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REV.
A

AS22520™/44

FEDERAL SUPPLY CLASS
5120

RATIONALE

REVISION REQUIRED TO CHANGE TEMPLATE PROCUREMENT BLOCK FROM "NONE" TO "AS22520."

NOTICE

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

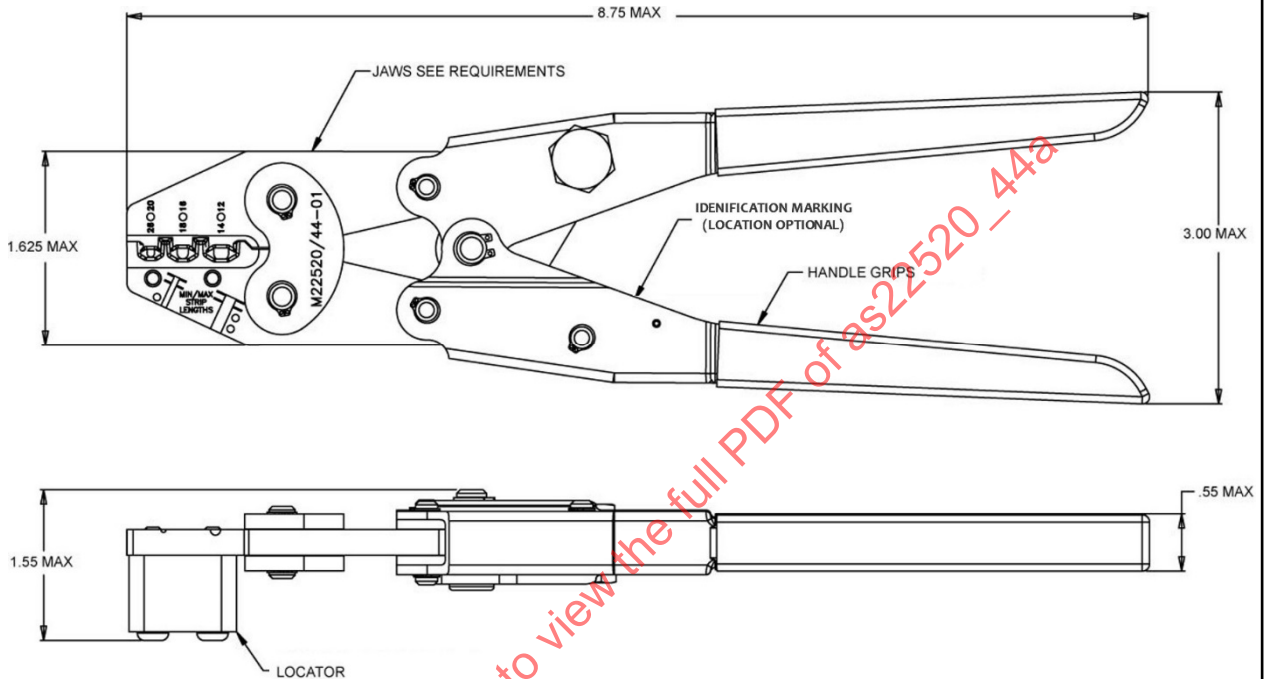
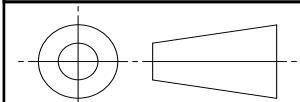


FIGURE 1 - M22520/44-01 CRIMPING TOOL

For more information on this standard, visit

<https://www.sae.org/standards/content/AS22520/44A/>

THIRD ANGLE PROJECTION



CUSTODIAN: AE-8C2

PROCUREMENT SPECIFICATION: AS22520



AEROSPACE STANDARD

CRIMPING TOOL, TYPE II, WIRE HEATLESS
TERMINATION, HAND ACTUATED,
WIRE SIZES 26-12

AS22520™/44
SHEET 1 OF 6

REV.
A

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ISSUED 2014-09 REVISED 2020-11

