

REV. A

SAE AS22520/3

FEDERAL SUPPLY CLASS
5220

RATIONALE

LIMIT SCOPE REVISION REQUIRED TO CORRECT FINISH THICKNESS

NOTICE

THE REQUIREMENTS FOR PROCURING THE CONTACTS DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION AND THE LATEST ISSUE OF SAE AS22520

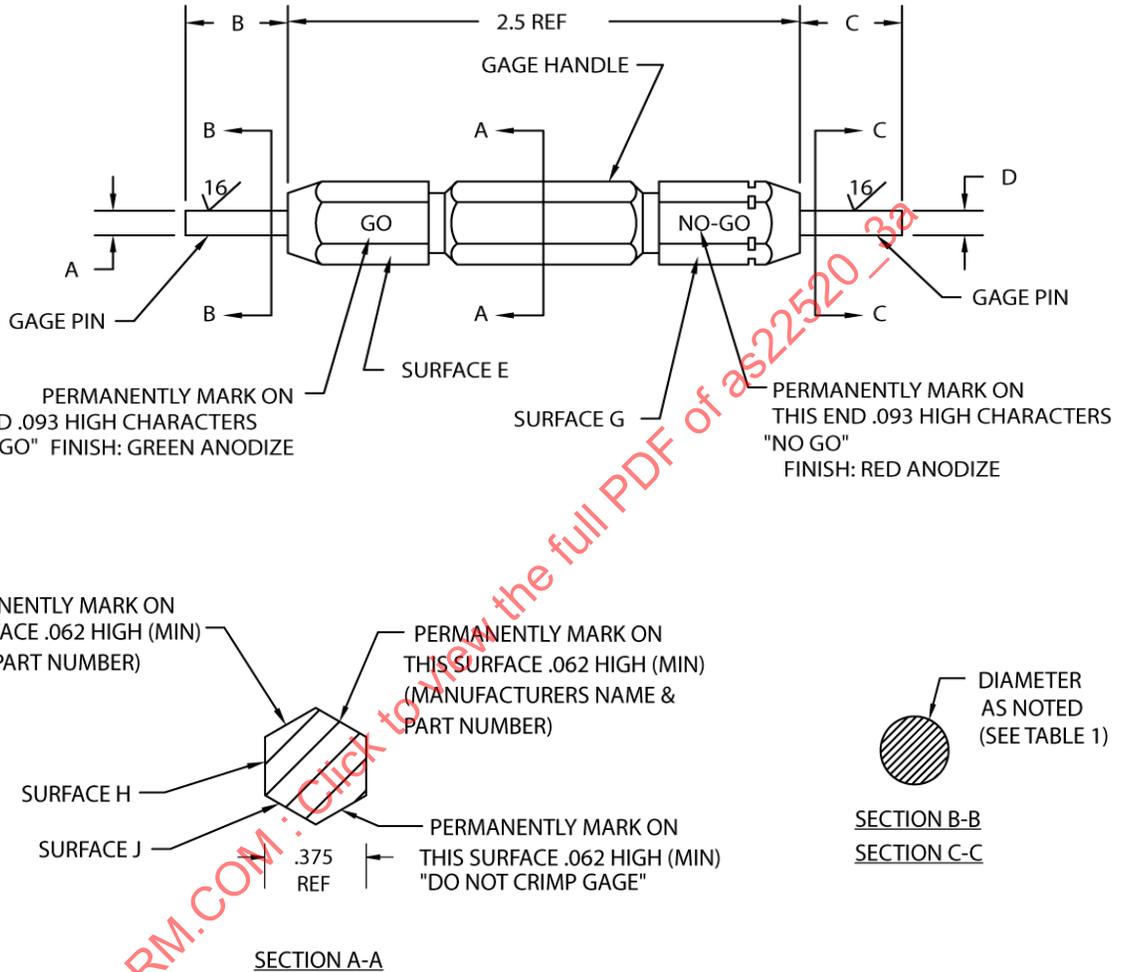
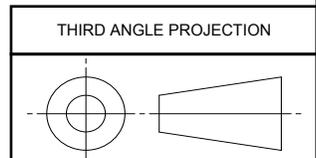


FIGURE 1 - INSPECTION GAGE

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS22520/3>



CUSTODIAN: AE-8/AE-8C2

PROCUREMENT SPECIFICATION: AS22520

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD
CRIMPING TOOLS, TERMINAL, HAND, WIRE
TERMINATION, INSPECTION GAGE FOR TYPE I AND II TOOLS

SAE AS22520/3
SHEET 1 OF 3

REV. A

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ISSUED 2010-10 REVISED 2011-09

