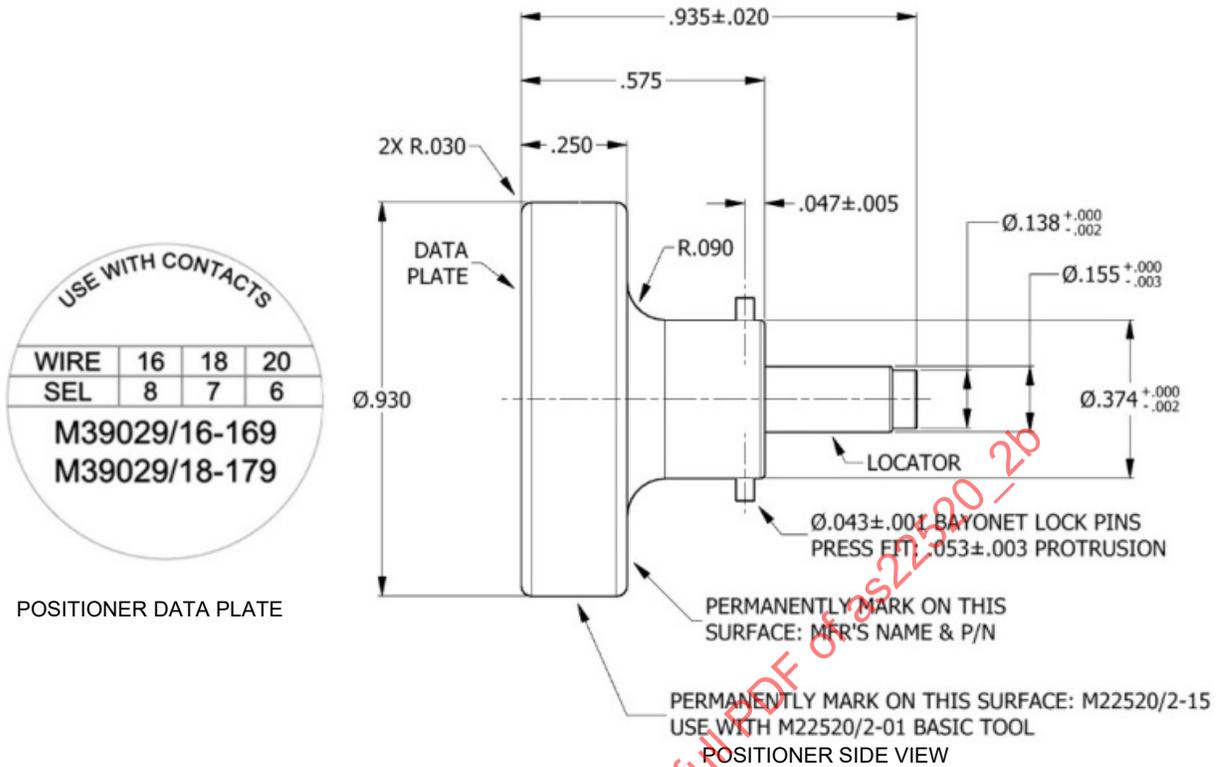
POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-14	M39029/16-168, M39029/18-178

TOOL/POSITIONER SUPERSESION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-14	M39029/16-20-20, /18-20-20

FIGURE 14 - M22520/2-14 POSITIONER

M22520/2-15 POSITIONER



M22520/2-15 POSITIONER INFORMATION

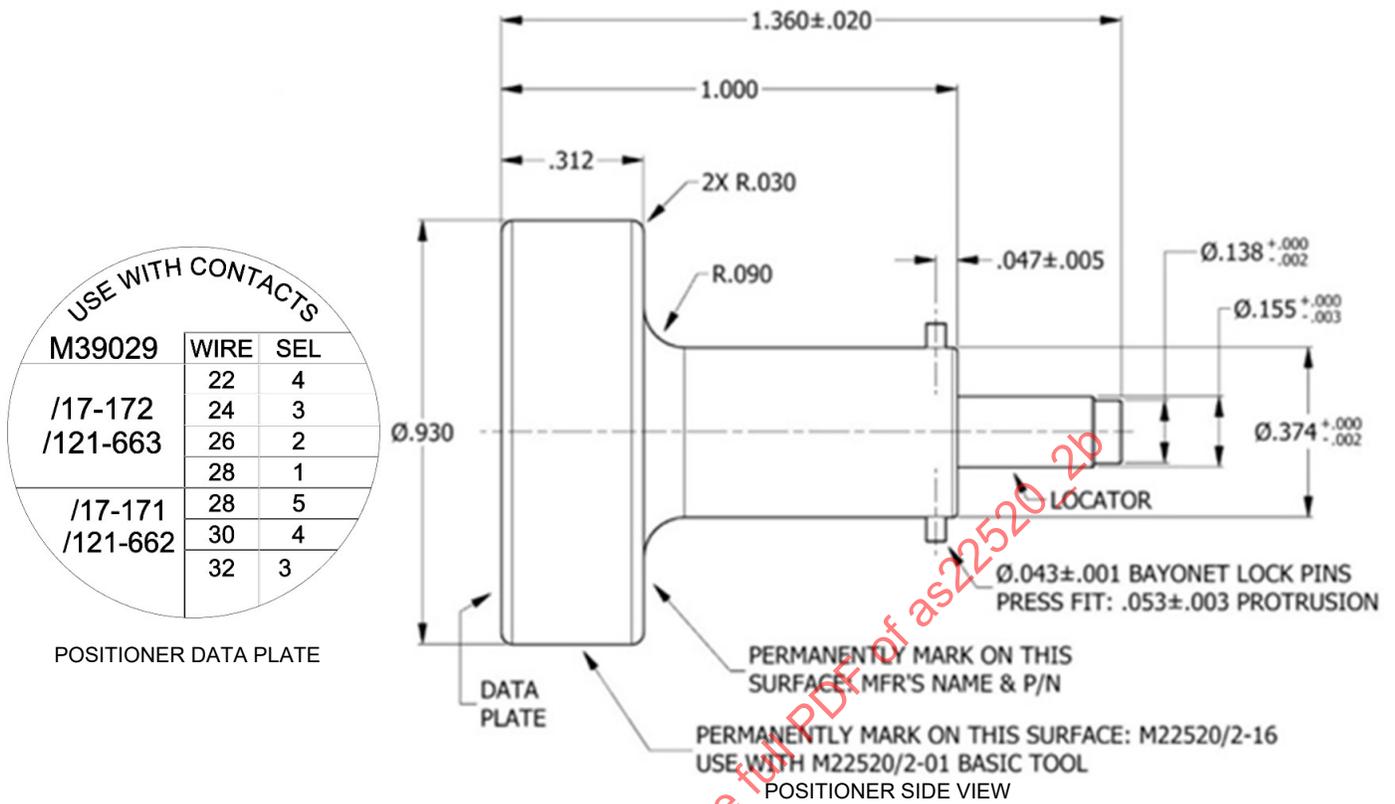
PART NO.	CONTACTS ACCOMMODATED
M22520/2-15	M39029/16-169, M39029/18-179

TOOL/POSITIONER SUPERSESSION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-15	M39029/16-16-16, /18-16-16

FIGURE 15 - M22520/2-15 POSITIONER

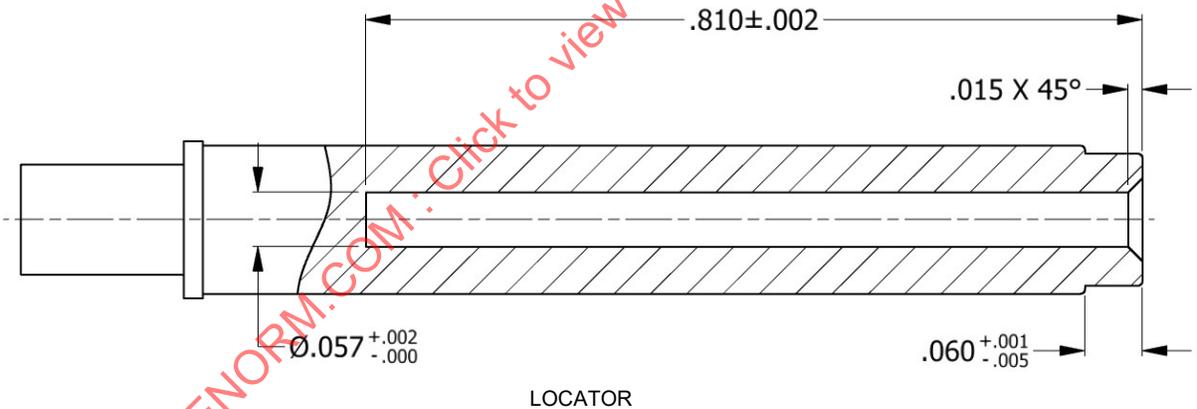
M22520/2-16 POSITIONER



USE WITH CONTACTS

M39029	WIRE	SEL
/17-172	22	4
/121-663	24	3
	26	2
	28	1
/17-171	28	5
/121-662	30	4
	32	3

POSITIONER DATA PLATE



LOCATOR

M22520/2-16 POSITIONER INFORMATION

POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-16	M39029/17-171 & -172, /121-662 & -663

