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REV.
A

AS22520™/37

FEDERAL SUPPLY CLASS
5120

RATIONALE

ADDITIONAL DETAIL SPECIFICATIONS WHICH THIS CRIMP TOOL IS INTENDED TO TERMINATE ARE ADDED TO APPLICATION NOTE. METRIC REFERENCE DIMENSIONS ADDED.

NOTICE

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

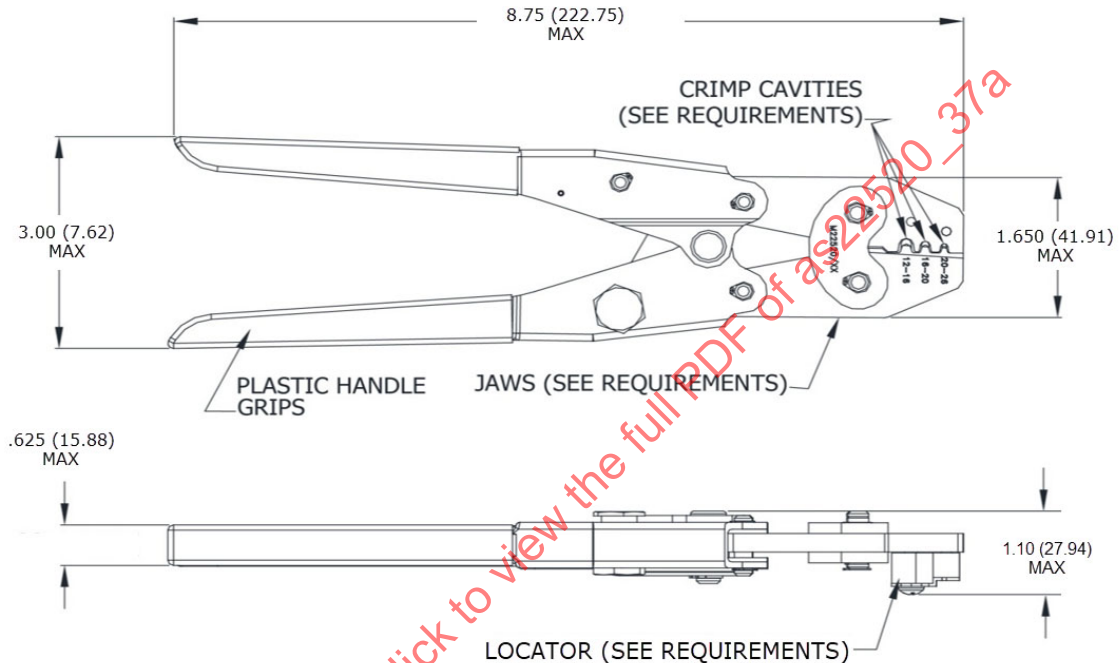
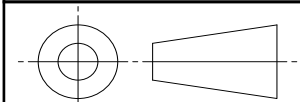


FIGURE 1 - AS22520/37-01 BASIC CRIMPING TOOL

For more information on this standard, visit

<https://www.sae.org/standards/content/AS22520/37A/>

THIRD ANGLE PROJECTION



CUSTODIAN: AE-8C2

PROCUREMENT SPECIFICATION: AS22520



AEROSPACE STANDARD

CRIMPING TOOL, TYPE 2, ELECTRICAL, WIRE
SPlicing, HAND ACTUATED, TYPE II, FOR
ENVIRONMENTAL SPLICES, WIRE RANGE 26-12 AWG

AS22520™/37
SHEET 1 OF 4

REV.
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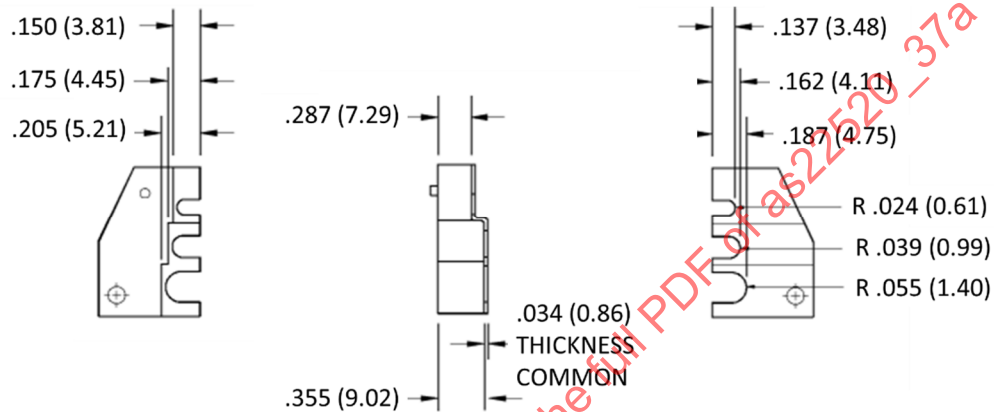
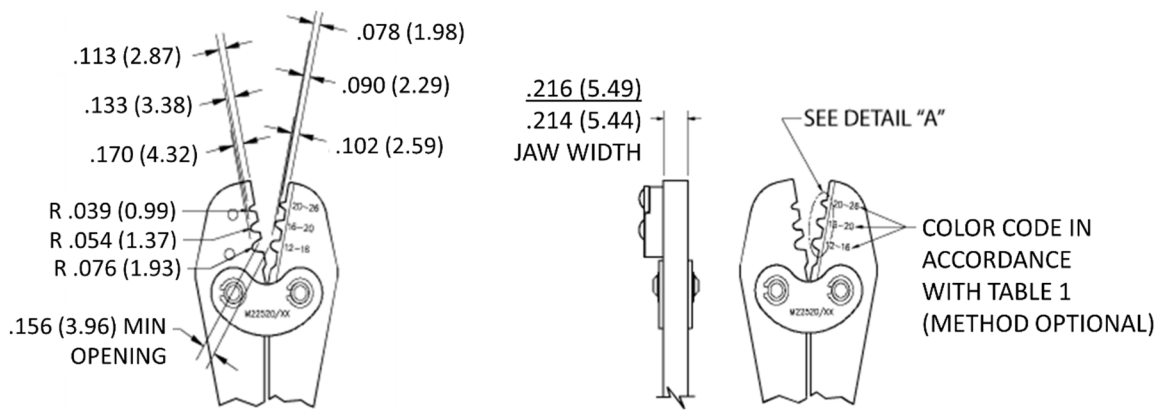
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ISSUED 2013-04 REVISED 2022-07



