

REV.
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AS22520™/38

FEDERAL SUPPLY CLASS
5120

RATIONALE

FULL REVISION REQUIRED TO ADD TOOLS THAT PREVENTS CRACKING OF CRIMP BARREL SEAM.

NOTICE

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

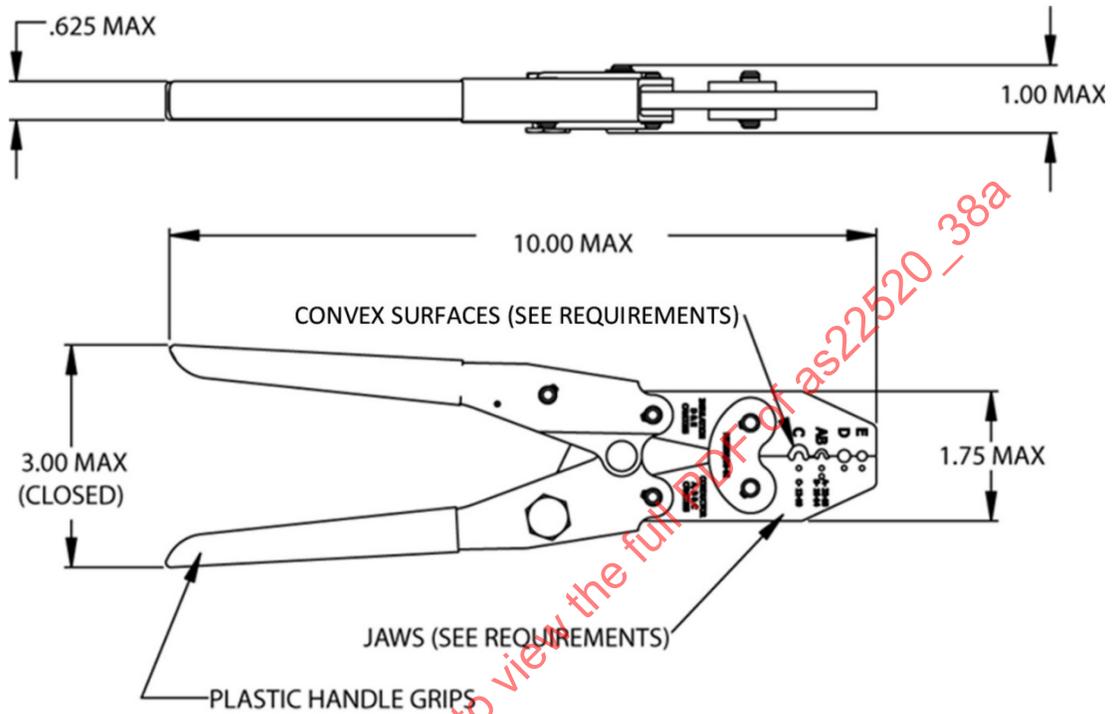
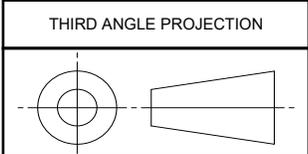


FIGURE 1 - M22520/38-01 CRIMPING TOOL

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CUSTODIAN: AE-8C2

PROCUREMENT SPECIFICATION: AS22520



AEROSPACE STANDARD

(R) CRIMPING TOOL, TERMINAL, HAND ACTUATED,
WIRE TERMINATION, TYPE II, FOR EXTERNAL
POWER PLUG SOCKET CONTACTS AND LUG
TERMINAL SIZES 22-10

AS22520™/38
SHEET 1 OF 10

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ISSUED 2011-10 REAFFIRMED 2016-11 REVISED 2023-08