TOOL/POSITIONER SUPERSESSION INFORMATION

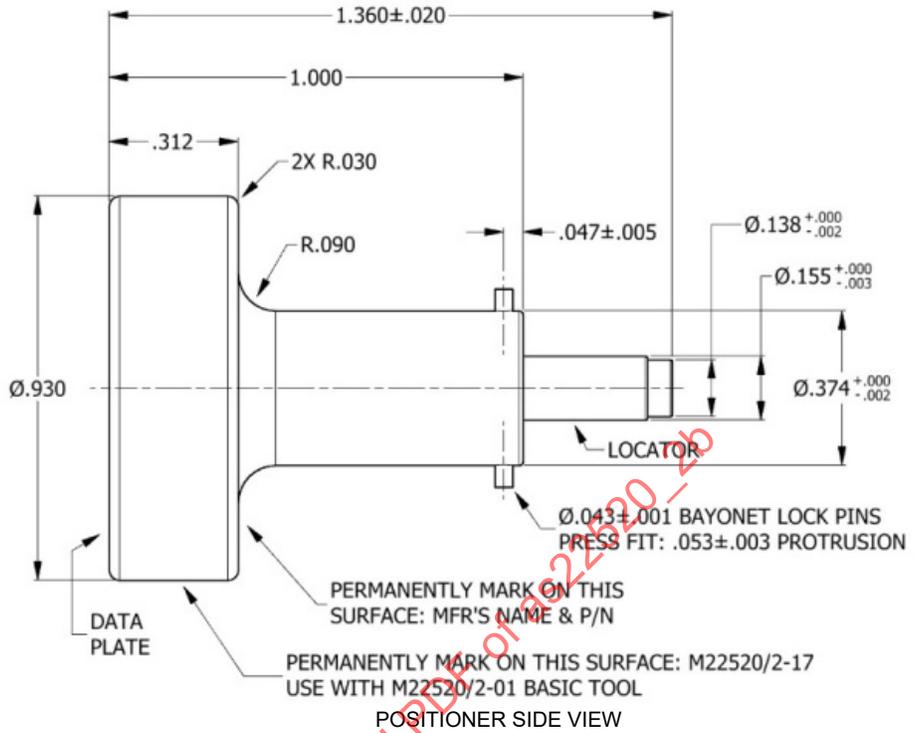
POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-16	M39029/16-23-28 & /16 -23-22

FIGURE 16 - M22520/2-16 POSITIONER

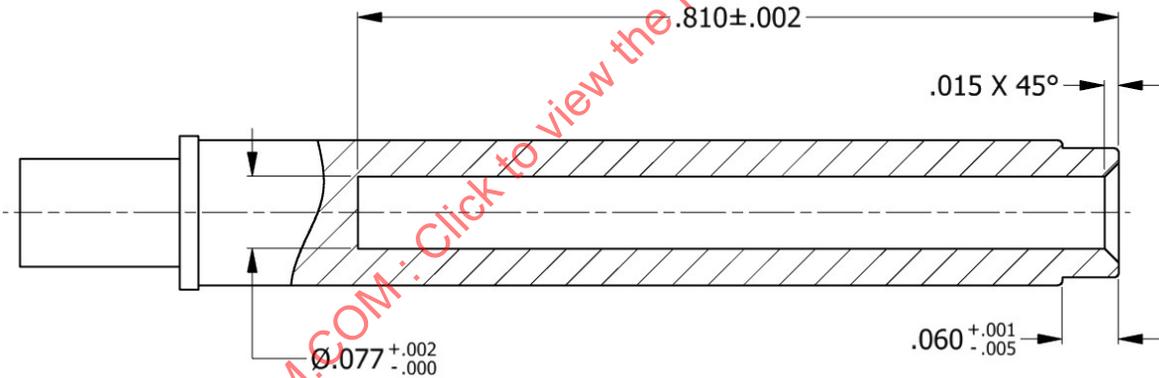
M22520/2-17 POSITIONER



POSITIONER DATA PLATE



POSITIONER SIDE VIEW



LOCATOR

M22520/2-17 POSITIONER INFORMATION

POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-17	M39029/17-173

TOOL/POSITIONER SUPERSESSSION INFORMATION

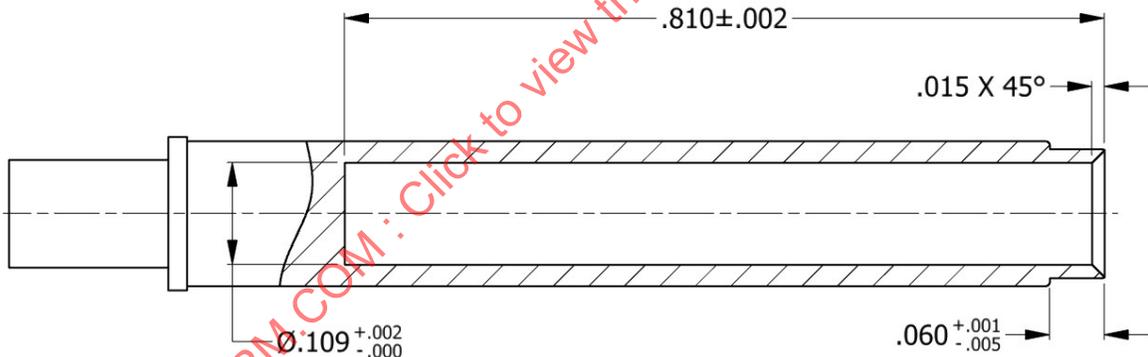
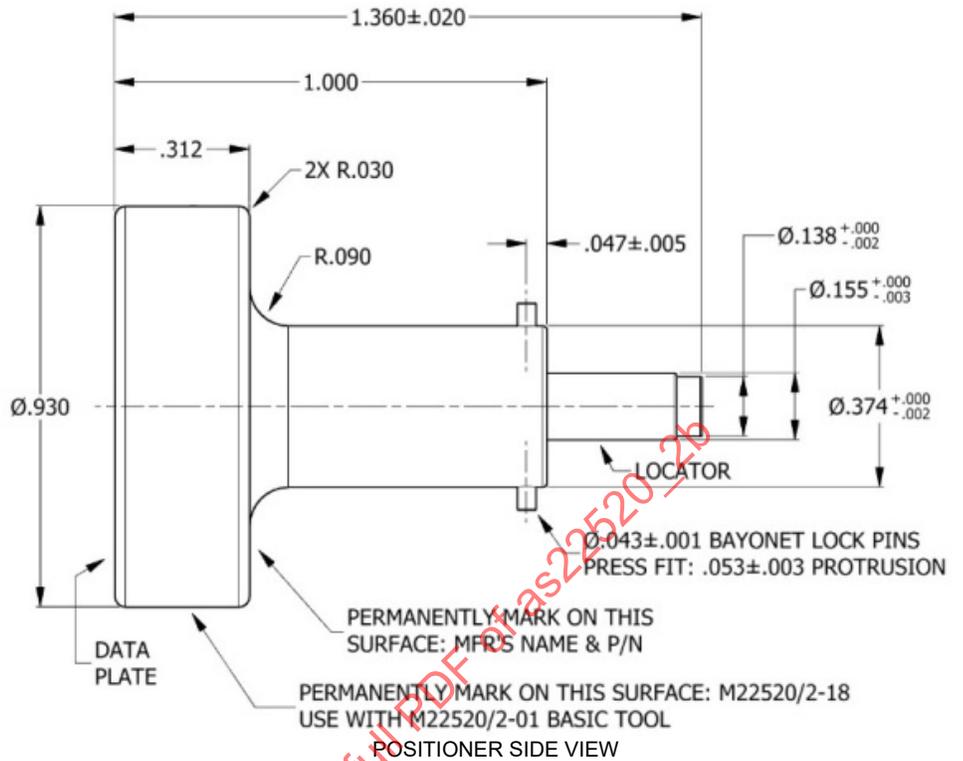
POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-17	M39029/17-20-20

FIGURE 17 - M22520/2-17 POSITIONER

M22520/2-18 POSITIONER



POSITIONER DATA PLATE



LOCATOR

M22520/2-18 POSITIONER INFORMATION

PART NO.	CONTACTS ACCOMMODATED
M22520/2-18	M39029/17-174

TOOL/POSITIONER SUPERSESION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-18	M39029/17-16-16

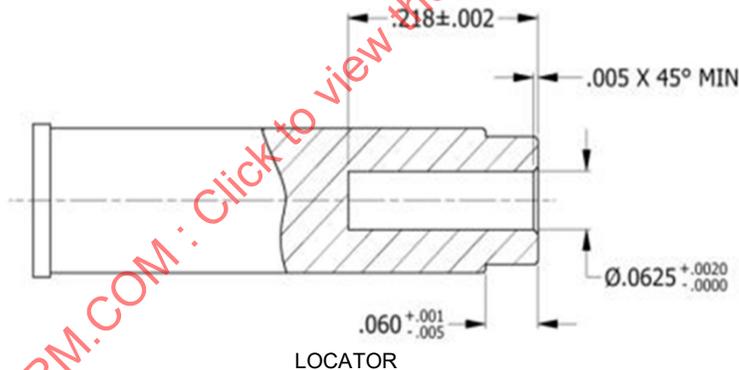
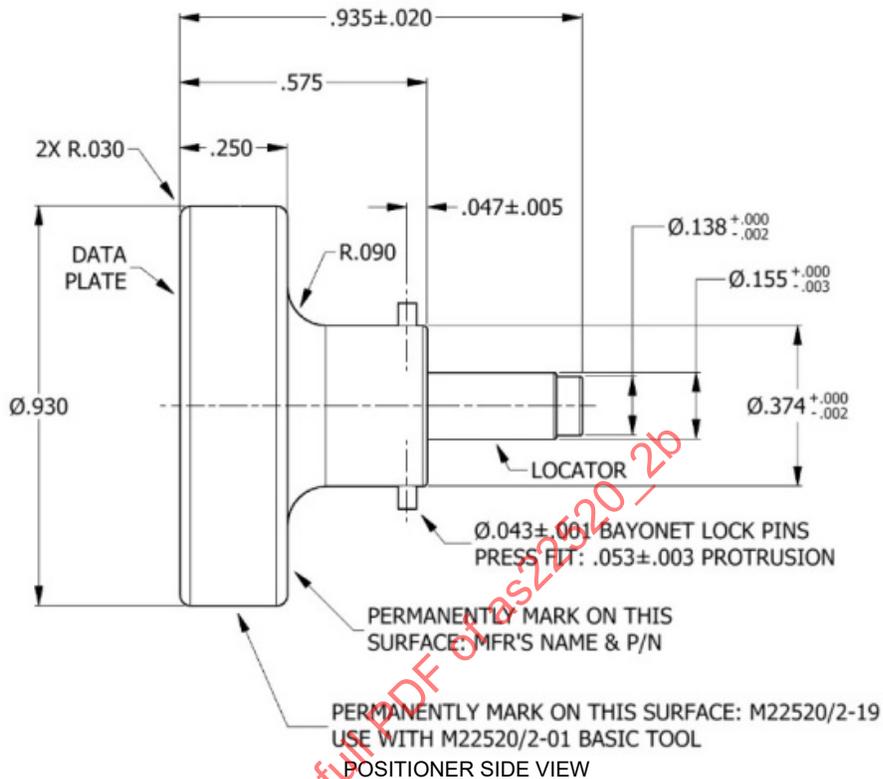
FIGURE 18 - M22520/2-18 POSITIONER

