

REV.  
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AS5259™/1

FEDERAL SUPPLY CLASS  
5120

RATIONALE

REVISION REQUIRED TO CORRECT PART NUMBER, TABLE 1 LISTING, AND MINOR EDITORIAL ERRORS.  
AS5259/1B HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

NOTICE

THE COMPLETE REQUIREMENTS FOR PROCURING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF AS5259.

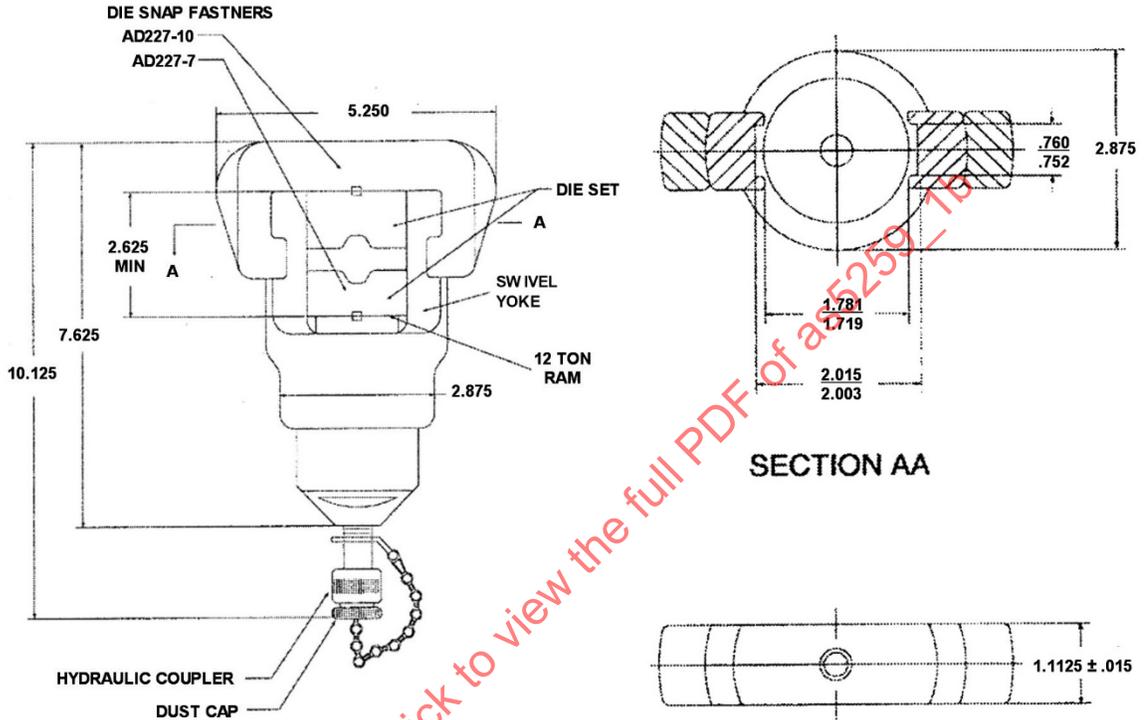
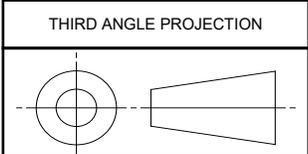


FIGURE 1 - MS25441-1 REMOTE 12 TON CRIMPING TOOL HEAD

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<https://www.sae.org/standards/content/AS5259/1B/>



CUSTODIAN: AE-8/AE-8C2

PROCUREMENT SPECIFICATION: AS5259



**AEROSPACE STANDARD**

(R) CRIMPING TOOL AND ACCESSORIES, REMOTE CRIMP HEAD, HYDRAULIC, WIRE SIZE 8 TO 0000 FOR INSULATED AND UN-INSULATED CRIMP BARRELS

AS5259™/1  
SHEET 1 OF 3

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ISSUED 2008-09 REVISED 2019-02 REAFFIRMED 2025-04

REQUIREMENTS: AS SPECIFIED IN AS5259.