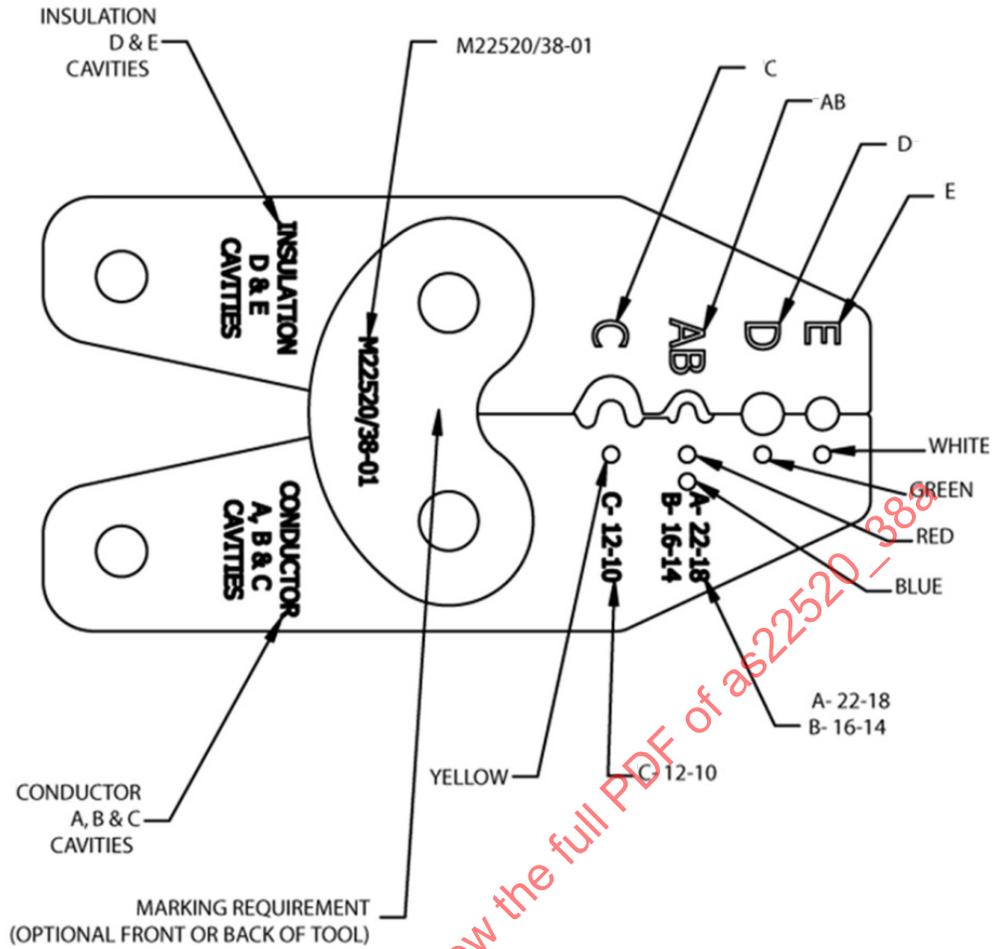


FIGURE 2 - M22520/38-01 CRIMPING TOOL MARKING REQUIREMENTS

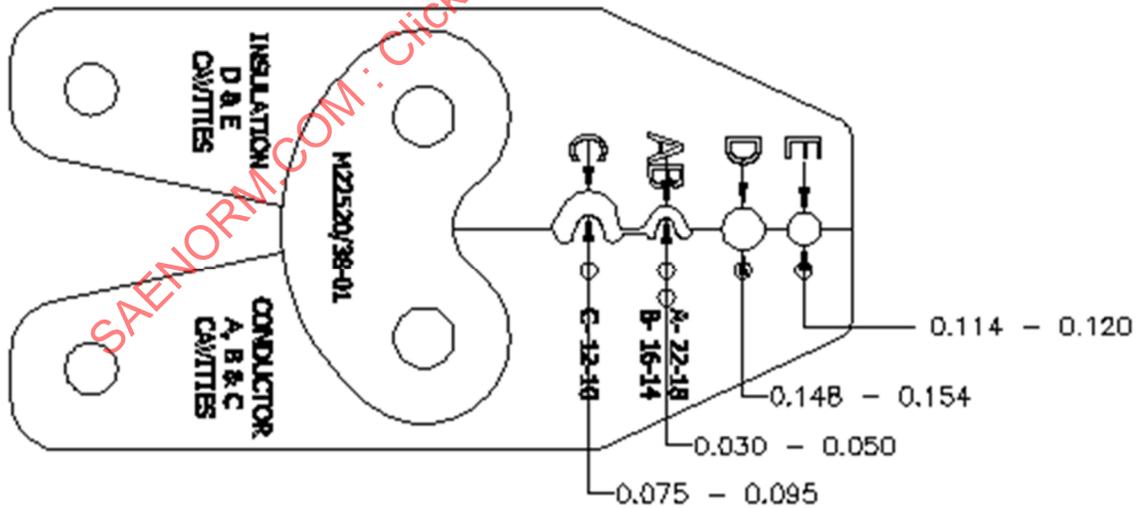


FIGURE 3 - M22520/38-01 CRIMPING TOOL CRIMP CAVITY DIMENSIONS

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	(R) CRIMPING TOOL, TERMINAL, HAND ACTUATED, WIRE TERMINATION, TYPE II, FOR EXTERNAL POWER PLUG SOCKET CONTACTS AND LUG TERMINAL SIZES 22-10		