M22520/2-19 POSITIONER

USE WITH CONTACTS

M39029	WIRE	SEL
/101-552	22	4
	24	3
	26	2
/22-191	28	1
	28	5
/101-551	30	4
	32	3

POSITIONER DATA PLATE



M22520/2-19 POSITIONER INFORMATION

POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-19	M39029/22-190 & -191, M39029/101-551 & -552

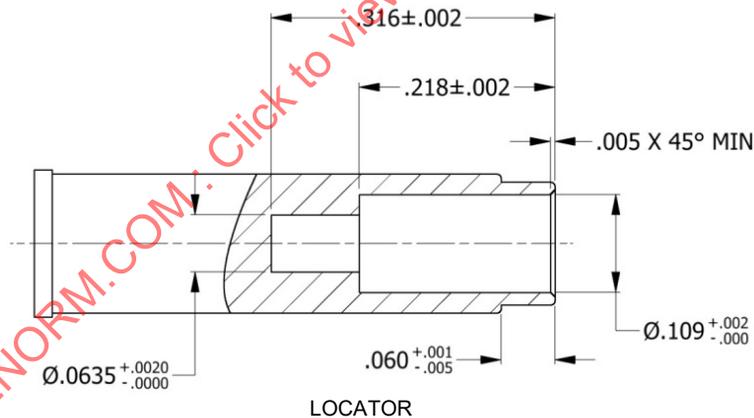
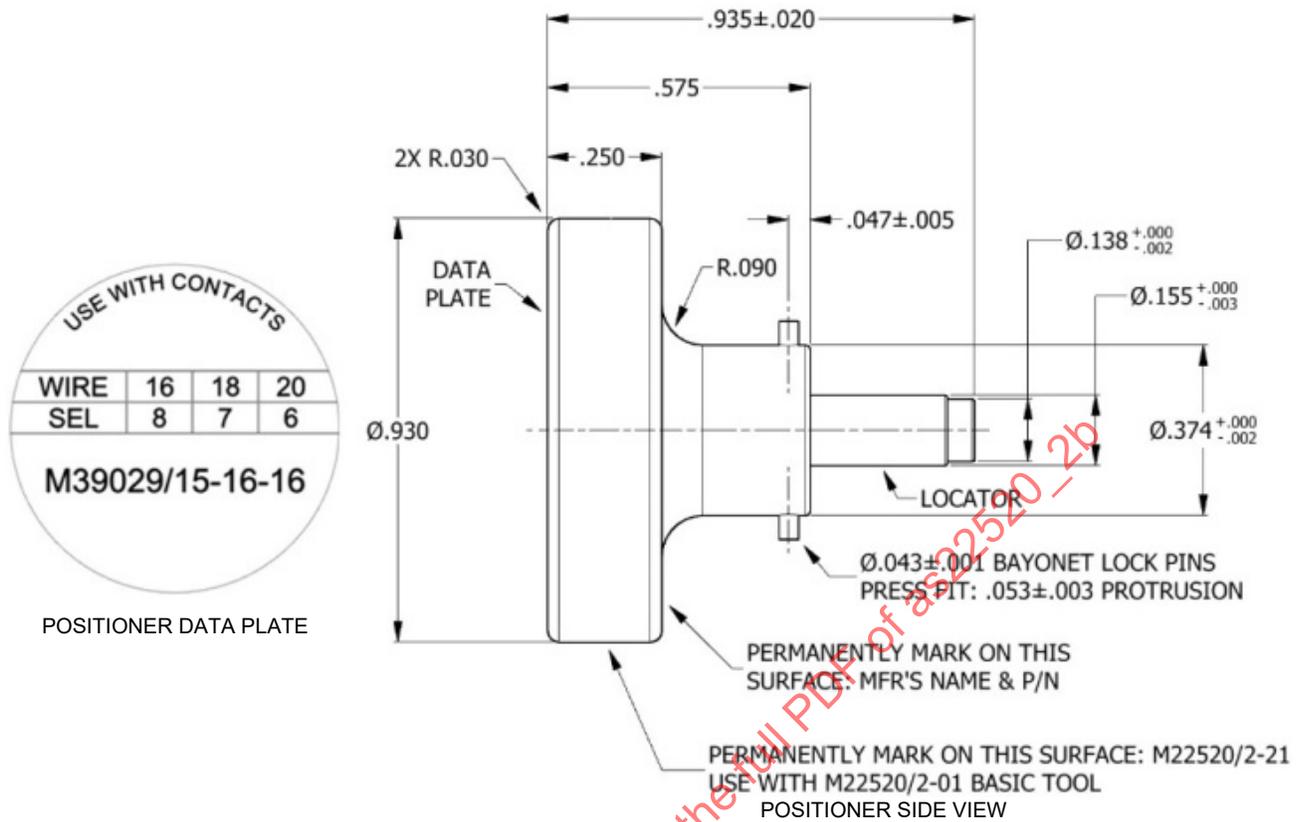
TOOL/POSITIONER SUPERSESSION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-19	M39029/15-22-28, /15-22-22

FIGURE 19 - M22520/2-19 POSITIONER



M22520/2-21 POSITIONER



M22520/2-21 POSITIONER INFORMATION

POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-21	M39029/15-16-16

TOOL/POSITIONER SUPERSESSSION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-21	M39029/15-16-16 1/

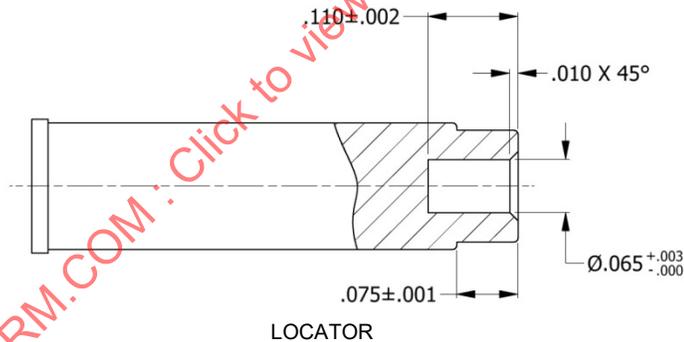
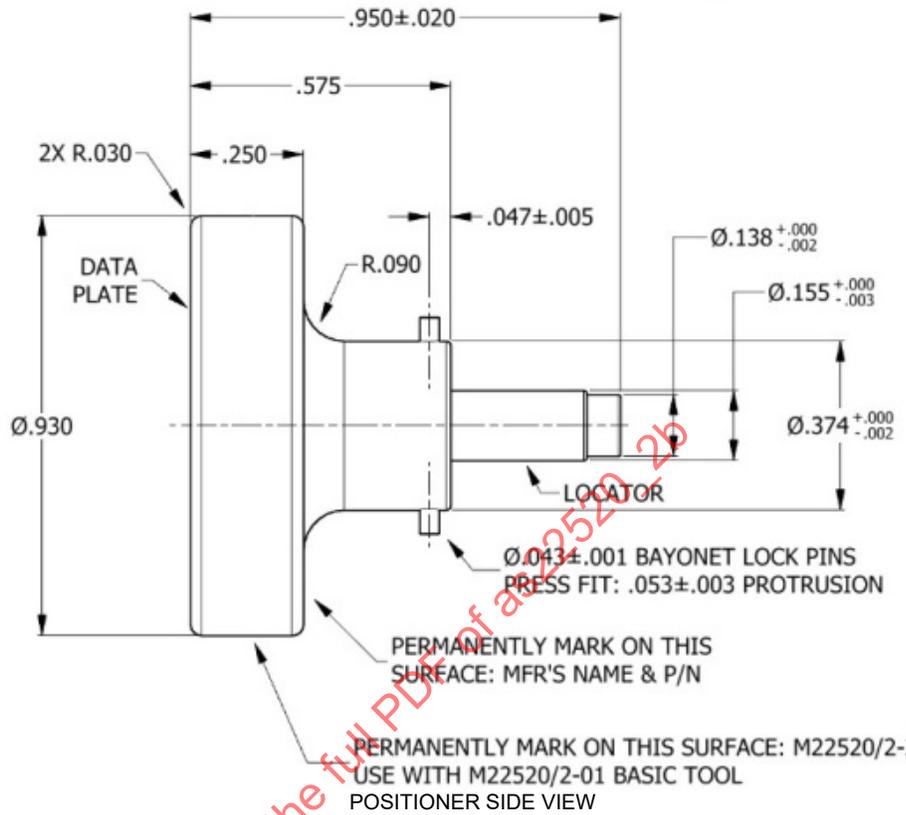
1/ CONTACT CANCELED WITHOUT REPLACEMENT.

