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REV.
A

AS22520™/46

FEDERAL SUPPLY CLASS
5120

RATIONALE

REVISION IS REQUIRED TO ADD POSITIONERS FOR THE AS39029/102 AND /103 INNER CONTACTS, MAKE MINOR EDITORIAL CHANGES, AND MAKE TECHNICAL CORRECTIONS IF NEEDED.

NOTICE

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

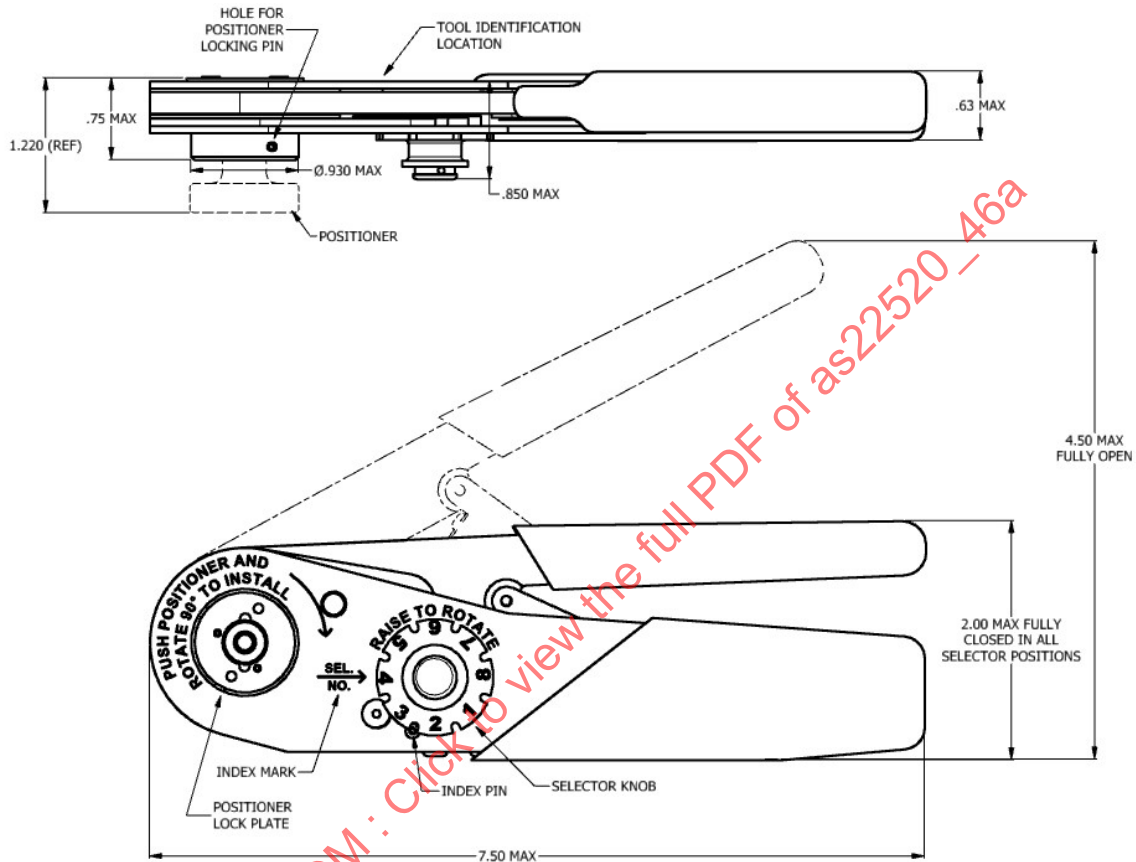
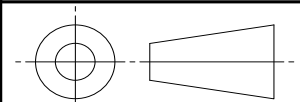


FIGURE 1 - M22520/46-01 TOOL

For more information on this standard, visit

<https://www.sae.org/standards/content/AS22520/46A/>

THIRD ANGLE PROJECTION



CUSTODIAN: AE-8C2

PROCUREMENT SPECIFICATION: AS22520



AEROSPACE STANDARD

CRIMPING TOOLS, TYPE 1, TERMINAL, HAND,
WIRE TERMINATING FOR MINIATURE CO-AXIAL
AND TRI-AXIAL INNER CONTACTS

AS22520™/46
SHEET 1 OF 7

REV.
A

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ISSUED 2018-03 REVISED 2023-01