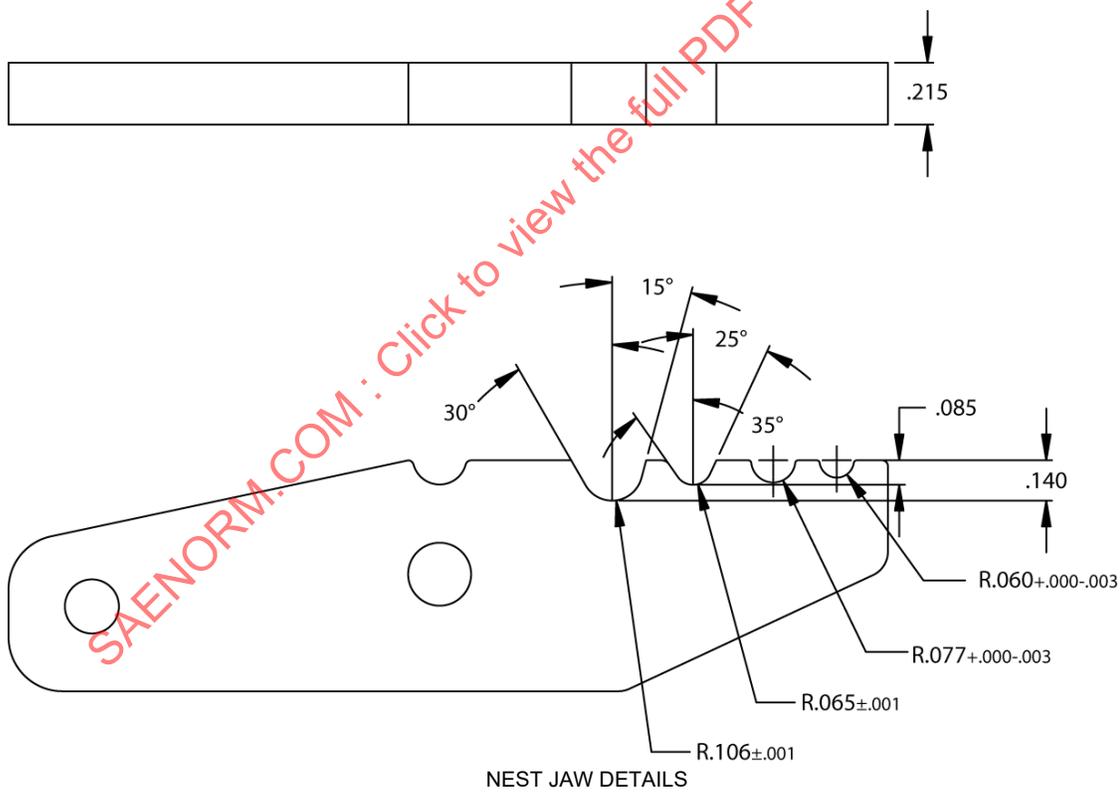
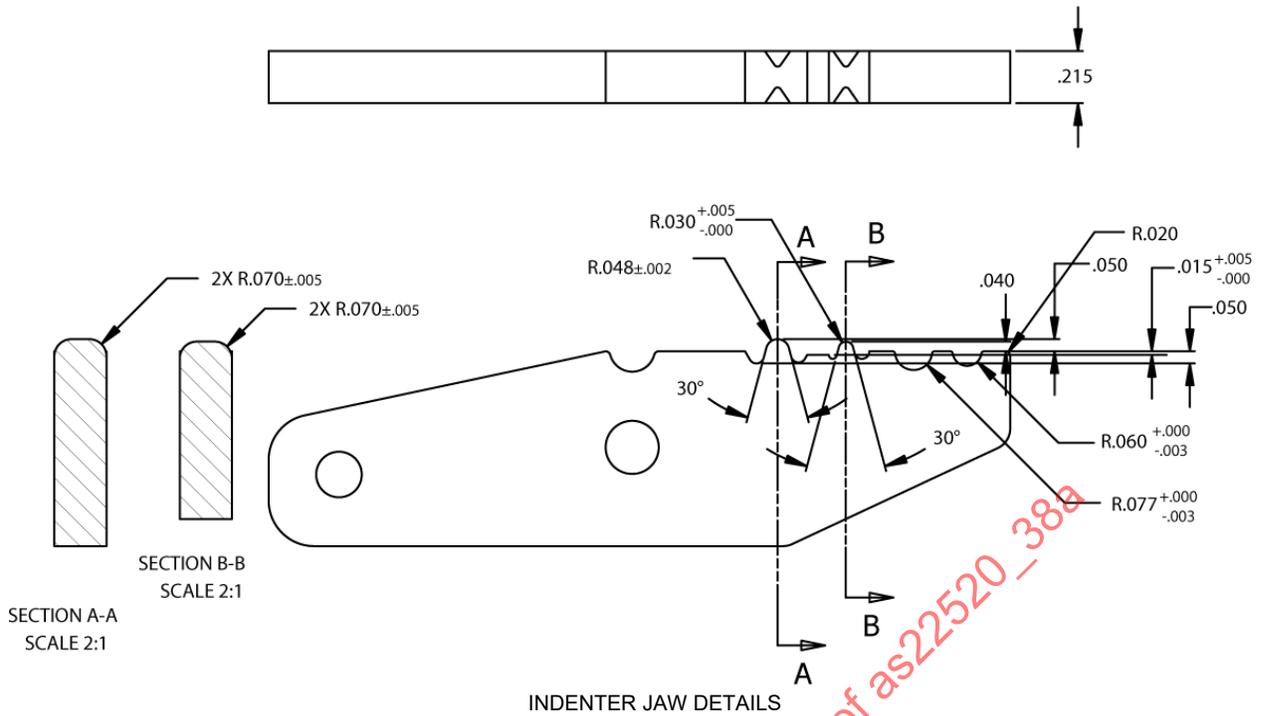