TABLE 1 – DESIGN CONFIGURATION AND APPLICATIONS

PART NO.	A dia. ±.0001	B ±.02	C ±.02	D dia. ±.0001	STAMPING				USE FOR INSPECTION OF BASIC TOOL OR DIES
					Surface E	Surface G	Surface H	Surface J	
M22520/3-1	.0390	.50	.50	.0440	.0390	.0440	USE SEL. 4 FOR M22520/1-01	USE SEL. 8 FOR M22520/2-01	MS22520/1-01 MS22520/2-01
M22520/3-2	.0960	"	"	.1000	.0960	.1000	M22520/4-01 BASIC TOOL	-----	M22520/4-01
M22520/3-3	.0410	"	"	.0460	.0410	.0460	USE SEL. 8 FOR M22520/7-01	-----	M22520/7-01
M22520/3-4	.0640	"	"	.0670	.0640	.0670	USE SEL. 7 FOR M22520/19-01 /20-01	USE SEL. 1 FOR M22520/21-01 /22-01	M22520/19-01,M22520/20-01, M22520/21-01, M22520/22-01 IDENTERS ONLY
M22520/3-5	.0890	"	"	.0920	.0890	.0920	M22520/19-01 BASIC TOOL	RETAINERS ONLY	M22520/19-01 RETAINERS ONLY
M22520/3-6	.0740	"	"	.0770	.0740	.0770	M22520/20-01 BASIC TOOL	RETAINERS ONLY	M22520/20-01 RETAINERS ONLY
M22520/3-7	.1480	"	"	.1510	.1480	.1510	M22520/21-01 BASIC TOOL	RETAINERS ONLY	M22520/21-01 RETAINERS ONLY
M22520/3-8	.1210	"	"	.1240	.1210	.1240	M22520/22-01 BASIC TOOL	RETAINERS ONLY	M22520/22-01 RETAINERS ONLY
M22520/3-9	.1320	"	"	.1400	.1320	.140	M22520/5-100 /10-100 DIES	DIE SIZE 12-10	M22520/5-100 & /10-100 DIE * CAVITY SIZE 12-10
M22520/3-10	.0960	"	"	.1040	.0960	.1040	M22520/5-100 /10-101 DIES	DIE SIZE 26-14	M22520/5-100 & /10-101 DIE * CAVITY SIZE 26-14
MS22502/3-11	.0660	"	"	.0740	.0660	.0740	M22520/5-101 /10-102 DIES	DIE SIZE 26-24 SPLICE	M22520/5-101 & /10-102 DE CAVITY SIZE 26-20
MS22502/3-12	.0640	"	"	.0720	.0640	.0720	M22520/5-102 /10-103 DIES	DIE SIZE 16-12	M22520/5-102 & /10-103 DIE CAVITY SIZE 16-12
MS22502/3-13	.0430	"	"	.0510	.0430	.0510	M22520/5-103 /10-104 DIES	DIE SIZE 20-16	M22520/5-103 & /10-104 DIE CAVITY SIZE 20-16
M22520/3-14	.0250	"	"	.0330	.0250	.0330	M22520/5-103 /10-104 DIES	DIE SIZE 26-20	M22520/5-103 & /10-104 DIE CAVITY SIZE 26-20
M22520/3-15	.1420	"	"	.1460	.1420	.1460	M22520/31-01 BASIC TOOL	-----	M22520/31-01

*SEE AS22520/5 FOR OTHER DIES USING THE SAME GAGE

REQUIREMENTS: AS SPECIFIED IN AS22520.

1. DIMENSIONS: UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES AS SPECIFIED IN FIGURE 1 AND TABLE 1.

CONFIGURATION IS OPTIONAL WITHIN DEFINED DIMENSIONS. TOLERANCES ARE DECIMALS ±.010 INCHES. DIMENSIONS A AND D APPLY AFTER PROTECTIVE COATING (SEE REQUIREMENT 3).

2. MATERIAL:

GAGE PINS: ALLOY TOOL STEEL PER ASTM A681, ASTM-A295, OR EQUIVALENT (CLASS OPTIONAL). HARDEN TO ROCKWELL C58-64.

GAGE HANDLE: ALUMINUM ALLOY, ASTM B211 ALUMINUM AND ALUMINUM-ALLOY BAR, ROD, AND WIRE

3. FINISH:

GAGE PINS; CHROME PLATE WITH ADEQUATE COVERAGE FOR CORROSION AND WEAR RESISTANCE PER AMS-QQ-C-320 PLATING CHROMIUM, CLASS I, TYPE II WITH A THICKNESS OF .00003 INCHES MINIMUM.

GAGE HANDLE: ANODIZED IN ACCORDANCE WITH MIL-A-8625 OR EQUALVALENT.

4. MARKING: UNLESS OTHERWISE SPECIFIED, STAMPING SHALL BE INDENTED. LASER ETCHING IS ALSO ACCEPTABLE.

5. STORAGE CONTAINER: EACH GAGE SHALL BE FURNISHED WITH A SUITABLE CONTAINER.

 An SAE International Group	AEROSPACE STANDARD	SAE AS22520/3 SHEET 2 OF 3	REV. A
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