

RATIONALE

PROVIDE A STANDARD TOOL TO REPLACE NONSTANDARD TOOLS PROCURED BY USERS.

NOTICE

THE REQUIREMENTS FOR PROCURING THE TOOLS DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION AND THE LATEST ISSUE OF: SAE AS5259.

SAE AS5259/3

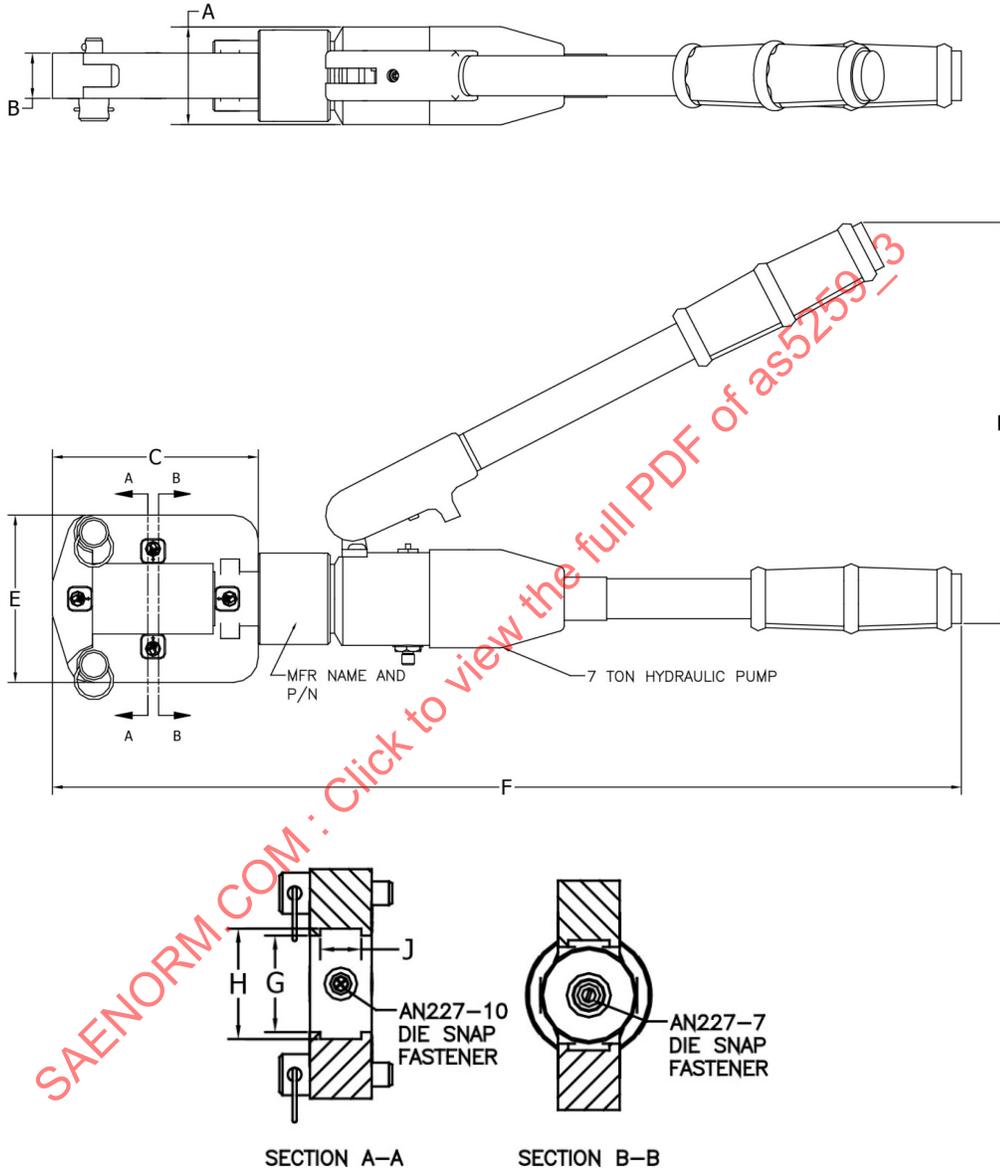
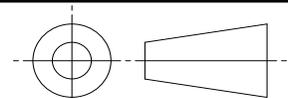