FIGURE 21 - M22520/2-21 POSITIONER

M22520/2-22 POSITIONER



POSITIONER DATA PLATE



LOCATOR

M22520/2-22 POSITIONER INFORMATION

POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-22	10215913 (ARMY)

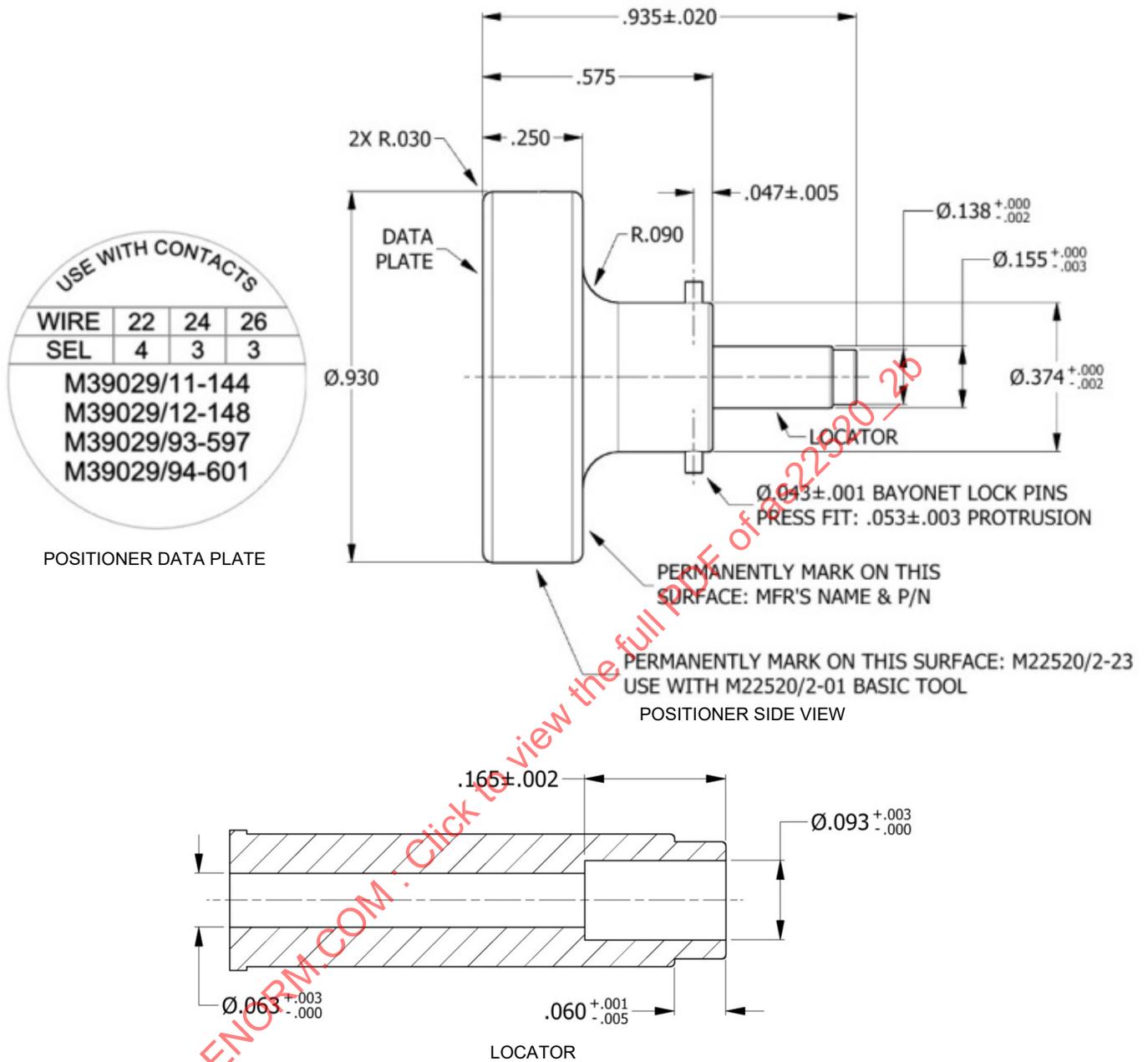
TOOL/POSITIONER SUPERSESSION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-22	UNKNOWN 1/

1/ CONTACT CANCELED WITHOUT REPLACEMENT.

FIGURE 22 - M22520/2-22 POSITIONER

M22520/2-23 POSITIONER



M22520/2-23 POSITIONER INFORMATION

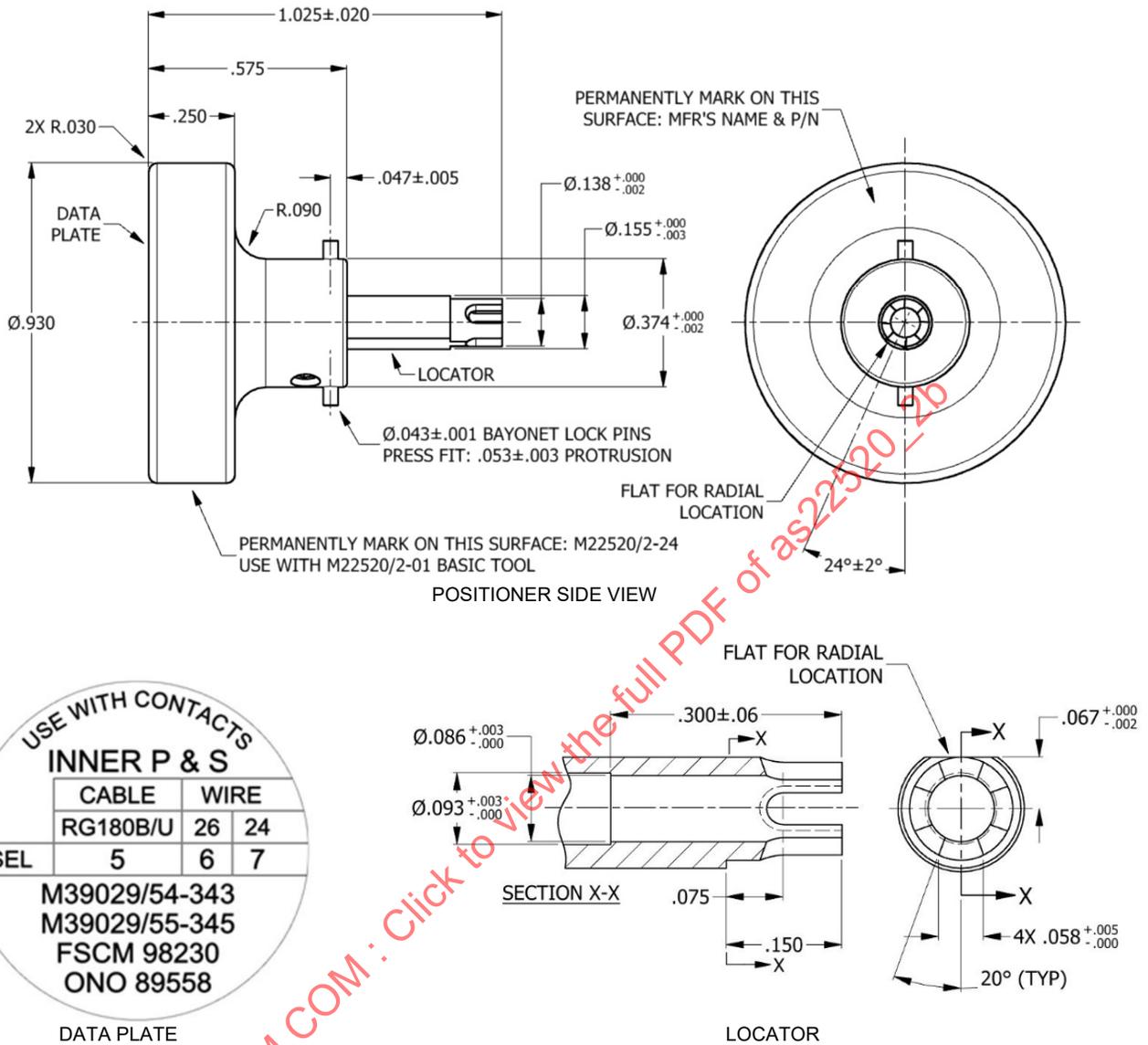
POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-23	M39029/11-144, /12-148, /93-597, /94-601

TOOL/POSITIONER SUPERSESSION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-23	M39029/11-22-22, /12-22-22

FIGURE 23 - M22520/2-23 POSITIONER

M22520/2-24 POSITIONER



M22520/2-24 POSITIONER INFORMATION

POSITIONER PART NO.	CONTACTS ACCOMMODATED
22520/2-24	FSCM 98230, ONO 89558, M39029/54-343, /55-345

TOOL/POSITIONER SUPERSESION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-24	MS27493-22D, -22M, -22, MS27184-20P, MS27185-20S

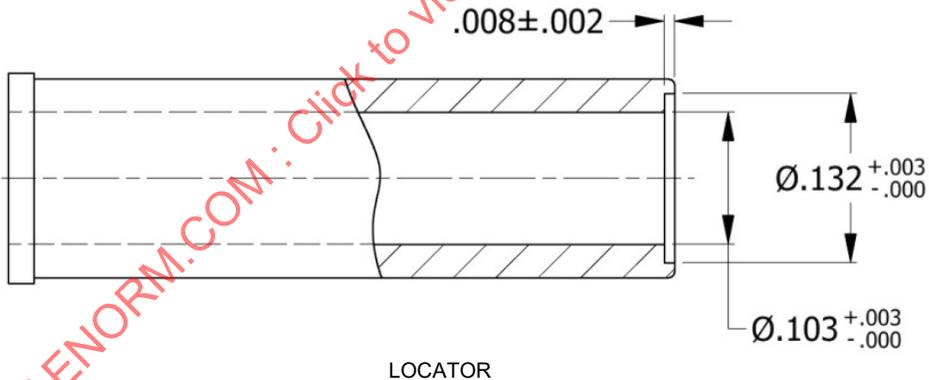
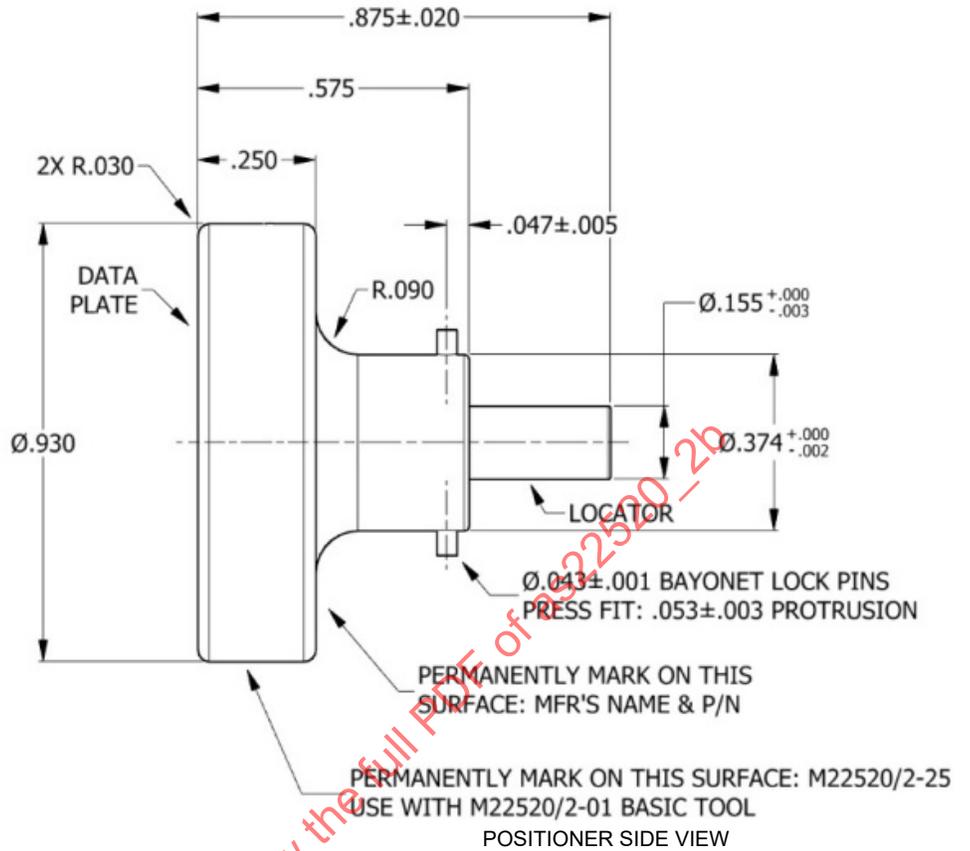
FIGURE 24 - M22520/2-24 POSITIONER

