

REV.
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AS5259™/2

FEDERAL SUPPLY CLASS
5120

RATIONALE

TOTAL REVISION REQUIRED TO ADDRESS NON-QUALIFIED PUMPS, ESTABLISH PUMP OUTPUT REQUIREMENTS FOR AS5259 REMOTE CRIMPING TOOLS, EDITING, AND TECHNICAL CHANGES AS NEEDED.

NOTICE

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

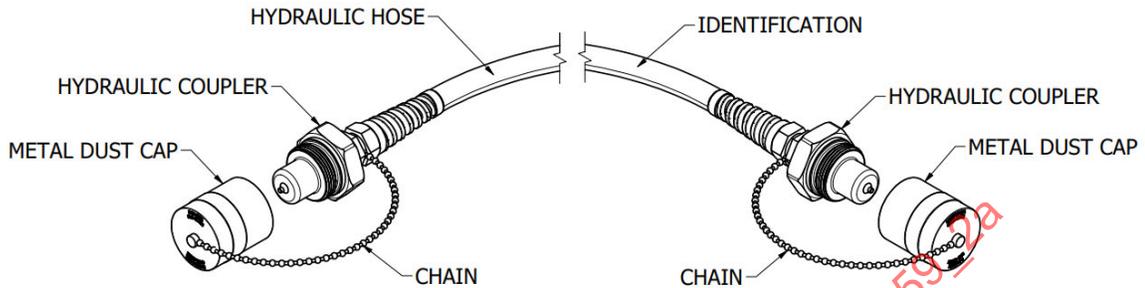


FIGURE 1 - M5259/2-01 HOSE FLEXIBLE, NON-METALLIC, HYDRAULIC CONTROL HOSE ASSEMBLY

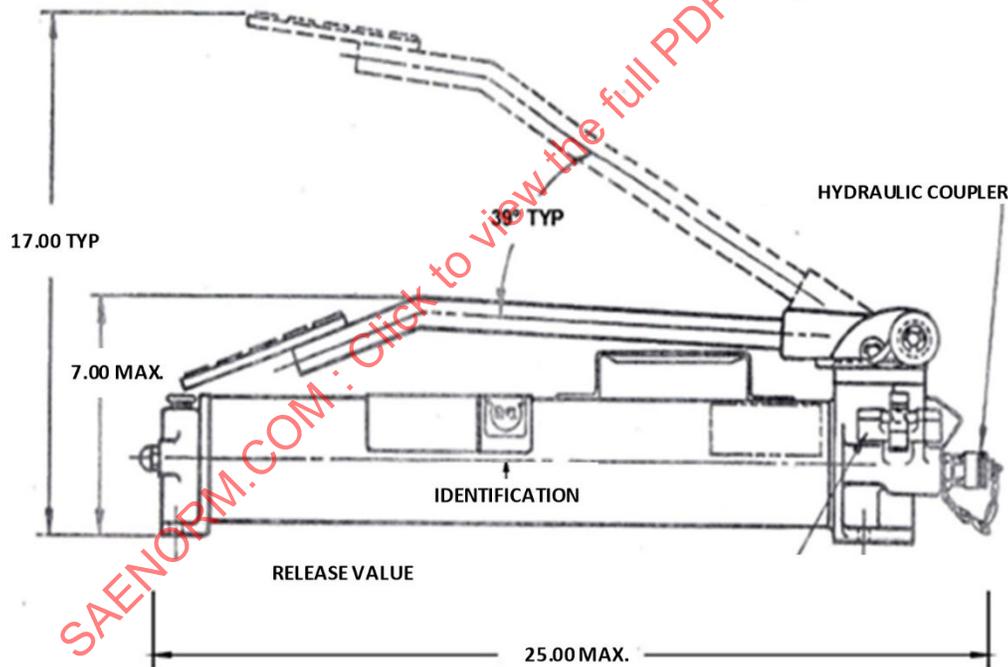
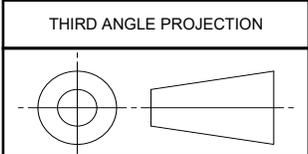


FIGURE 2 - M5259/2-02 HYDRAULIC HAND OR FOOT PUMP

For more information on this standard, visit
<https://www.sae.org/standards/content/AS5259/2A/>



CUSTODIAN: AE-8C2

PROCUREMENT SPECIFICATION: AS5259



AEROSPACE STANDARD

(R) CRIMPING TOOL AND ACCESSORIES,
HYDRAULIC PUMPS, 10000 PSI MINIMUM

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SHEET 1 OF 4

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ISSUED 2012-08 REVISED 2021-12