FIGURE 4 - M22520/38-01 CRIMPING TOOL JAW CONFIGURATION

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	(R) CRIMPING TOOL, TERMINAL, HAND ACTUATED, WIRE TERMINATION, TYPE II, FOR EXTERNAL POWER PLUG SOCKET CONTACTS AND LUG TERMINAL SIZES 22-10		

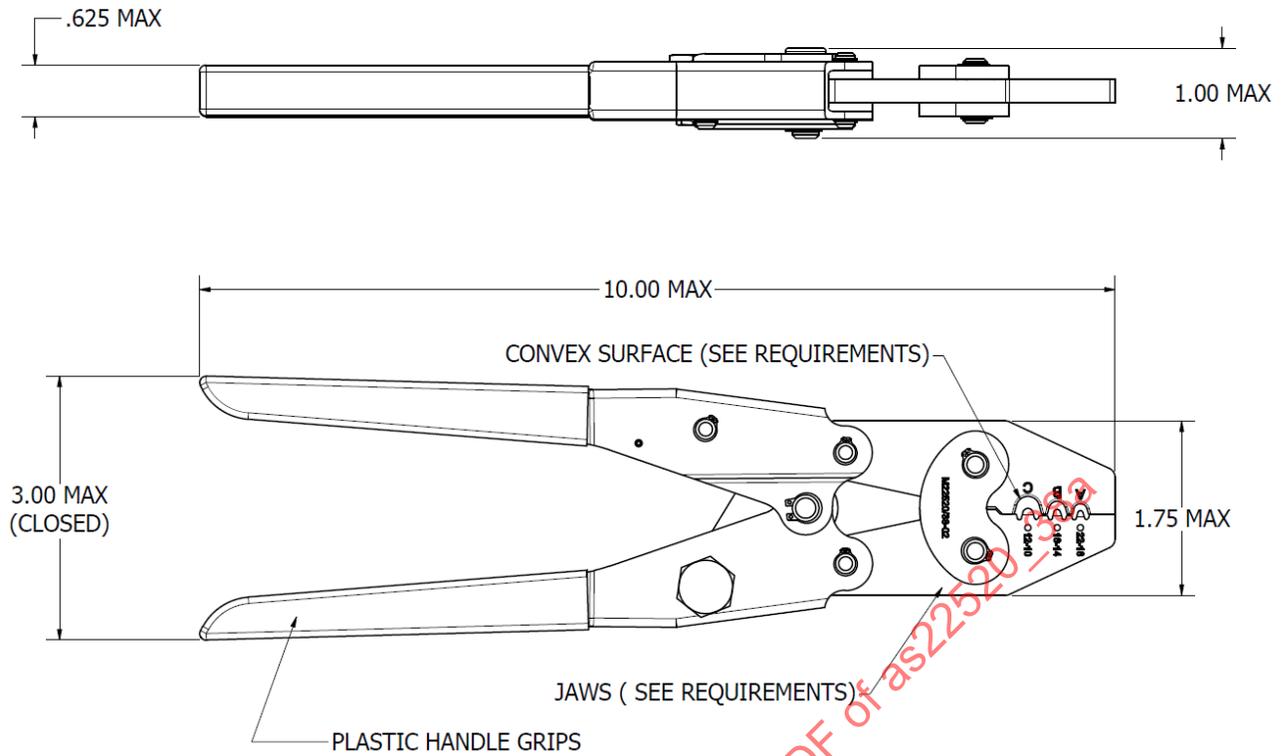


FIGURE 5 - M22520/38-02 TOOL

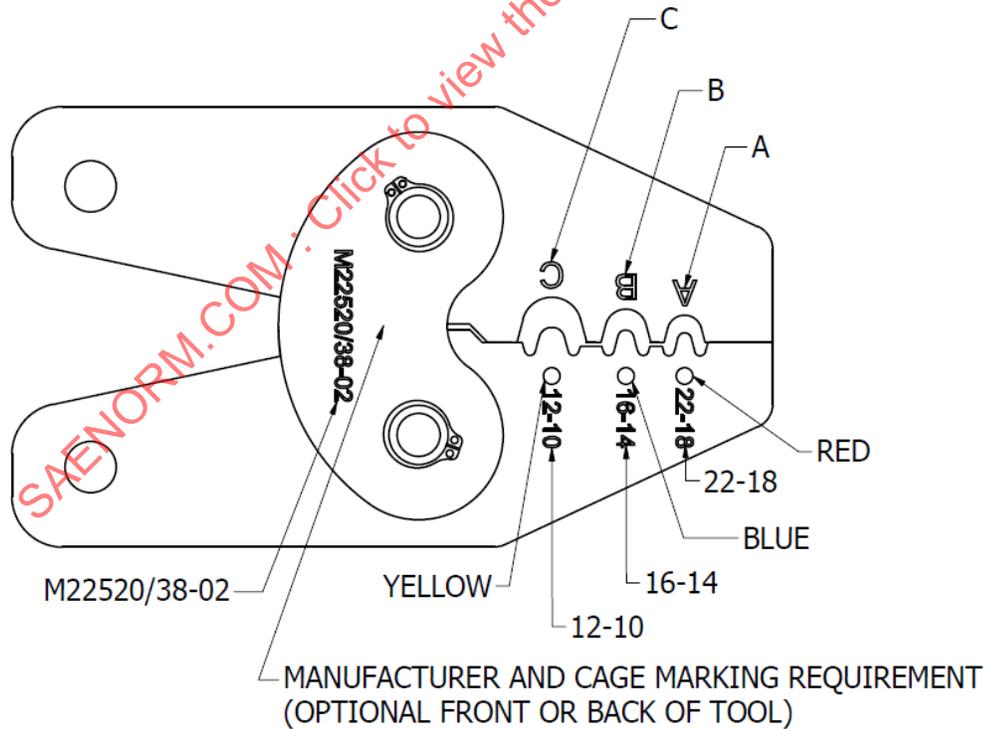


FIGURE 6 - M22520/38-02 TOOL MARKING REQUIREMENTS