M22520/2-25 POSITIONER

USE WITH CONTACTS  
INNER P & S  
CENTER CONDUCTOR OF

RG179B/U	RG180A/U	RG187A/U	RG195A/U	MICRODOT 293-3922	RAYCHEM 9530D5117	RG188A/U	MICRODOT 250-4070	RAYCHEM 5022E5111
SEL 2	3	5	6					
M39029/6-121 THRU -125								
M39029/13-153 THRU -157								
M39029/14-159 THRU -163								

POSITIONER DATA PLATE



M22520/2-25 POSITIONER INFORMATION

POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-25	M39029/6-121 THROUGH -125, M39029/13-153 THROUGH -157, M39029/14-159 THROUGH -163

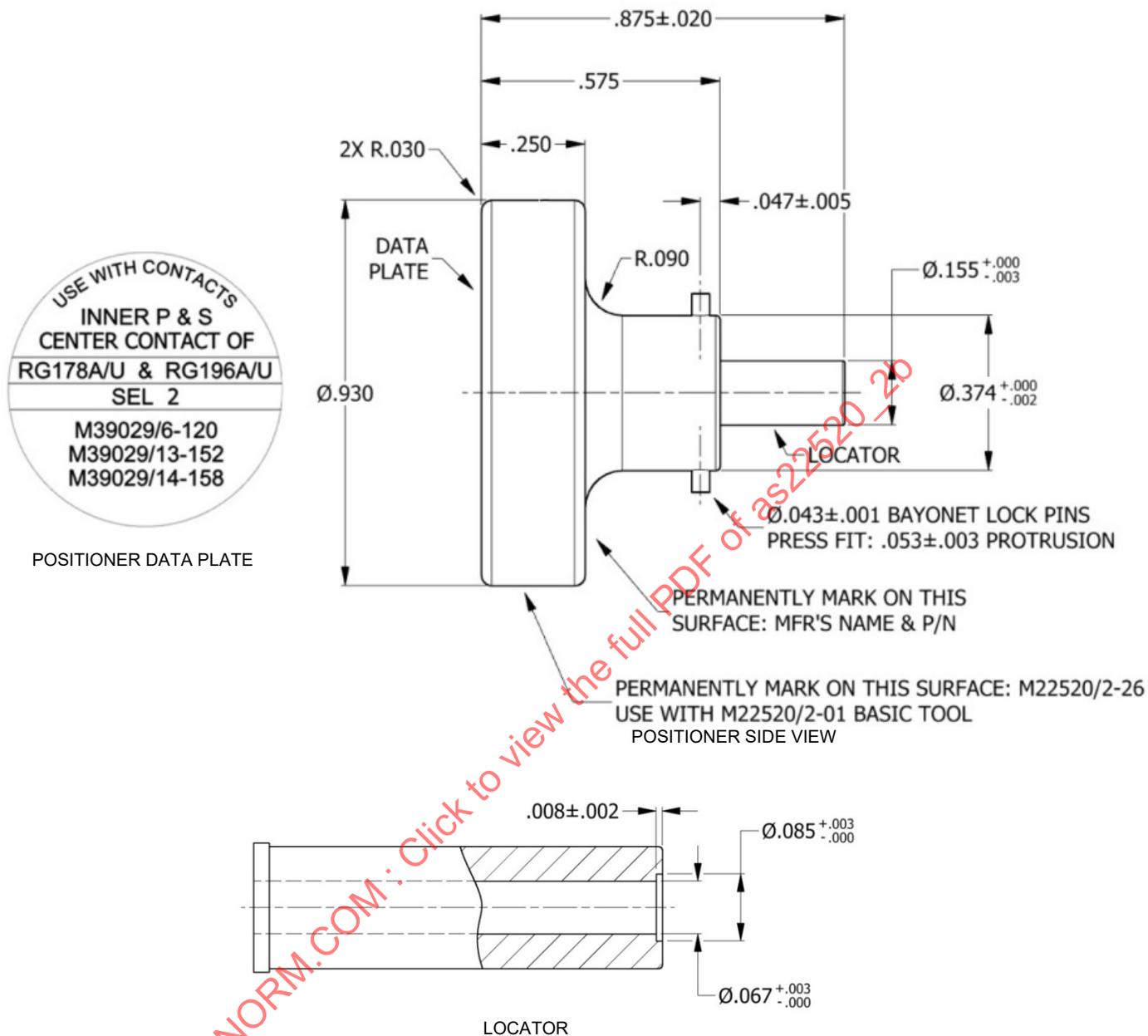
TOOL/POSITIONER SUPERSESION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-25	M39029/6-02 THROUGH -06, /13-02 THROUGH -06, /14-02 THROUGH -06

FIGURE 25 - M22520/2-25 POSITIONER

	<b>AEROSPACE STANDARD</b>	<b>AS22520™/2</b> SHEET 31 OF 49	<b>REV. B</b>
	CRIMPING TOOLS, TYPE 1, TERMINAL, HAND, WIRE TERMINATION FOR WIRE BARREL SIZES 20 THROUGH 28		

M22520/2-26 POSITIONER



M22520/2-26 POSITIONER INFORMATION

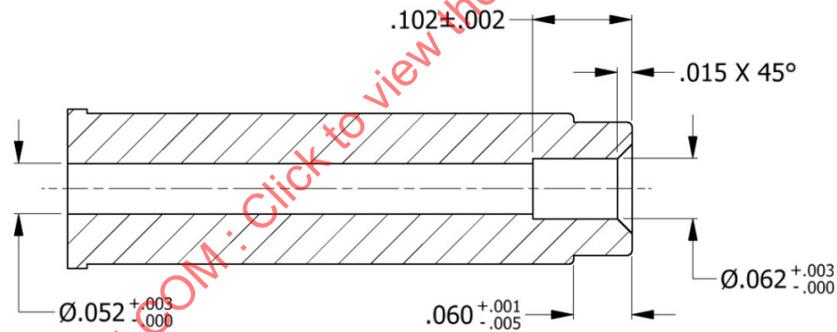
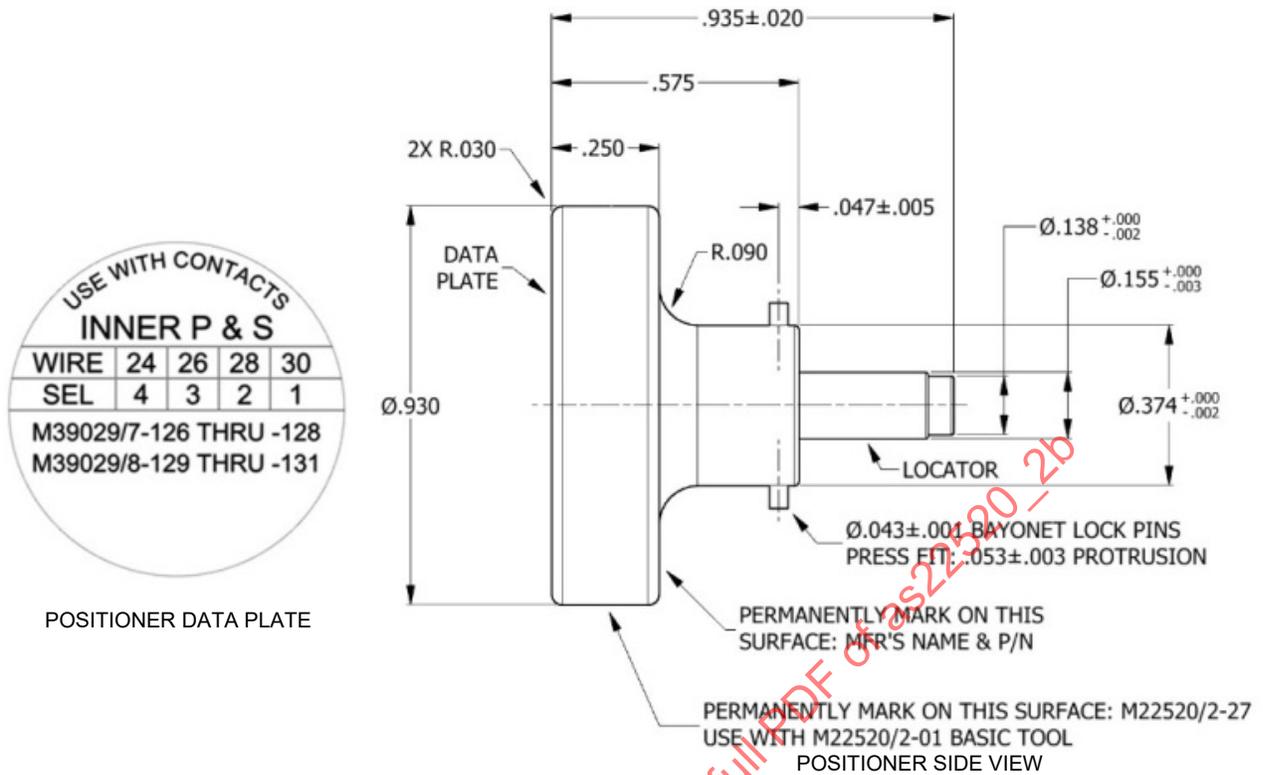
POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-26	M39029/6-120, M39029/13-152, M39029/14-158