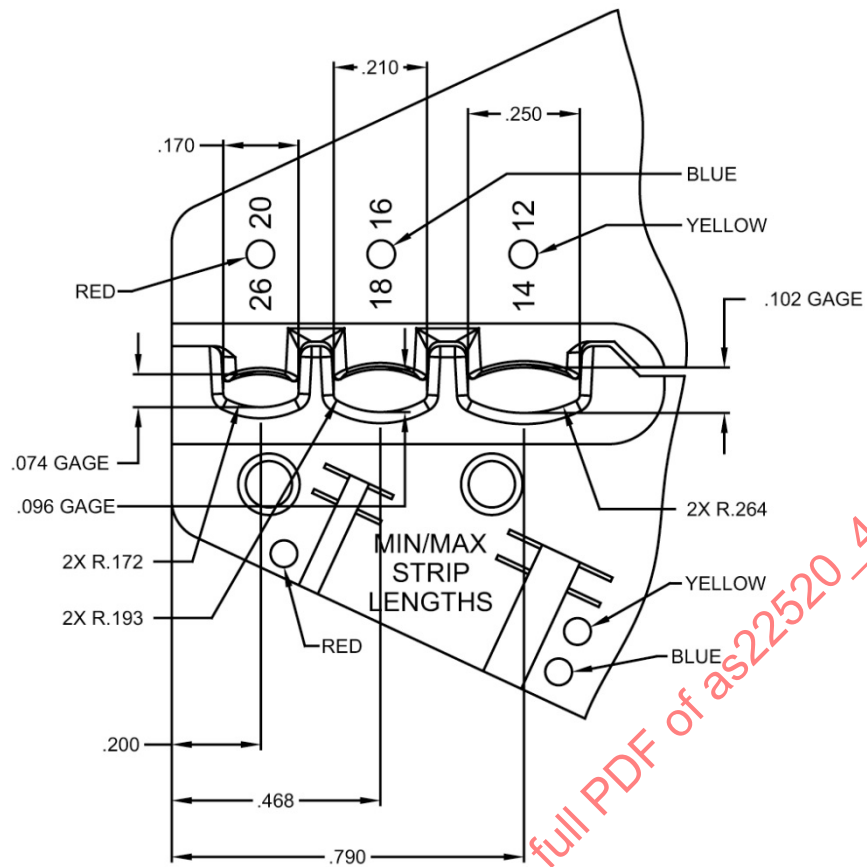


FIGURE 2 - M22520/44-01 CRIMPING TOOL JAW DETAIL

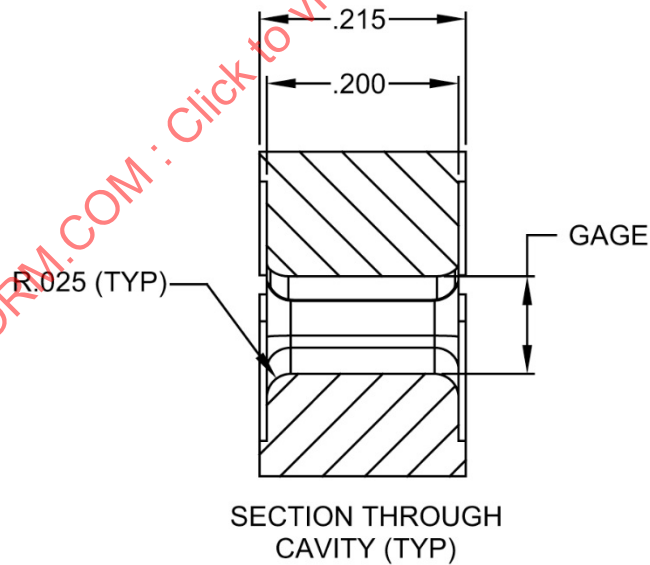


FIGURE 3 - M22520/44-01 CRIMP CAVITY SECTION, TYPICAL

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	CRIMPING TOOL, TYPE II, WIRE HEATLESS TERMINATION, HAND ACTUATED, WIRE SIZES 26-12		

