

RATIONALE

AS22520/45 IS ISSUED TO ELIMINATE MANUFACTURERS PROPRIETARY TOOL PART NUMBERS WHICH ARE CURRENTLY LISTED IN SEVERAL AS39029 DETAIL SPECIFICATIONS.

NOTICE

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

AS22520/45

TABLE 1 - TOOL/CONTACT CRIMP APPLICATIONS

CRIMP TOOL FRAME M22520/45-01 ( SHEETS 1 AND 2)		
CONTACT DETAIL SPECIFICATION NUMBER	REQUIRED POSITIONER	POSITIONER DESCRIPTION LOCATION (SHEET NUMBERS)
M39029/56, /58, /117, /118, /121, /123	FIXED	2

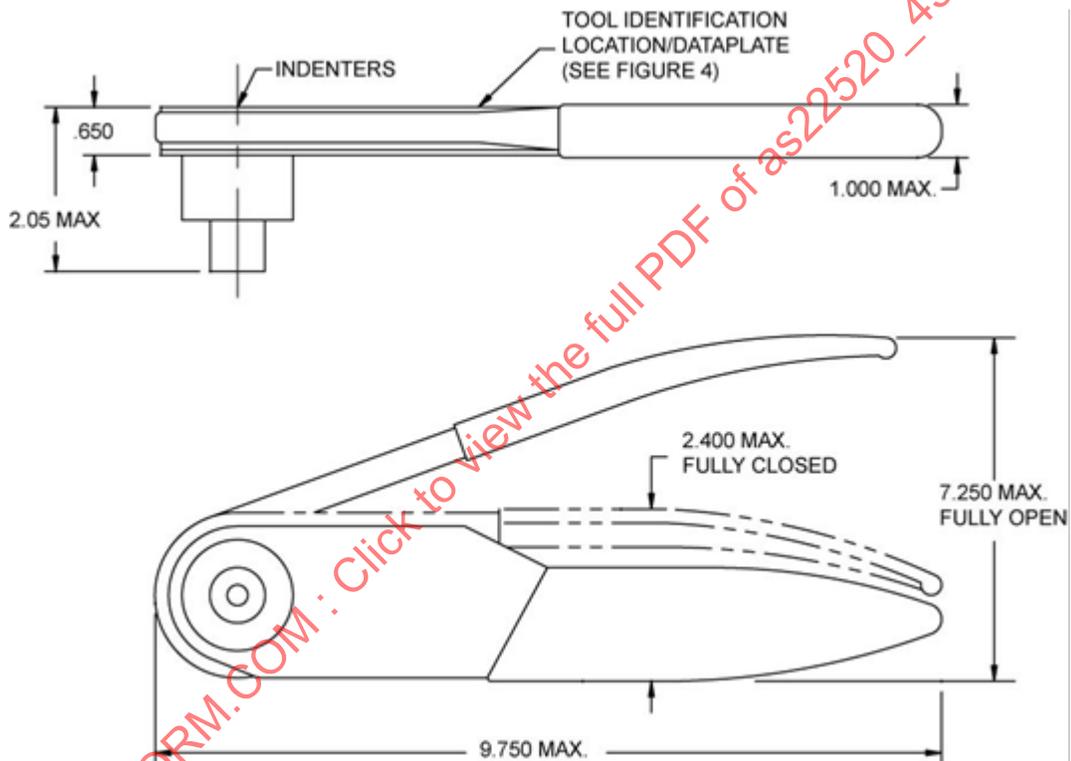
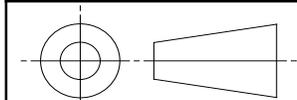