FIGURE 1 - AS5259/3-01 BASIC CRIMPING TOOL WITHOUT DIES

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THIRD ANGLE PROJECTION



CUSTODIAN: AE-8C2

PROCUREMENT SPECIFICATION: AS5259

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD
CRIMPING TOOL AND ACCESSORIES, HAND OPERATED, DIE TYPE, WIRE SIZES 8 TO 0000

SAE AS5259/3
SHEET 1 OF 3

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TABLE 1 – BASIC CRIMPING TOOL CONFIGURATION WITHOUT DIES

PART NO	A MAX	B MAX	C MAX	D MAX	E MAX	F MAX	G	H	J
AS5259/3-01	2.75	1.5	5.25	6.5 CLOSED 19.5 OPEN	4.25	23.00	1.781 1.719	2.015 2.003	.760 .755

REQUIREMENTS: AS SPECIFIED IN AS5259.

1. DESIGN AND CONFIGURATION:

- BASIC TOOL DIMENSIONS SHALL BE IN INCHES IN ACCORDANCE WITH TABLE 1 AND TOLERANCES SHALL BE ± 0.015 AND ANGLES ± 1 DEGREE.
- CONFIGURATION IS OPTIONAL WITHIN ENVELOPE DEFINED BY FIGURE 1. DIE SNAPS REQUIRED AS SHOWN.
- REMOVE ALL BURRS AND BREAK ALL EDGES.
- AS5259/3 TOOL DIES AND INSPECTION GAGES ARE SPECIFIED IN TABLE 2 (SEE TABLE 3 FOR SPECIFIC TERMINAL OR CONTACT APPLICATIONS).
- MAXIMUM WEIGHT WITH HEAVIEST DIE SPECIFIED IN TABLE 2 SHALL BE 16 lbs MAX.
- MULTIPLE COMPRESSIONS OF THE HANDLE IS PERMITTED DEPENDING ON THE SIZE OF THE CRIMP BARREL. INSTRUCTIONS FOR MULTIPLE COMPRESSIONS SHALL BE INCLUDED IN THE SUPPLIER'S ASSEMBLY INSTRUCTIONS.

2. MATERIALS:

- TOOL STEEL IN ACCORDANCE WITH ASTM 4340 HEAT TREATED TO 49-52 hrc.
- FINISH SHALL BE BLACK OXIDE 63 MICRO INCHES THICK
- GRIPS BLACK NITRILE 70+/-5 DUROMETER

3. AS5259/6 INSPECTION GAGES FOR AS5259/7 DIES (SEE TABLE 3 FOR APPLICABLE COMPONENTS):

TABLE 2 – AS5259/6 INSPECTION GAGE PART NUMBERS FOR AS5259/7 DIES

CRIMP BARREL SIZES	COPPER (UN-INSULATED)		COPPER (INSULATED)		ALUMINUM (UN-INSULATED)	
	DIE MS90485-	GAGE MS90486-	DIE MS23002-	GAGE MS23003-	DIE MS25442-	GAGE MS25472-
8	8	8	8	8	8A	1
6	6	6	6	6	6A	2
4	4	4	4	4	4A	3
2	2	2	2	2	2A	4
1	1	1	1	1	1A	5
0	01	01	01	01	01A	6
00	02	02	02	02	02A	7

- CRIMP COMPRESSION FORCE SHALL BE 14 000 lbs.
- CORROSION TEST NOT REQUIRED.
- BASIC TOOL PART NUMBER SHALL BE M5259/3-01.
- SUPPLIER SYMBOL, IF USED, SHALL BE IN ACCORDANCE AIR 1351.
- UNLESS SPECIFIED IN A STORAGE CONTAINER (SEE AS5259), TOOL SHALL BE PROTECTED BY A CONTAINER WITH A HANDLE FOR CARRYING. CONTAINER SHALL BE LABELED WITH TOOL PART NUMBER AND SUPPLIER NAME.