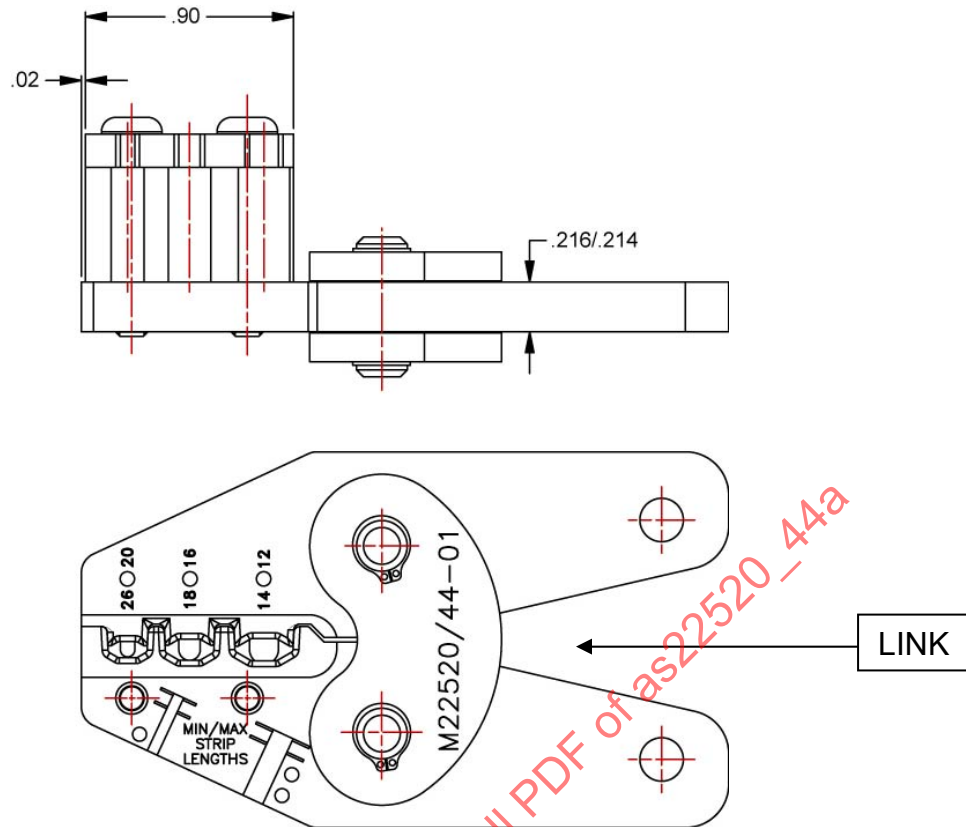


FIGURE 4 - M22520/44-01 LOCATOR POSITION

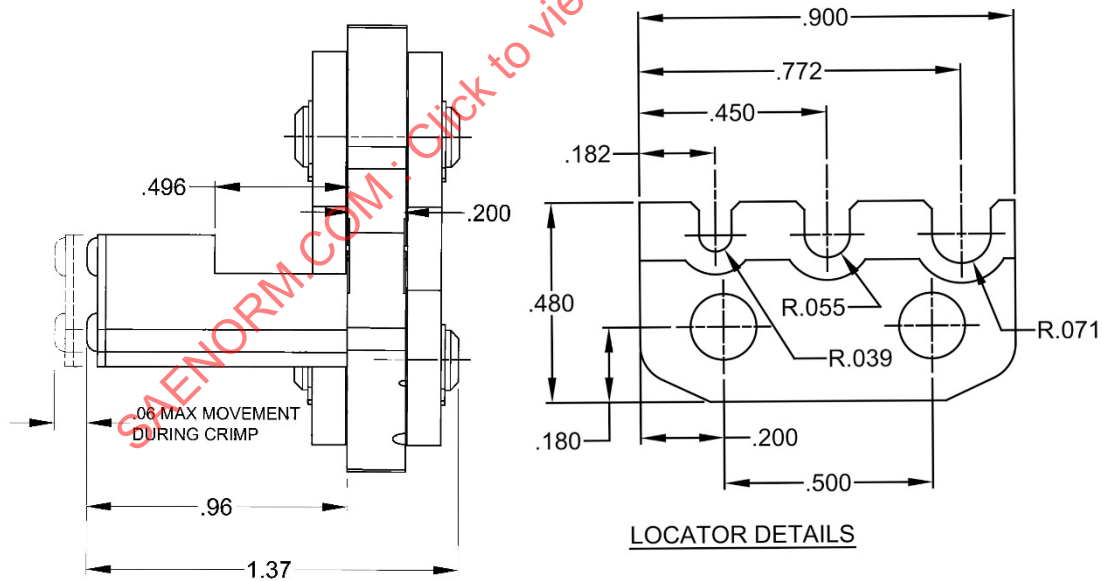


FIGURE 5 - M22520/44-01 LOCATOR DETAIL

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	CRIMPING TOOL, TYPE II, WIRE HEATLESS TERMINATION, HAND ACTUATED, WIRE SIZES 26-12		

TABLE 1 - GAGING LIMITS

WIRE SIZE	GAGING LIMITS 1/		INSPECTION CRIMP GAGE
20-26	GO - .072	NO-GO - .076	M22520/39-03
16-18	GO - .094	NO-GO - .098	
12-14	GO - .100	NO-GO - .104	

1/ SEE REQUIREMENT 8.