	AEROSPACE STANDARD (R) CRIMPING TOOL, TERMINAL, HAND ACTUATED, WIRE TERMINATION, TYPE II, FOR EXTERNAL POWER PLUG SOCKET CONTACTS AND LUG TERMINAL SIZES 22-10	AS22520™/38 SHEET 4 OF 10	REV. A

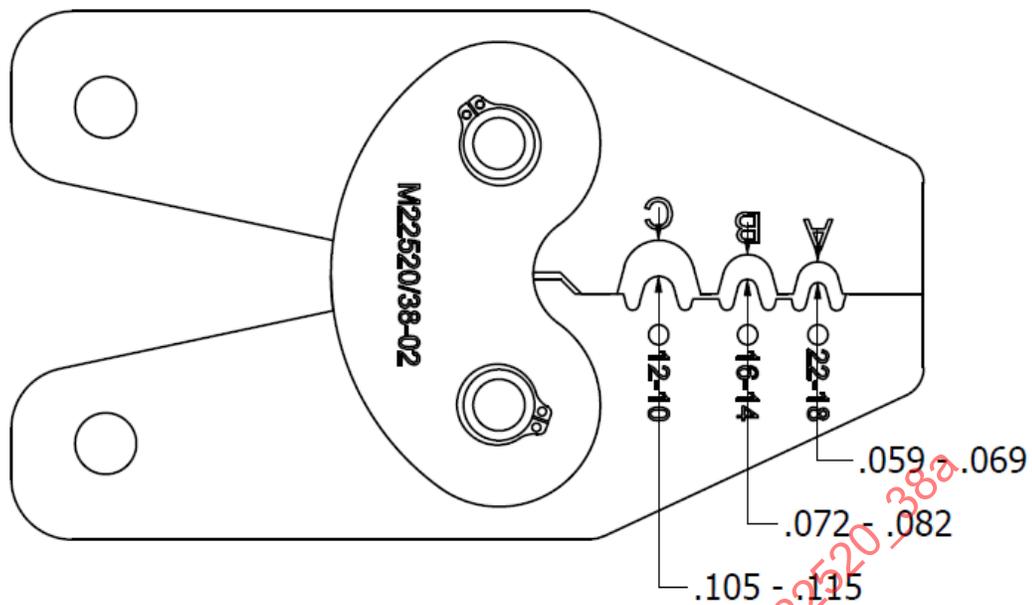


FIGURE 7 - M22520/38-02 TOOL CRIMP CAVITY DIMENSIONS

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	(R) CRIMPING TOOL, TERMINAL, HAND ACTUATED, WIRE TERMINATION, TYPE II, FOR EXTERNAL POWER PLUG SOCKET CONTACTS AND LUG TERMINAL SIZES 22-10		