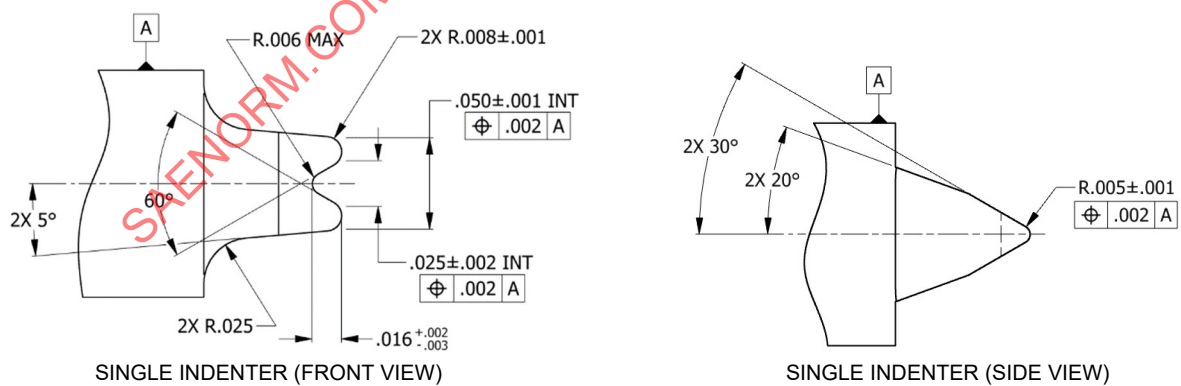
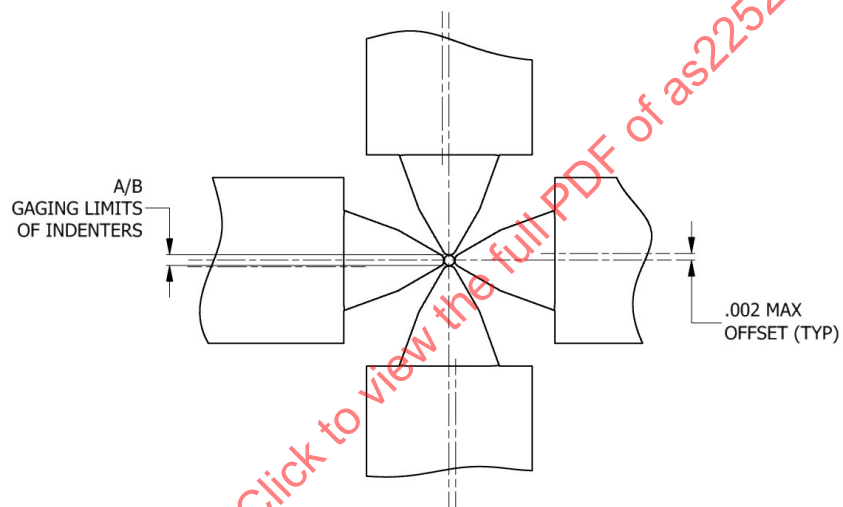
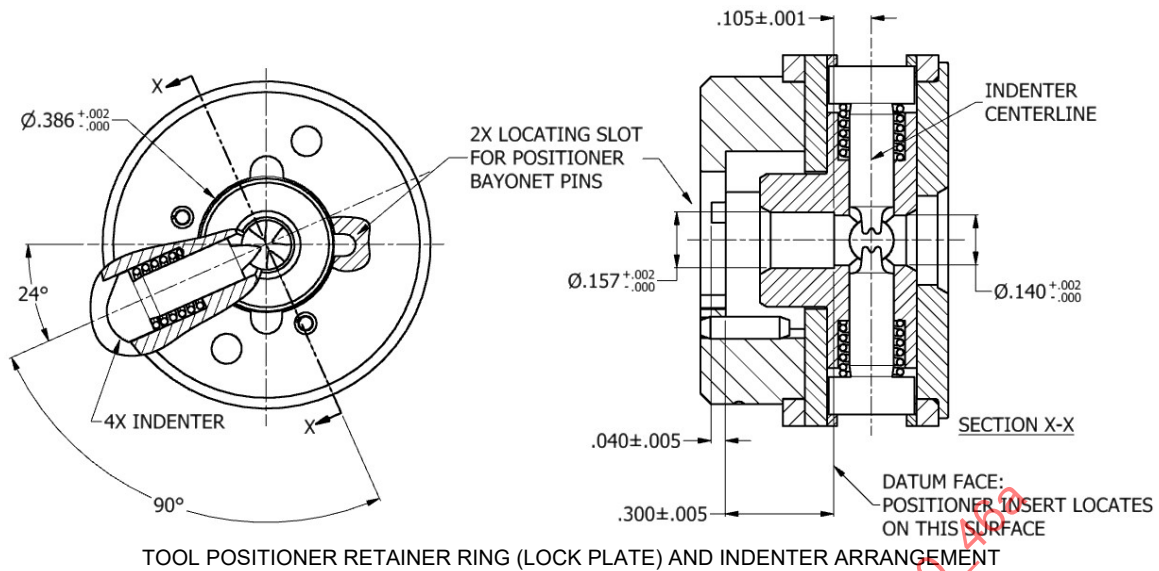
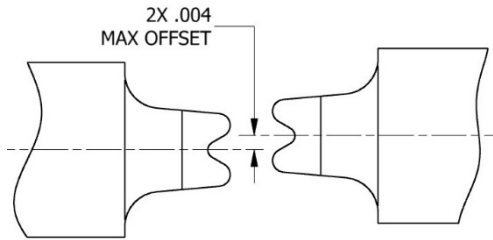