FIGURE 1 - TOOL BODY DETAILS

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THIRD ANGLE PROJECTION



CUSTODIAN: AE-8/AE-8C2

PROCUREMENT SPECIFICATION: AS22520



**AEROSPACE STANDARD**

CRIMPING TOOLS, TYPE I, HAND, WIRE, TERMINATION FOR WIRE BARREL SIZE 10 POWER CONTACTS

**AS22520/45**  
SHEET 1 OF 5

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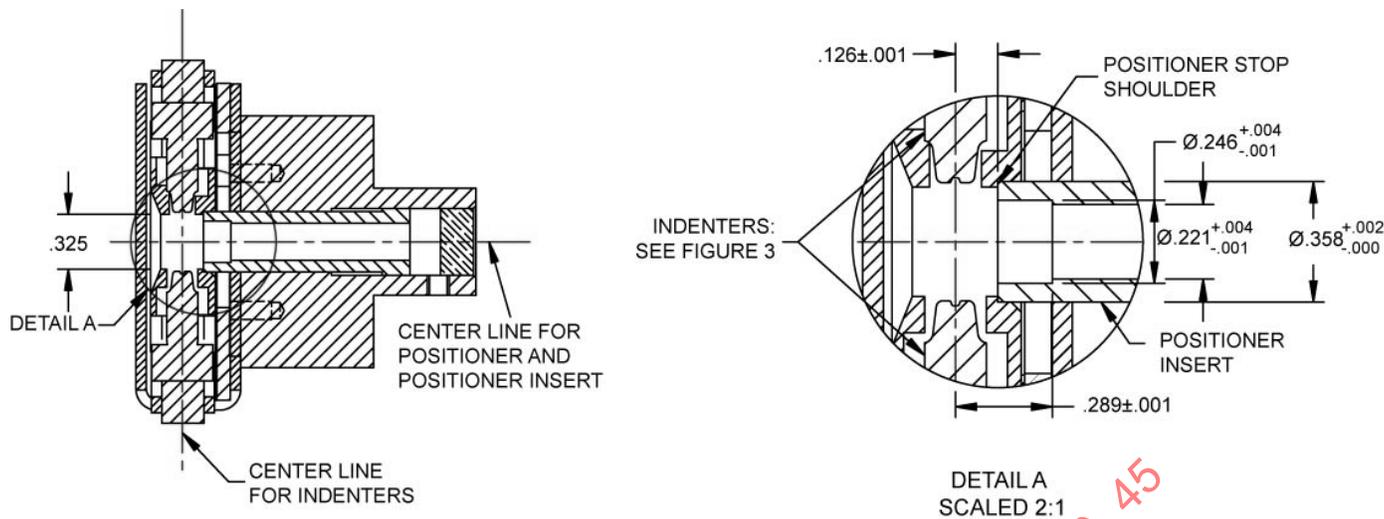
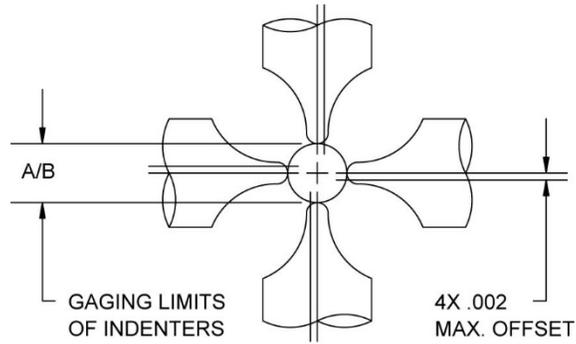


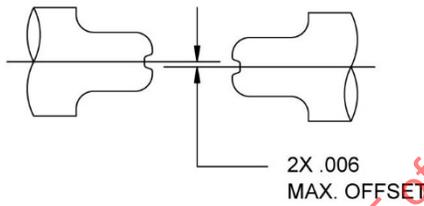
FIGURE 2 - POSITIONER AND INDENTER VIEW

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	<b>AEROSPACE STANDARD</b> CRIMPING TOOLS, TYPE I, HAND, WIRE, TERMINATION FOR WIRE BARREL SIZE 10 POWER CONTACTS	<b>AS22520/45</b> SHEET 2 OF 5	