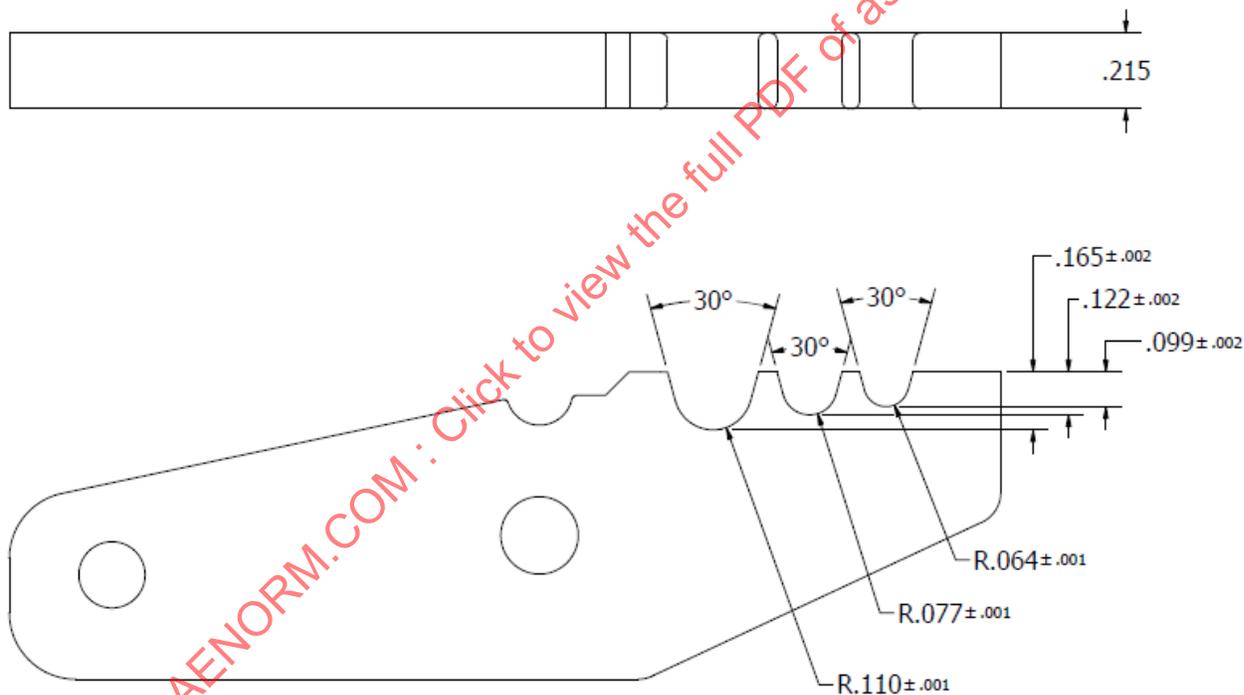
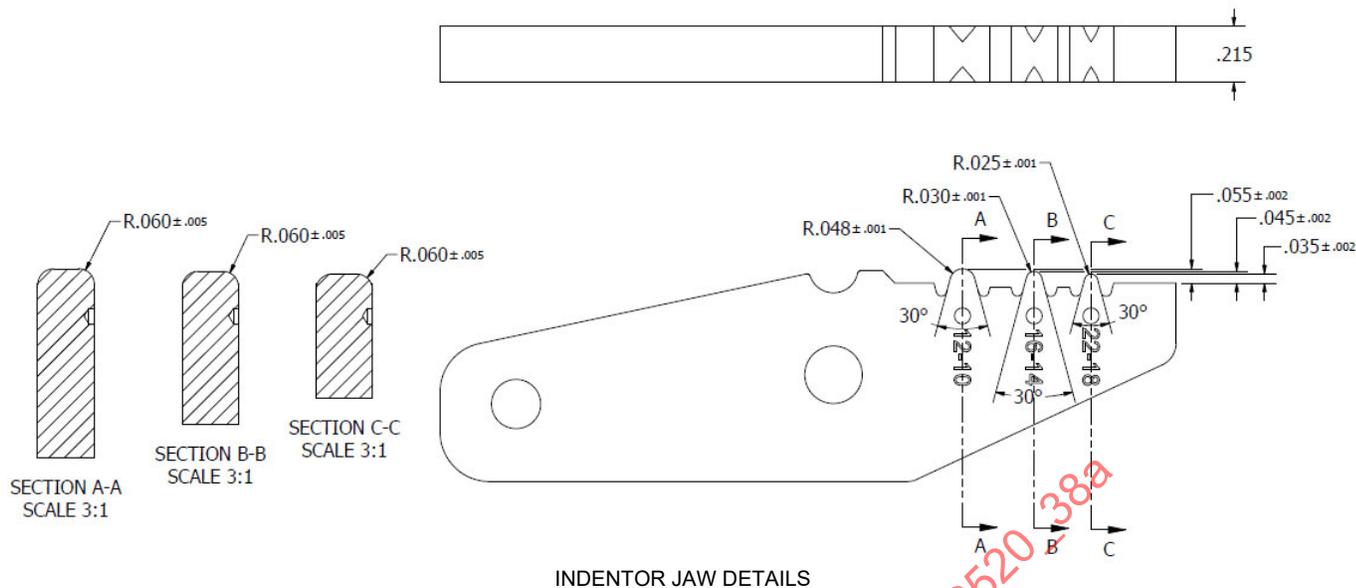