TOOL/POSITIONER SUPERSESSION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-26	M39029/6-01, /13-01, /14-01

FIGURE 26 - M22520/2-26 POSITIONER

M22520/2-27 POSITIONER



LOCATOR

M22520/2-27 POSITIONER INFORMATION

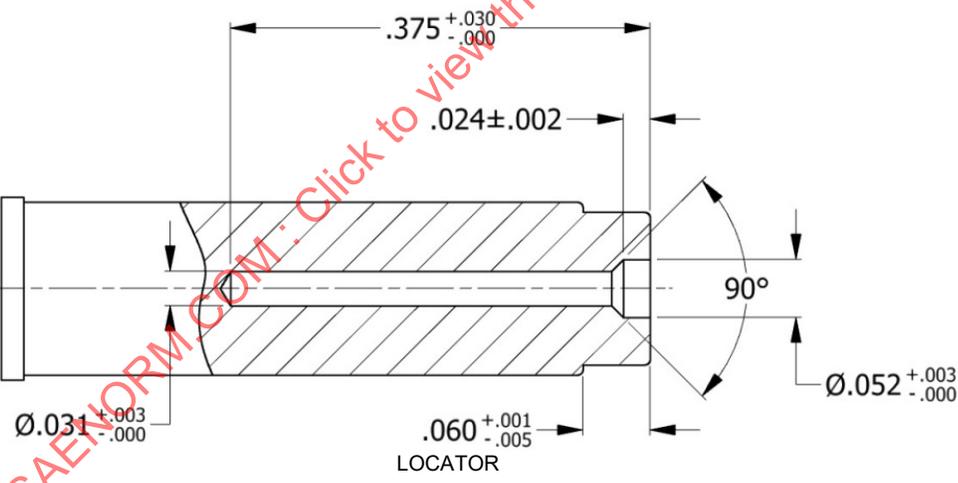
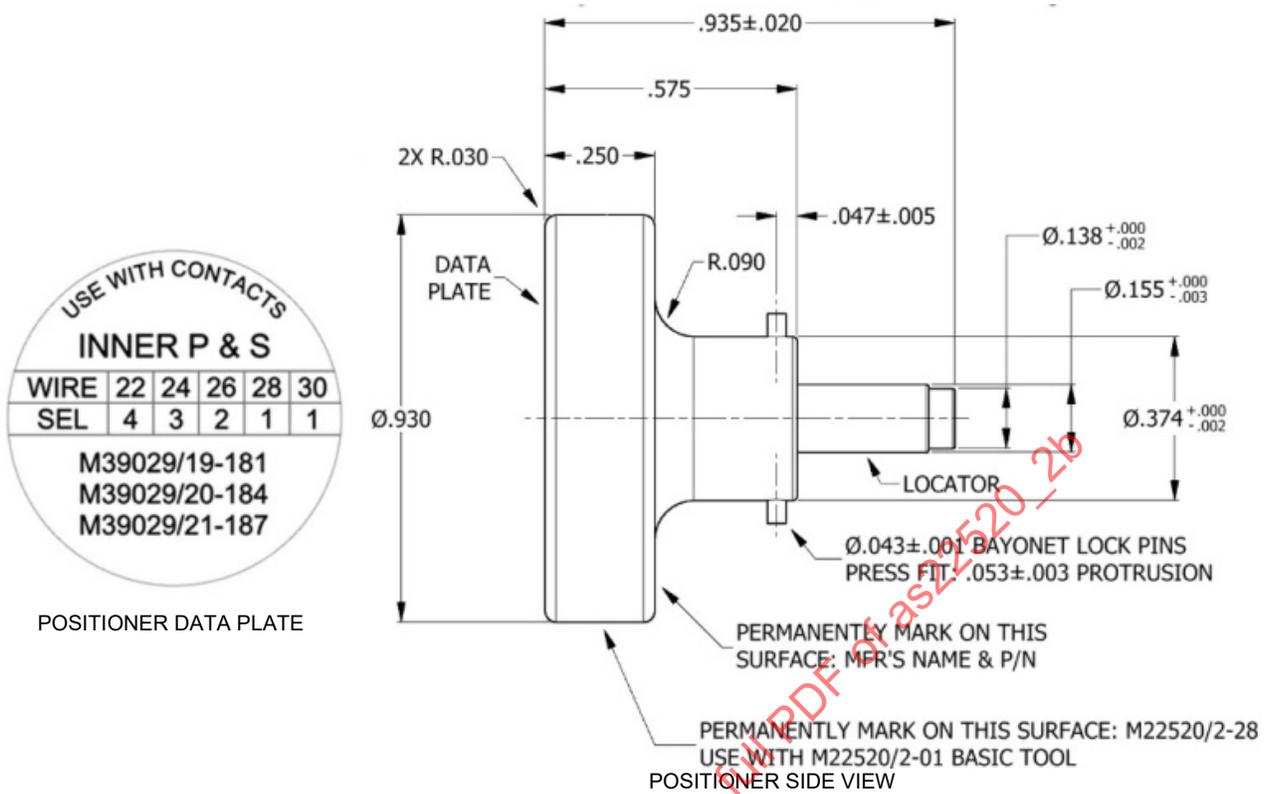
POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-27	M39029/7-126 THROUGH -128, M39029/8-129 THROUGH -131

TOOL/POSITIONER SUPERSESION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-27	M39029/7-001 THROUGH -003, /8-001 THROUGH -003

FIGURE 27 - M22520/2-27 POSITIONER

M22520/2-28 POSITIONER



M22520/2-28 POSITIONER INFORMATION

POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-28	M39029/19-181, M39029/20-184, M39029/21-187

TOOL/POSITIONER SUPERSESION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-28	M39029/19-001, /20-001, /21-001

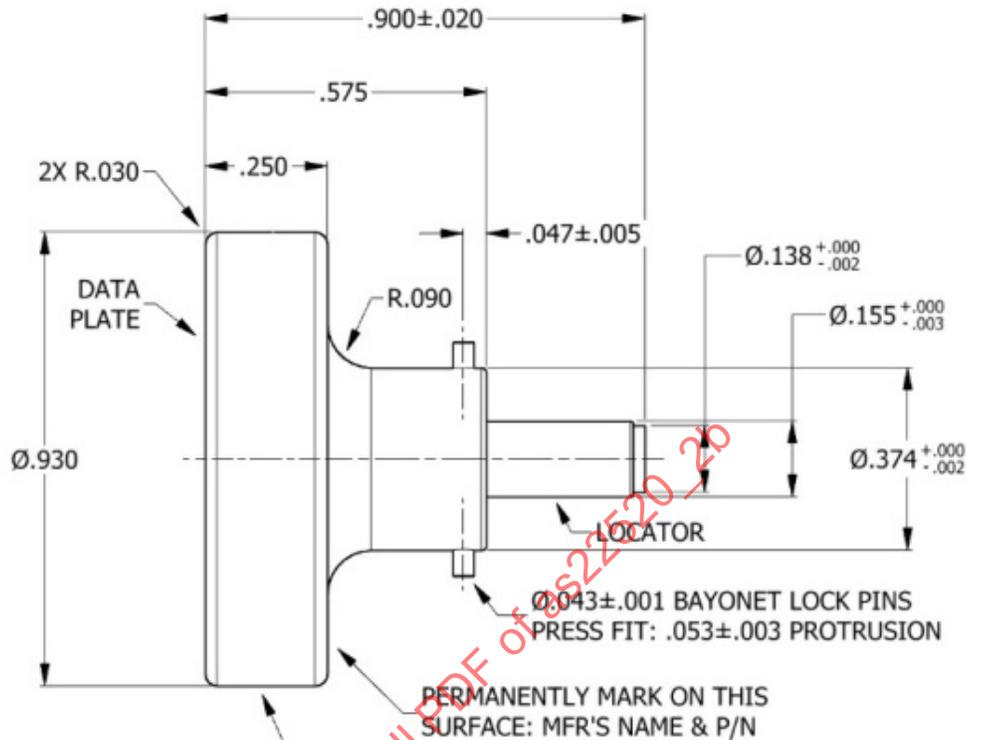
FIGURE 28 - M22520/2-28 POSITIONER

M22520/2-29 POSITIONER

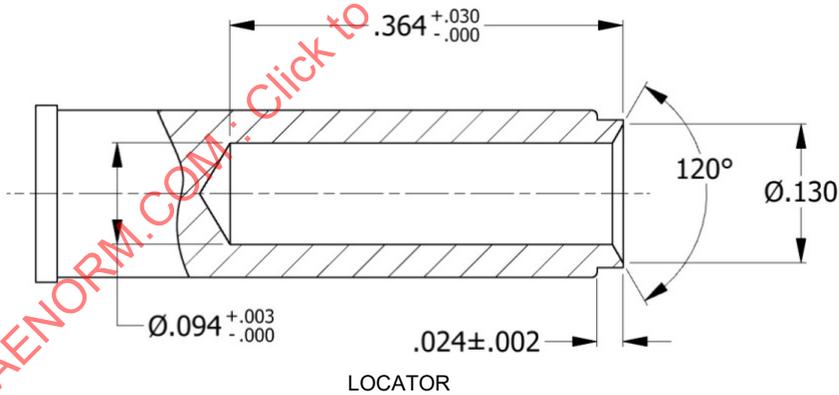
USE WITH CONTACTS  
INNER P & S

WIRE	22	24	26	28	30
SEL	4	3	2	1	1
M39029/19-182, -183					
M39029/20-185, -186					
M39029/21-188, -189					

POSITIONER DATA PLATE



PERMANENTLY MARK ON THIS SURFACE: M22520/2-29  
USE WITH M22520/2-01 BASIC TOOL  
POSITIONER SIDE VIEW



LOCATOR

M22520/2-29 POSITIONER INFORMATION

POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-29	M39029/19-182 & -183, M39029/20-185 & -186, M39029/21-188 & -189