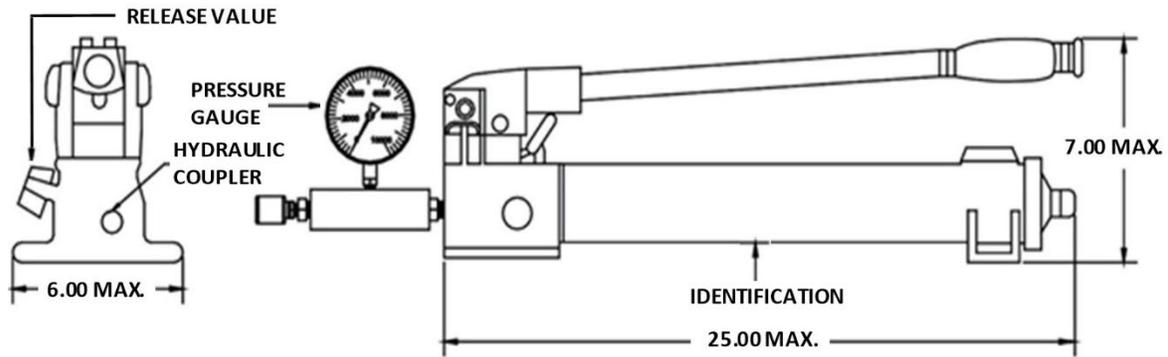


FIGURE 3 - M5259/2-03 HYDRAULIC HAND PUMP

REQUIREMENTS: ALL REQUIREMENTS SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF AS5259.

1. FLEXIBLE, NON-METALLIC, HYDRAULIC CONTROL HOSE ASSEMBLY SHALL BE IN ACCORDANCE WITH FIGURE 1.

CONFIGURATION

- BOTH ENDS SHALL BE TERMINATED WITH A SIZE 10 MALE HYDRAULIC COUPLER, MEETING ISO 14540 REQUIREMENTS.
- METAL DUST CAP WITH CHAIN SHALL BE SECURELY ATTACHED TO THE HOSE BEYOND THE COUPLER.
- HYDRAULIC HOSE RATED FOR 10000 PSI MINIMUM WORKING PRESSURE, 20000 PSI MINIMUM BURST PRESSURE, 10 FEET LONG \pm 1 INCH WITH A $0.25 \pm .01$ INCH INTERNAL DIAMETER.

MATERIAL

- MATERIAL SHALL BE IN ACCORDANCE WITH AS5259.

IDENTIFICATION MARKING

- COLOR IS OPTIONAL.
- IDENTIFICATION SHALL BE CONTRASTING MARKING AND INCLUDE PART NUMBER, SUPPLIER'S NAME, AND SUPPLIER'S PART NUMBER.
- PART NUMBER

2. MANUAL HYDRAULIC FOOT PUMP AND HAND PUMP SHALL BE IN ACCORDANCE WITH FIGURE 2 AND FIGURE 3 RESPECTIVELY.

CONFIGURATION

- DIMENSIONS ARE IN INCHES AND TOLERANCE $\pm .01$ INCH. DESIGN AND SHAPE IS OPTIONAL WITHIN DIMENSIONS SPECIFIED. THE 7.00 MAX DIMENSION IS THE HANDLE LOCATION IN THE CLOSED AND LOCK POSITION.
- PRESSURE GAGE (OPTIONAL) SHALL BE UNITS EXPRESSED IN POUNDS PER SQUARE INCH (PSI). MINIMUM SCALE SHALL INDICATE 10000 PSI.
- PARTIAL PRESSURE RELEASE VALVE REQUIRED.
- OUTPUT HYDRAULIC PRESSURE COUPLER (THREADED TYPE) SHALL BE A SIZE 10 FEMALE HYDRAULIC COUPLER, MEETING ISO 14540 REQUIREMENTS.
- DUST CAP SHALL BE A METAL DUST CAP WITH CONSTRAINT DEVICE (CHAIN, ETC.) TO PREVENT CAP LOSS.

MATERIALS

- MATERIAL SHALL BE IN ACCORDANCE WITH AS5259.
- THE HYDRAULIC FLUID SHALL BE SPECIFIED IN THE PUMP INSTRUCTIONS.

IDENTIFICATION MARKING (ADDITIONAL MARKING IS PERMITTED)

- COLOR IS OPTIONAL.
- IDENTIFICATION SHALL BE CONTRASTING MARKING AND INCLUDE AS5259/2 PART NUMBER, SUPPLIER'S NAME, AND SUPPLIER'S PART NUMBER. IF A STORAGE UNIT IS USED, THE SAME INFORMATION REQUIRED ON THE STORAGE UNIT.
- PART NUMBER:

M5259 / 2 - 03
 | | |
 | | | DASH NUMBER (SEE FIGURE 3)
 | | | DETAIL SPECIFICATION NUMBER FOR AS5259 PUMPS AND ACCESSORIES
 | | | AS5259 BASIC SPECIFICATION NUMBER

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	(R) CRIMPING TOOL AND ACCESSORIES, HYDRAULIC PUMPS, 10000 PSI MINIMUM		