LOCATOR

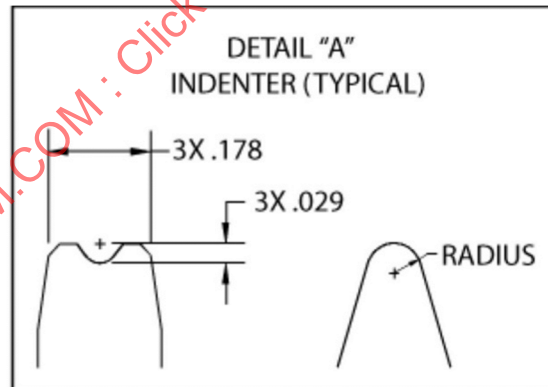


FIGURE 2 - AS22520/37-01 CRIMP JAW DETAILS



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CRIMPING TOOL, TYPE 2, ELECTRICAL, WIRE
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AS22520™/37
SHEET 2 OF 4

REV.
A

TABLE 1 - AS22520/37 CONFIGURATION DETAILS

WIRE SIZE	DIE COLOR CODE	AS22520/39-01 INSPECTION GAGES		RADIUS (INCHES)
		GO GAGE	NO-GO GAGE	
20-26	RED	TIP A	TIP F	.023 (0.58)
16-20	BLUE	TIP B	TIP E	.036 (0.91)
12-16	YELLOW	TIP C	TIP D	.047 (1.19)

REQUIREMENTS: AS SPECIFIED HEREIN AND IN AS22520 FOR TYPE 2 TOOLS:

1. DIMENSIONS:

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES AS SPECIFIED IN FIGURES 1 AND 2. CONFIGURATION IS OPTIONAL WITHIN DEFINED OR MAXIMUM DIMENSIONS IN THE CLOSE HANDLE POSITION. TOLERANCES ARE DECIMALS ± 0.010 INCH (0.254 MM) AND ANGLES $\pm 5^\circ$. METRIC DIMENSIONS ARE CONVERTED TO NEAREST 0.01 MM BASED ON 1 INCH = 25.4 MM AND ARE PROVIDED FOR REFERENCE INFORMATION ONLY.

2. MATERIAL AND FINISH:

- JAW SHALL BE 50 POINT CARBON MINIMUM ALLOY STEEL HEAT TREAT ROCKWELL C 43-54 WITH BLACK OXIDE FINISH. CONVEX CRIMP SURFACES SHALL BE POLISHED TO A SURFACE FINISH OF 16 (RMS) MICRO-FINISH.
- HANDLES SHALL BE STEEL WITH COMMERCIAL GRADE NICKEL OR CHROME PLATING.
- LOCATOR SHALL BE S 40 POINT CARBON STEEL MINIMUM WITH BLACK OXIDE FINISH.
- GRIPS SHALL BE PLASTIC OR RUBBER (COLOR OPTIONAL).

3. MAXIMUM WEIGHT:

1.0 POUND (0.45 KG)

4. IDENTIFICATION MARKING:

MANUFACTURER'S NAME OR AIR1351 LISTED LOGO, MANUFACTURER PART NUMBER, AND SPECIFICATION PART NUMBER (M22520/37-01) SHALL BE PERMANENTLY MARKED ON THE TOOL AND LEGIBLE AFTER ALL AS22520 ENVIRONMENTAL EXPOSURES.

5. TOOL DESIGN:

CYCLE CONTROL (RATCHET) ADJUSTMENT DEVICE SHALL BE SET TO RELEASE BETWEEN 40 TO 50 POUNDS (178 TO 222 N) AND SHALL BE TAMPER PROOF.

TOOL SHALL BE INSPECTED WITH THE INSPECTION GAGES SPECIFIED IN TABLE 1.

6. ASSEMBLY INSTRUCTIONS:

EACH TOOL SHALL HAVE AN INSTRUCTION SHEET WHICH INCLUDES CRIMPING AND GAGE APPLICATIONS, USAGE AND INSTRUCTIONS.

7. PART NUMBER:

M22520/37-01

NOTES:

1. APPLICATIONS:

TOOL IS USED TO CRIMP AS81824/1, /3, /5, /6, /7, /8, /9, /10, /11, /13, AND /14 SPLICES.

2. SUPERSESSION INFORMATION:

- THE M22520/37-01 IS AN ALL INCLUSIVE DIE TOOL THAT CAN USED IN PLACE OF THE M22520/5-102, /5-103, /10-103, AND /10-104 DIES, BUT THERE IS NO DIRECT SUPERSESSION.
- AS22520/37 SUPERSEDED MIL-DTL-22520/37 WITHOUT PART NUMBER CHANGE.

	AEROSPACE STANDARD		AS22520™/37 SHEET 3 OF 4	REV. A
	CRIMPING TOOL, TYPE 2, ELECTRICAL, WIRE SPLICING, HAND ACTUATED, TYPE II, FOR ENVIRONMENTAL SPLICES, WIRE RANGE 26-12 AWG			