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

1. CONFIGURATION:

- TOOL CONFIGURATION SHALL BE IN ACCORDANCE WITH FIGURES 1 THROUGH 5.
- DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES ARE $\pm .005$ FOR THREE PLACE DECIMALS, $\pm .01$ FOR TWO PLACE DECIMALS, AND $\pm .5^\circ$ FOR ANGLES.
- OUTLINE CONFIGURATION OPTIONAL WITHIN MAXIMUM DIMENSIONS SHOWN FOR A CLOSED HANDLE POSITION.
- THE WIRE STRIP LENGTH INDICATORS SHALL BE INDENTED INTO THE JAW SURFACE (FIGURES 2 AND 4).

LOCATOR:

- ATTACH THE LOCATOR TO THE LOWER HALF OF THE CRIMP JAW AS SHOWN IN FIGURES 4 AND 5.
- LOCATOR SHALL ALIGN THE AS81824/12 SPLICE INNER METAL SLEEVE CRIMP ZONES WITH THE DIE USING A POSITIVE STOP.
- LOCATOR SHALL RETAIN THE SPLICE IN THE APPROPRIATE PLACE FOR CRIMPING, WITH THE WIRE (IN THE SIDE BEING CRIMPED) EXITING THE SPLICE ON THE LOCATOR SIDE OF THE TOOL.
- THE LOCATOR SHALL BE SPRING LOADED AND LOCATOR STOP SHALL EXTEND TO PROPERLY CRIMP THE SPLICE DUE TO ELONGATION OF THE SPLICE AFTER THE FIRST CRIMP (SEE FIGURE 5).
- THE SPRING LOADED LOCATOR SPRING RATE SHALL BE $4 \text{ LBF} \pm 1/2 \text{ LBF}$ (SEE FIGURE 5).
- LOCATOR SHALL NOT CAUSE DAMAGE TO SPLICE COMPONENT INSULATOR WHEN THE CRIMP IS PERFORMED.

2. MATERIALS:

ALL UNSPECIFIED MATERIALS SHALL WITHSTAND THE AS22520 REQUIREMENTS WITHOUT CHANGE IN PROPERTIES.

- JAWS SHALL BE ALLOY STEEL; 50 POINT CARBON MINIMUM AND HEAT TREAT TO ROCKWELL C 43-54.
- LOCATOR SHALL BE ALUMINUM OR EQUIVALENT.
- HANDLES SHALL BE ALLOY STEEL.
- GRIPS SHALL BE PLASTIC, RUBBER, OR EQUIVALENT.

3. FINISH:

ALL UNSPECIFIED METAL COMPONENTS SHALL BE PLATED OR TREATED FOR CORROSION RESISTANCE.

- JAWS AND LINK SHALL BE BLACK.
- LOCATOR SHALL BE BLACK.
- HANDLES SHALL BE CHROME PLATED (COMMERCIAL GRADE OR EQUIVALENT).
- CONVEX CRIMP SURFACES SHALL BE POLISHED TO 16 (RMS) MICRO-FINISH.

4. MARKINGS:

- JAW CAVITY MARKINGS SHOWN IN FIGURE 1 SHALL BE PERMANENTLY ETCHED (SEE TABLES 2 AND 3).
- JAWS SHALL BE PERMANENTLY ETCHED WITH THE WORDS "FOR PRE-INSULATED SPLICES ONLY" ON THE OPPOSITE SIDE OF THE CRIMP CAVITY MARKINGS.

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	CRIMPING TOOL, TYPE II, WIRE HEATLESS TERMINATION, HAND ACTUATED, WIRE SIZES 26-12		