TOOL/POSITIONER SUPERSESION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-29	M39029/19-002 & -003, /20-002 & -003, /21-002 & -003

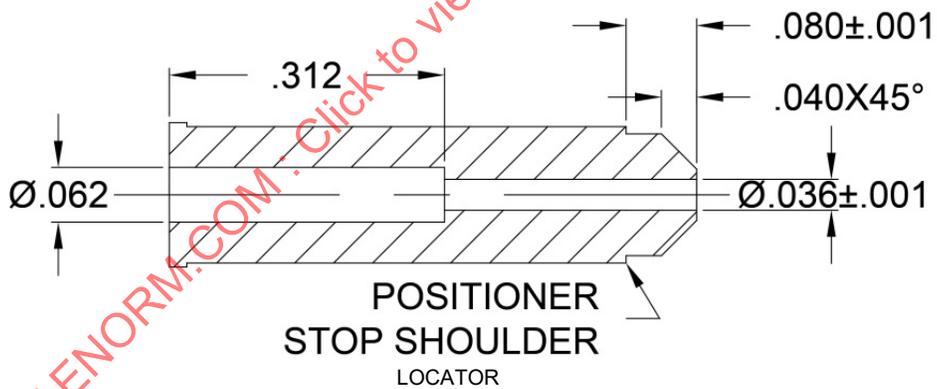
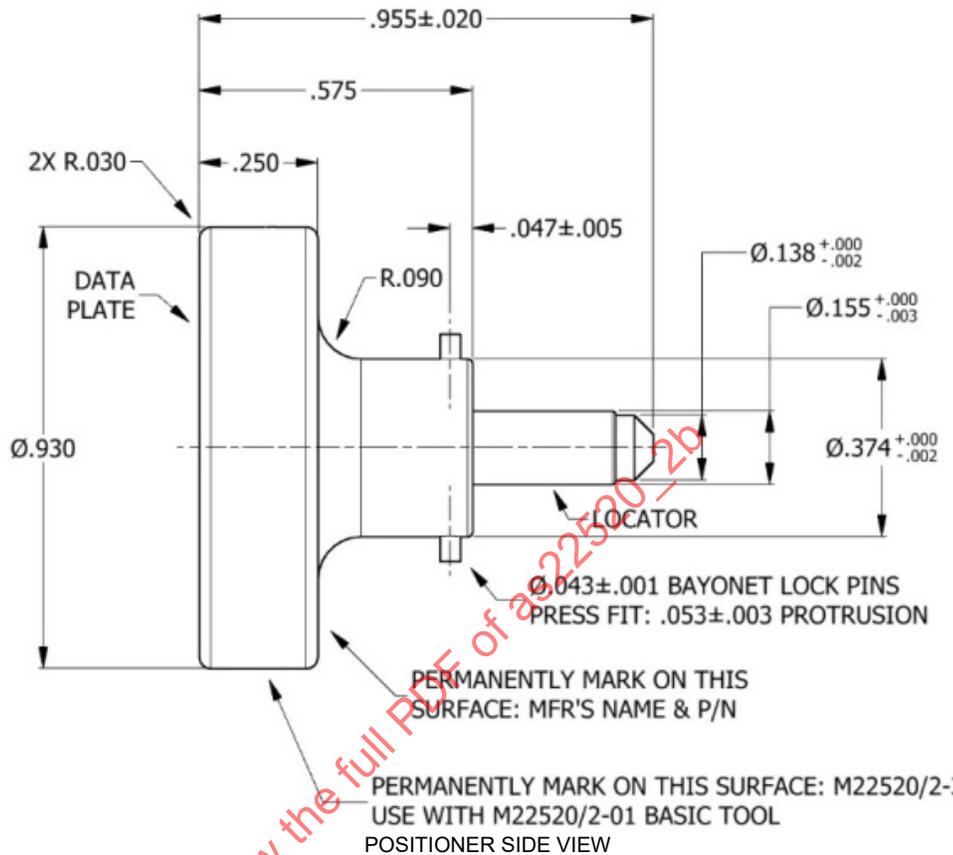
FIGURE 29 - M22520/2-29 POSITIONER

	<b>AEROSPACE STANDARD</b>	<b>AS22520™/2</b> SHEET 35 OF 49	<b>REV. B</b>
	CRIMPING TOOLS, TYPE 1, TERMINAL, HAND, WIRE TERMINATION FOR WIRE BARREL SIZES 20 THROUGH 28		

M22520/2-30 POSITIONER



POSITIONER DATA PLATE



M22520/2-30 POSITIONER INFORMATION

POSITIONER PART NO.	CONTACTS ACCOMMODATED (INNER CONTACTS ONLY)
M22520/2-30	M39029/50-340, M39029/51-341

TOOL/POSITIONER SUPERSESION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-30	M83733/13-12, /14-12

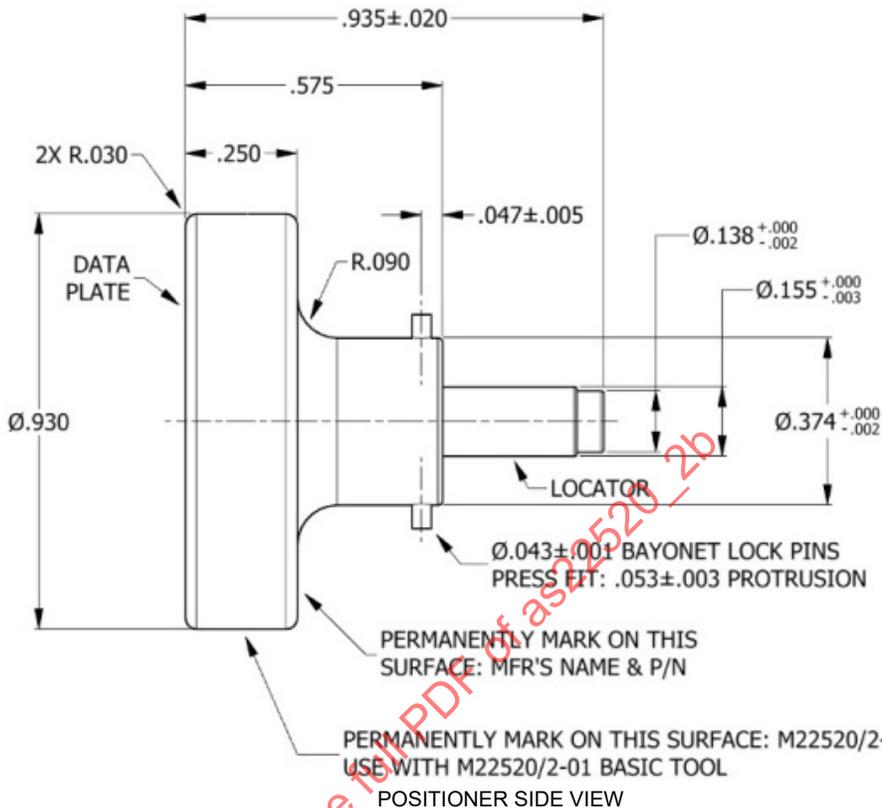
FIGURE 30 - M22520/2-30 POSITIONER

	<b>AEROSPACE STANDARD</b>	<b>AS22520™/2</b> SHEET 36 OF 49	<b>REV.</b> <b>B</b>
	CRIMPING TOOLS, TYPE 1, TERMINAL, HAND, WIRE TERMINATION FOR WIRE BARREL SIZES 20 THROUGH 28		

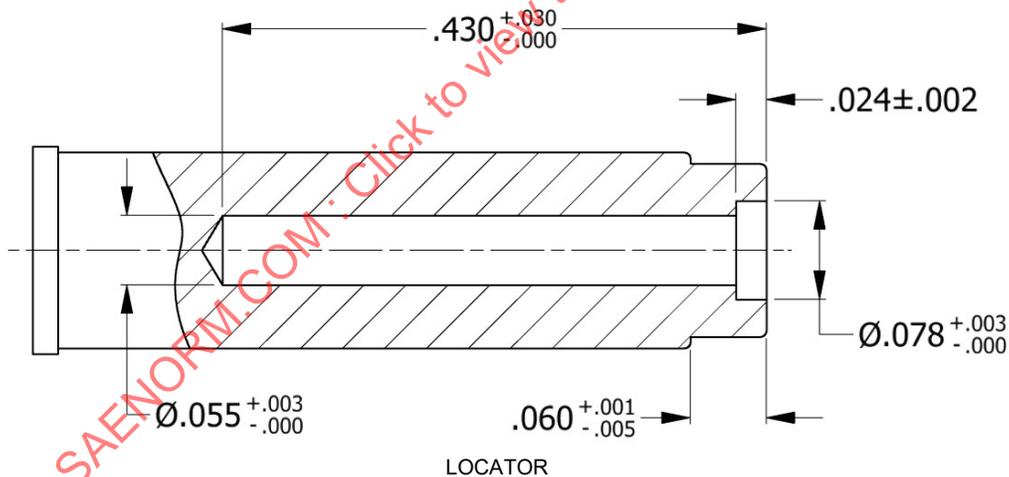
M22520/2-31 POSITIONER



POSITIONER DATA PLATE



POSITIONER SIDE VIEW



LOCATOR

M22520/2-31 POSITIONER INFORMATION

POSITIONER PART NO. M22520/2-31	CONTACTS ACCOMMODATED M39029/59-366, M39029/60-367
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TOOL/POSITIONER SUPERSESSSION INFORMATION

POSITIONER PART NO. M22520/2-31	SUPERSEDED OBSOLETE CONTACT PART NO. MS27535, MS27536
------------------------------------	--

FIGURE 31 - M22520/2-31 POSITIONER

	<b>AEROSPACE STANDARD</b>	<b>AS22520™/2</b> SHEET 37 OF 49	<b>REV.</b> <b>B</b>
	CRIMPING TOOLS, TYPE 1, TERMINAL, HAND, WIRE TERMINATION FOR WIRE BARREL SIZES 20 THROUGH 28		