INDENTER LOCATIONS WITH TOOL  
IN FULLY CLOSED POSITION



OPPOSITE AND ADJACENT  
INDENTER CENTERLINES

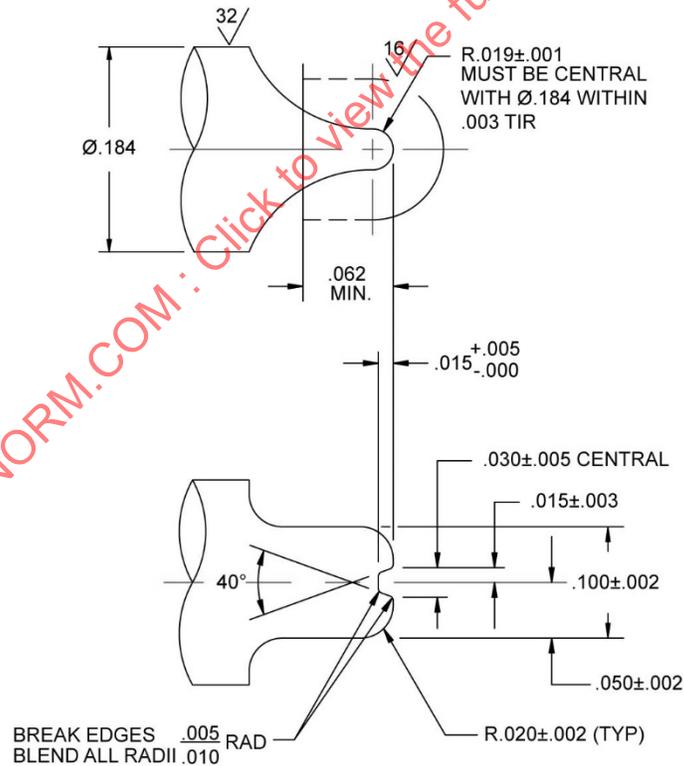


FIGURE 3 - INDENTER DETAILS

TABLE 2 - BASIC TOOL MARKINGS

PART NO.	TOOL BODY COLOR (SURFACE FINISH)	HANDLE GRIP COLOR	FOR INSPECTION GAGING USE
M22520/45-01	BLUE 1/	BLUE	M22520/3-16

1/ COLOR IS OPTIONAL

TABLE 3 - INDENTER INSPECTION GAGE LIMITS

GAGING LIMITS OF INDENTERS	
INSPECTION GAGE	
Ø GO A + .0001	Ø NO-GO B + .0001
.0730	.0780

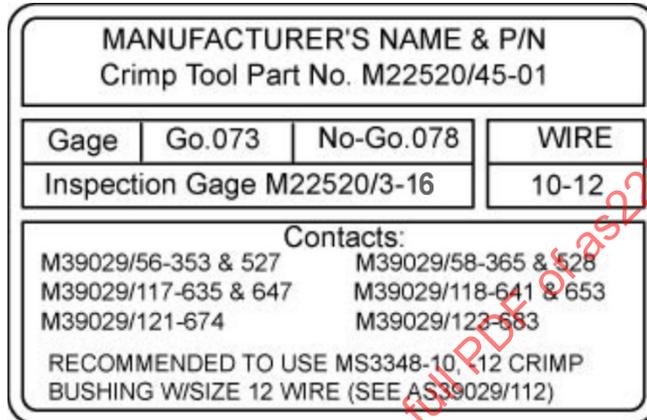


FIGURE 4 - DATAPLATE MARKING

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

1. DIMENSIONS: UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES, TOLERANCES (DECIMALS  $\pm 0.10$ , ANGLES  $\pm 1/2^\circ$ ). OUTLINE CONFIGURATION OPTIONAL WITHIN MAXIMUM DIMENSIONS SHOWN IN FIGURES 1 THRU 3.
2. MARKING: IDENTIFICATION AND COLOR SHALL BE IN ACCORDANCE WITH TABLE 2 AND FIGURE 4. THE MARKING SHALL BE IN ACCORDANCE MIL-STD-130, STAMP AND WHITE FILL OR LASER MARKED. UNLESS OTHERWISE SPECIFIED LETTERING HEIGHT IS .093 MIN. PART NUMBER AND COLOR SHALL BE AS SPECIFIED. LABEL PRINTING SHALL BE BLACK LETTERING ON CONTRASTING BACKGROUND.
3. MATERIALS: UNLESS OTHERWISE SPECIFIED, MATERIAL IS IN ACCORDANCE WITH M22520. SURFACE TEXTURE SHALL BE 63 RMS OVER ALL IN ACCORDANCE WITH ASME B46 1-2009 (AMERICAN NATIONAL STANDARDS INSTITUTE). INDENTER MATERIAL SHALL BE TOOL STEEL, HARDENED TO ROCKWELL "C" 58-60.
4. WEIGHT: WEIGHT OF TOOL SHALL NOT EXCEED 1.5 POUNDS.
5. TOOL COMPRESSION FORCE: THE COMPRESSION FORCE REQUIRED TO MAKE SATISFACTORY CRIMPS SHALL NOT EXCEED 120 POUNDS WHICH IS APPLICABLE FOR THE M39029/56-527 OR M39029/58-528 CONTACT CRIMPED ON A SIZE 10 WIRE.
6. TOOL FRAME INDENTER GAGE LIMITS: INDENTER GAGE LIMITS ARE DEFINED IN TABLE 3.

APPLICATION NOTES:

1. THIS IS A DEDICATED TOOL FOR SIZE 10 POWER CONTACTS CONFORMING TO AS39029 AND DESIGNED TO BE USED WITH MIL-DTL-38999 CONNECTORS.
2. POSITIONER IS NOT REPLACEABLE AND ADDITIONAL POSITIONER OR TURRET HEAD IS NOT REQUIRED.

	<b>AEROSPACE STANDARD</b> CRIMPING TOOLS, TYPE I, HAND, WIRE, TERMINATION FOR WIRE BARREL SIZE 10 POWER CONTACTS	<b>AS22520/45</b> SHEET 4 OF 5	