PERFORMANCE REQUIREMENTS

- PUMP SHALL BE USABLE WITH THE M5259/2-01 HOSE (SEE APPLICATION NOTE) OR A HOSE WITH THE SAME COUPLER CONFIGURATION.
- PUMP MATERIALS AND ACCESSORIES SHALL SHOW NO CORROSION, WATER ABSORPTION MARKING OR COLOR DETERIORATION WHEN TESTED AS SPECIFIED HEREIN.
- WHEN PERFORMING A CRIMP, THE OUTPUT HYDRAULIC PRESSURE SHALL BE 10000 ± 250 PSI PRIOR TO RELEASING THE CRIMP. COMPLETION OF COMPONENT CRIMP IS INDICATED BY COMPLETE DIE CLOSURE (END FACE TO END FACE).
- PUMP SHALL BE EASILY CARRIED BY ONE PERSON (I.E., HANDLE, LIMITED WEIGHT, ETC.). MAXIMUM PUMP WEIGHT IN STORAGE CONTAINER (IF USED) SHALL BE 35 POUNDS.
- PUMP SHALL BE DESIGNED TO FULLY CYCLE ALL AS5259 BASIC TOOLS FOR A MINIMUM OF 5000 CYCLES EXCEPT FOR SELF CONTAINED HAND PUMP MANUAL TOOLS.
- OPERATION AND ASSEMBLY INSTRUCTION SHALL BE PROVIDED WITH EACH PUMP. INSTRUCTION SHALL INCLUDE MAINTENANCE, AND REPAIR INFORMATION, HYDRAULIC OIL REPLACEMENT TYPE, ACCESSORY PART NUMBERS, AND STANDARD TOOLS AS NEEDED. (SEE APPLICATION NOTE).
- SPECIAL TOOLS FOR ASSEMBLY OR OPERATION SHALL NOT BE REQUIRED.

3. ELECTRIC OR AIR POWER PUMPS

- ELECTRIC OR AIR POWER PUMP MAY BE USED IN-LIEU OF THE MANUAL PUMPS.
- OPERATION AND ASSEMBLY INSTRUCTION SHALL BE PROVIDED WITH EACH PUMP. INSTRUCTION SHALL INCLUDE MAINTENANCE, AND REPAIR INFORMATION, HYDRAULIC OIL REPLACEMENT TYPE, ACCESSORY PART NUMBERS, AND STANDARD TOOLS AS NEEDED. (SEE APPLICATION NOTE).

THE RECOMMENDED INPUT CHARACTERISTICS ARE AS FOLLOWS:

- BATTERY ACTIVATED PUMPS SHOULD HAVE RECHARGEABLE BATTERY(S) THAT WILL CRIMP A MINIMUM OF TEN CRIMPS BETWEEN EACH CHARGE.
- ELECTRIC ACTIVATED PUMPS SHOULD HAVE AN INPUT POWER OF 115 VAC, 50/60 Hz.
- AIR ACTIVATED PUMPS SHOULD HAVE AN INPUT PRESSURE OF 40 TO 125 PSI.

THE REQUIRED OUTPUT CHARACTERISTICS ARE AS FOLLOWS:

- THE OUTPUT HYDRAULIC PRESSURE SHALL BE 10000 ± 250 PSI. ONCE CRIMPING ACTION HAS BEGUN, THE PUMP SHALL OPERATE IN SUCH A MANNER, THAT IT ENSURES THE PROPER PRESSURE IS BEING CONTINUALLY APPLIED WITHOUT RELEASE TO THE NIBS/DIES. WHEN A PROPER CRIMP IS COMPLETED (END FACE-TO-END FACE FOR DIES), THE PUMP SHALL INDICATE TO THE OPERATOR THAT THE PRESET PRESSURE HAS BEEN REACHED, AND THE CRIMPING MECHANISM CAN BE RELEASED TO OPEN (AUTOMATICALLY OR MANUALLY). THE HYDRAULIC PRESSURE SHALL BE MAINTAINED, IF THE INPUT POWER (OR AIR PRESSURE) IS INTERRUPTED.
- THE PUMP SHALL BE DESIGNED TO FULLY CYCLE ALL AS5259 BASIC TOOLS FOR A MINIMUM OF 5000 CYCLES. COMPLETION OF A CYCLE IS INDICATED BY COMPLETE DIE CLOSURE AND DIE SEPARATION.
- AIR POWERED PUMPS SHALL BE USABLE WITH THE M5259/2-01 HOSE OR A HOSE WITH THE SAME COUPLER CONFIGURATION.
- THE PUMP SHALL HAVE A PARTIAL PRESSURE RELEASE MECHANISM.

4. QUALIFICATION NOT REQUIRED

5. QUALITY ASSURANCE (100% INSPECTION):

- VISUAL AND MECHANICAL EXAMINATION IN ACCORDANCE WITH AS5259.
- VERIFY ASSEMBLY/OPERATING INSTRUCTIONS ARE INCLUDED WITH EACH PUMP.
- VERIFY THAT THE M5259/2-01 HOSE IS INCLUDED IN OR OUT OF THE CARRYING CASE (WHEN SPECIFIED).
- VERIFY ALL MARKING ARE AS SPECIFIED.

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	(R) CRIMPING TOOL AND ACCESSORIES, HYDRAULIC PUMPS, 10000 PSI MINIMUM		