FIGURE 8 - M22520/38-02 TOOL JAW CONFIGURATION

	AEROSPACE STANDARD (R) CRIMPING TOOL, TERMINAL, HAND ACTUATED, WIRE TERMINATION, TYPE II, FOR EXTERNAL POWER PLUG SOCKET CONTACTS AND LUG TERMINAL SIZES 22-10	AS22520™/38 SHEET 6 OF 10	REV. A

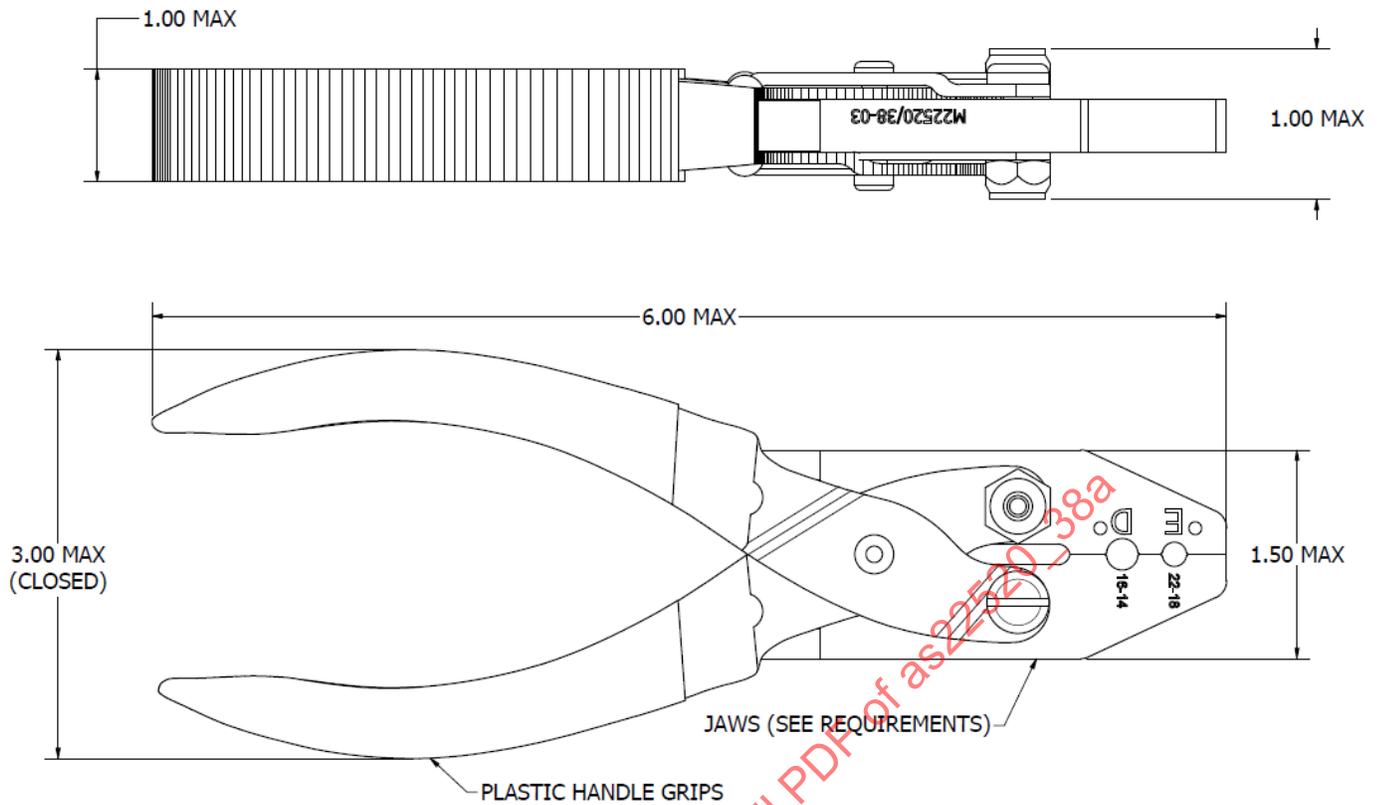


FIGURE 9 - M22520/38-03 WIRE INSULATION GRIP CRIMPING TOOL

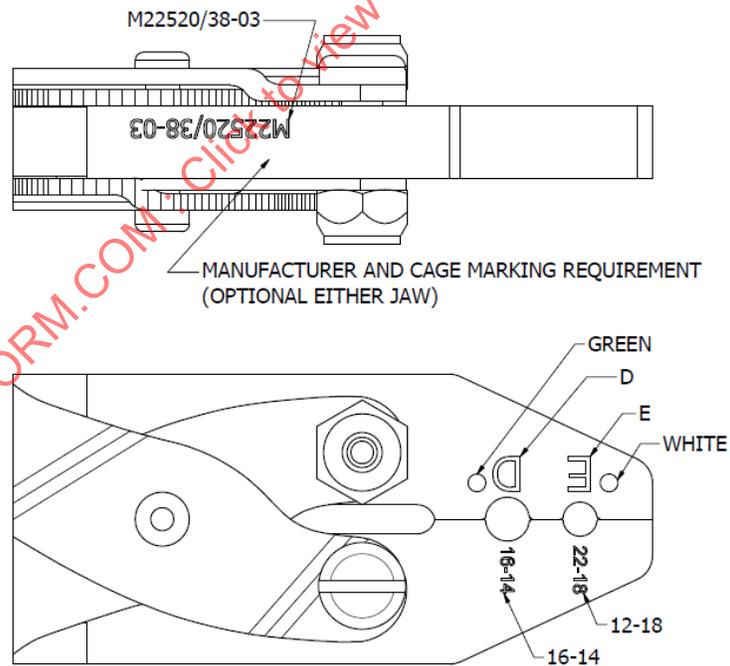


FIGURE 10 - M22520/38-03 TOOL MARKING REQUIREMENTS

	AEROSPACE STANDARD	AS22520™/38 SHEET 7 OF 10	REV. A
	(R) CRIMPING TOOL, TERMINAL, HAND ACTUATED, WIRE TERMINATION, TYPE II, FOR EXTERNAL POWER PLUG SOCKET CONTACTS AND LUG TERMINAL SIZES 22-10		

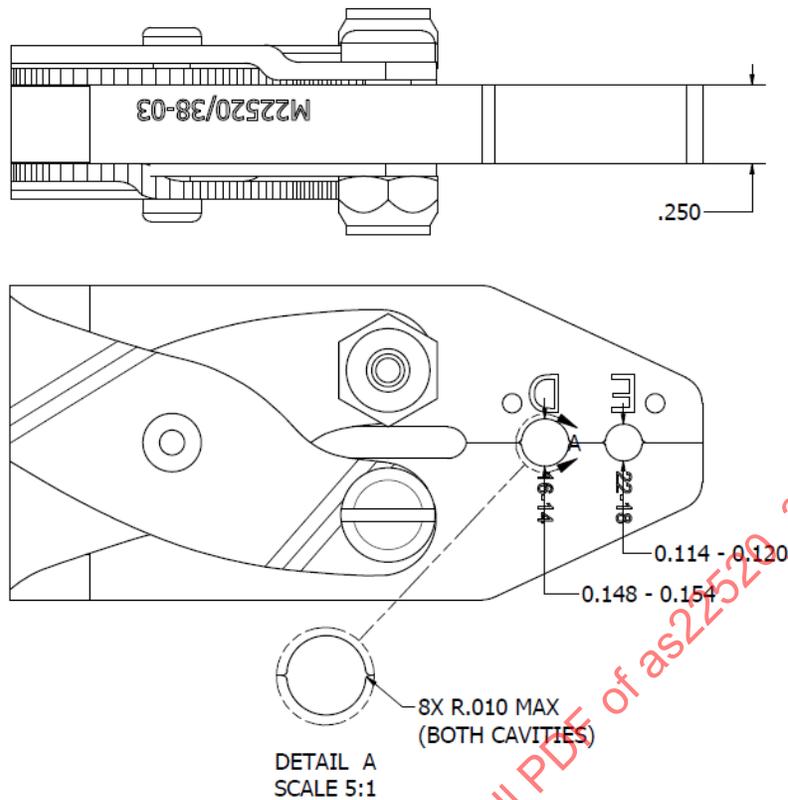


FIGURE 11 - M22520/38-03 TOOL CRIMP CAVITY DIMENSIONS

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

1. DIMENSIONS:

TOOL CONFIGURATION SHALL BE IN ACCORDANCE WITH FIGURES 1-11. DIMENSIONS ARE INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES ARE ± 0.010 (0.25 MM) FOR THREE PLACE DECIMALS AND $\pm 5^\circ$ FOR ANGLES. OUTLINE CONFIGURATION OPTIONAL WITHIN MAXIMUM DIMENSIONS SHOWN FOR A CLOSED HANDLE POSITION.

2. MATERIALS:

JAWS SHALL BE 50 POINT CARBON MINIMUM ALLOY STEEL HEAT TREAT ROCKWELL C 43-54 OR EQUIVALENT.

HANDLES SHALL BE STEEL OR EQUIVALENT.

GRIPS SHALL PLASTIC, RUBBER, OR EQUIVALENT (COLOR RED).

3. FINISH:

JAWS AND LINK SHALL BE BLACK OXIDE OR EQUIVALENT.

HANDLES SHALL BE NICKEL OR CHROME PLATING COMMERCIAL GRADE OR EQUIVALENT.

CONVEX CRIMP SURFACES SHALL BE POLISHED TO 16 MICROINCHES (RMS) FINISH.

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	<small>(R) CRIMPING TOOL, TERMINAL, HAND ACTUATED, WIRE TERMINATION, TYPE II, FOR EXTERNAL POWER PLUG SOCKET CONTACTS AND LUG TERMINAL SIZES 22-10</small>		