1. CONFIGURATION:

- a. DIMENSIONS SHALL BE IN INCHES IN ACCORDANCE WITH FIGURE 1. UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE  $\pm 0.015$  AND ANGLES  $\pm 1^\circ$ .
- b. REMOVE ALL BURRS AND BREAK ALL EDGES.
- c. REQUIRED MAXIMUM HYDRAULIC PRESSURE SHALL BE 1700 PSI  $\pm 2$  PSI.
- d. COUPLER SHALL BE A HYDRAULIC FEMALE COUPLER, QUICK CONNECT, 3/8 INCH PIPE SIZE NPT, 10000 PSI RATING AND FLOW RATE 10.8 GPM (REF).
- e. DUST CAP SHALL BE A METAL DUST CAP WITH CONSTRAINT DEVICE (CHAIN, ETC.) TO PREVENT LOSS.
- f. MAXIMUM WEIGHT LESS THE DIE SHALL BE 9 POUNDS.
- g. HEAD SHALL BE RATED FOR MINIMUM OF 10000 PSI INPUT PRESSURE. HEAD SHALL GENERATE A MINIMUM OF 12 TONS OF FORCE AT THE DIE FACES WITH 10000 PSI INPUT PRESSURE.

2. MATERIALS:

- a. TOOL STEEL HEAD IN ACCORDANCE WITH AMS6359. HEAT TREATED TO 49-52 HRC.
- b. FINISH SHALL BE BLACK OXIDE. SALT SPRAY TEST IS NOT REQUIRED.

3. CRIMP DIES ARE IN ACCORDANCE WITH AS5259/7 (SEE TABLE 1 FOR DIE APPLICATION).

4. INSPECTION GAGES IN ACCORDANCE WITH AS5259/6 (SEE TABLE 1 FOR GAGE APPLICATION).

5. SUPPLIER NAME OR SYMBOL, SUPPLIER PART NUMBER AND SAE PART NUMBER (MS25441-1) IS REQUIRED ON THE TOOL (LOCATION OPTIONAL). SUPPLIER SYMBOL SHALL BE IN ACCORDANCE WITH AIR1351.



6. FOR QUALIFICATION TOOL WILL BE TESTED WITH THE AS5259/2-01 FLEXIBLE HOSE AND AS5259/2-02 FOOT OPERATED PUMP OR THE -04 HAND OPERATED PUMP.

APPLICATIONS:

- 1. GO/NO-GO GAGE INSPECTION RECOMMENDED AT PERIODIC INTERVALS.
- 2. AS5259/2 PUMPS ARE RECOMMENDED FOR THE MS25441-1 REMOTE CRIMP HEAD (SEE TABLE 1).
- 3. THE TOOLS SPECIFIED HEREIN ARE DESIGNED TO CRIMP THE COMPONENTS SPECIFIED IN TABLE 1 USING THE REMOTE HOSE AND PUMPS SPECIFIED IN AS5259/2 OR EQUIVALENT.

SPECIFICATION NOTES:

- 1. IT IS THE RESPONSIBILITY OF THE COMPONENT SPECIFICATION PREPARER TO DETERMINE IF A SPECIFIC TOOL CAN BE USED TO CRIMP SPECIFIC WIRE BARRELS OTHER THAN THOSE LISTED. AFTER THE TOOL HAS BEEN DETERMINED TO BE ACCEPTABLE FOR THE COMPONENT, THE PREPARER IS RECOMMENDED TO REQUEST SAE TO EXPAND THE COMPONENT REFERENCE LIST OR TO ESTABLISH AN AS5259/Y DETAIL SPECIFICATION WHICH THE PREPARER CAN THEN REFERENCE IN THE COMPONENT SPECIFICATION.
- 2. 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.

	<b>AEROSPACE STANDARD</b>	<b>AS5259™/1</b> SHEET 2 OF 3	<b>REV.</b> <b>B</b>
	(R) CRIMPING TOOL AND ACCESSORIES, REMOTE CRIMP HEAD, HYDRAULIC, WIRE SIZE 8 TO 0000 FOR INSULATED AND UN-INSULATED CRIMP BARRELS		