M22520/2-32 POSITIONER

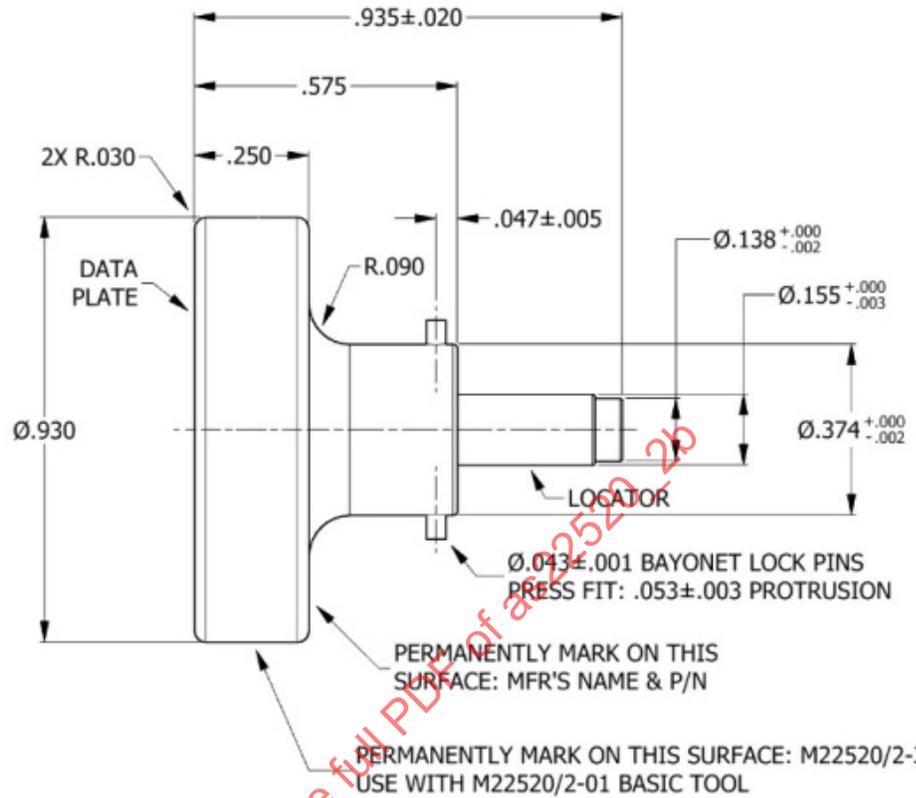
USE WITH CONTACTS  
M39029/1-507

WIRE	22	24	26	28
SEL	4	3	2	1

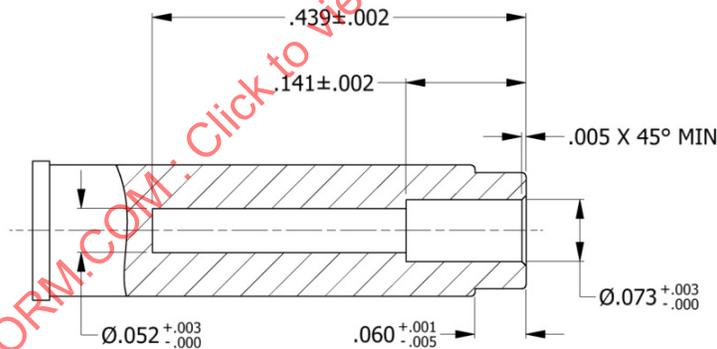
INNER P & S: M39029

/25	-204	-205	-206
/26	-207	-208	-209
SEL	4	4	7

POSITIONER DATA PLATE



POSITIONER SIDE VIEW



LOCATOR

M22520/2-32 POSITIONER INFORMATION

POSITIONER PART NO.	CONTACTS ACCOMMODATED
M22520/2-32	M39029/1-507, /25-204 THROUGH -206, /26-207 THROUGH -209

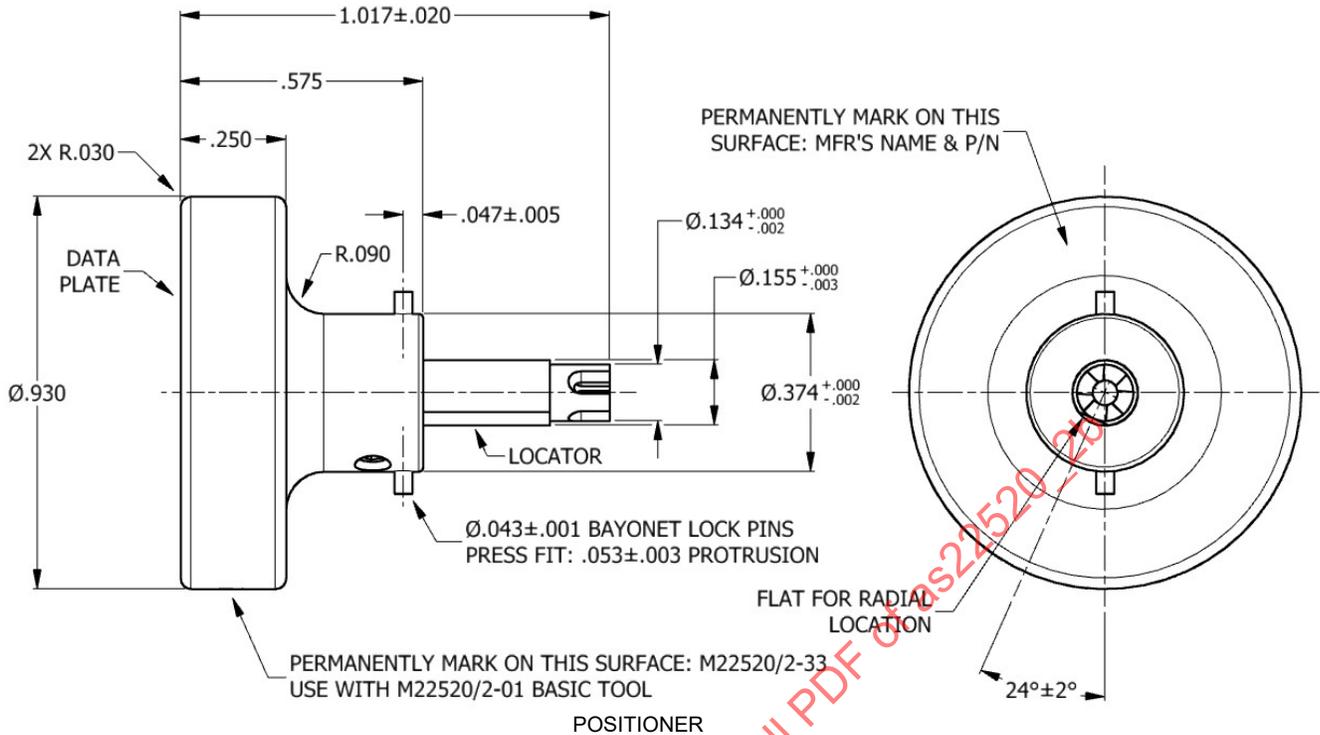
TOOL/POSITIONER SUPERSESION INFORMATION

POSITIONER PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-32	M29029/25-01 THROUGH -03, /26-01 THROUGH -03

FIGURE 32 - M22520/2-32 POSITIONER

	<b>AEROSPACE STANDARD</b>	<b>AS22520™/2</b> SHEET 38 OF 49	<b>REV.</b> <b>B</b>
	CRIMPING TOOLS, TYPE 1, TERMINAL, HAND, WIRE TERMINATION FOR WIRE BARREL SIZES 20 THROUGH 28		

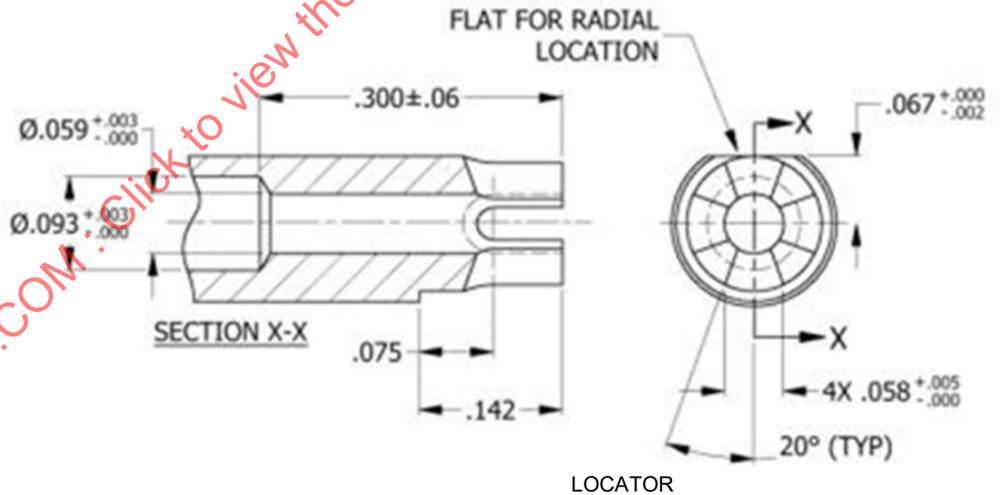
M22520/2-33 POSITIONER



USE WITH CONTACTS  
INNER P & S

WIRE	CABLE		
22	RG 178B/U	RG174A/U RG188A/U RG195A/U	
3	1	2	SEL
M39029/54-342			
M39029/55-344			

POSITIONER DATA PLATE



LOCATOR

M22520/2-33 POSITIONER INFORMATION

TOOL PART NO.	CONTACTS ACCOMMODATED
M22520/2-33	M39029/54-342, M39029/55-344

TOOL/POSITIONER SUPERSESION INFORMATION

PART NO.	SUPERSEDED OBSOLETE CONTACT PART NO.
M22520/2-33	MS27184-22P, -20P, MS27185-22S, -20S, MS27450-22S, -20S

FIGURE 33 - M22520/2-33 POSITIONER

	<b>AEROSPACE STANDARD</b> CRIMPING TOOLS, TYPE 1, TERMINAL, HAND, WIRE TERMINATION FOR WIRE BARREL SIZES 20 THROUGH 28	<b>AS22520™/2</b> SHEET 39 OF 49	<b>REV.</b> <b>B</b>