FIGURE 1 - M22520/46-01 TOOL (CONTINUED)

	AEROSPACE STANDARD	AS22520™/46 SHEET 2 OF 7	REV. A

CRIMPING TOOLS, TYPE 1, TERMINAL, HAND,
WIRE TERMINATING FOR MINIATURE CO-AXIAL
AND TRI-AXIAL INNER CONTACTS



OPPOSITE AND ADJACENT INDENTER CENTERLINES (TYP)

BASIC TOOL PART NUMBER, COLOR, AND INSPECTION GAGING INFORMATION TABLE

CRIMPING TOOL PART NO.	BODY COLOR	HANDLE GRIP COLOR	FOR INSPECTION GAGING USE
M22520/46-01	GOLD	BLACK	M22520/3-25 1/

1/ INSPECTION GAGE ONLY APPLICABLE FOR THE TOOL SET AT SELECTOR POSITION NUMBER 8 (SEE APPLICATION NOTES).

INDENTER GAGE LIMITS TABLE

SELECTOR NUMBER	GAGING LIMITS OF INDENTERS	
	INSPECTION GAGE DIAMETERS (INCHES)	
	Ø GO A ± .0001	Ø NO-GO D ± .0001
1	.0070	.0090
2	.0095	.0115
3	.0120	.0140
4	.0150	.0170
5	.0180	.0200
6	.0225	.0250
7	.0260	.0285
8	.0305	.0330

FIGURE 1 - M22520/46-01 TOOL (CONTINUED)

REQUIREMENTS: ALL COMPLETE REQUIREMENTS SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF AS22520.

1. DIMENSIONS: DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS $\pm .010$, ANGLES $\pm .5^\circ$. OUTLINE CONFIGURATION OPTIONAL WITHIN MAXIMUM DIMENSIONS SHOWN IN FIGURE 1. BREAK ALL SHARP EDGES .005 R MAX.
2. MATERIALS: UNLESS OTHERWISE SPECIFIED, MATERIAL SHALL BE IN ACCORDANCE WITH AS22520. SURFACE TEXTURE SHALL BE 63 RMS OR BETTER IN ACCORDANCE WITH ASA B46 1-1962 (ANSI).
 - 2.1 INDENTER MATERIAL SHALL BE OIL HARDENED TOOL STEEL. THE INDENTER MATERIAL SHALL BE HARDENED TO ROCKWELL "C" 56-58.
 - 2.2 RETAINER RING (LOCK PLATE) SHALL BE T3 ALUMINUM (OR EQUIVALENT) IN ACCORDANCE WITH AMS-QQ-A-225/6.
 - 2.3 POSITIONER BODY MATERIAL SHALL BE ALUMINUM AMS-QQ-A-225/6. LOCATOR SHALL BE STAINLESS STEEL PER AMS-QQ-S-763, CLASS 304 (OR EQUIVALENT).
 - 2.4 GRIP SHALL BE PLASTIC AND WITHSTAND ALL REQUIREMENTS OF AS22520.
3. IDENTIFICATION MARKING AND COLOR:
 - 3.1 TOOL IDENTIFICATION SHALL BE MARKED IN ACCORDANCE WITH MIL-STD-130, STAMP OR LASER MARKED. TOOL IDENTIFICATION SHALL INCLUDE MANUFACTURER NAME AND PART NUMBER, THE TOOL PART NUMBER M22520/46-01, AND THE INSPECTION GAGE PART NUMBER M22520/3-25. ADDITIONAL TOOL MARKING AND COLOR SHALL BE AS SHOWN IN FIGURE 1.
 - 3.2 POSITIONERS SHALL BE MARKED AS SHOWN IN FIGURE 2. MARKING SHALL BE IN ACCORDANCE WITH MIL-STD-130, STAMP OR LASER MARKED. POSITIONER COLOR SHALL BE GOLD.
 - 3.3 DATA PLATES LABELS BE SHALL BE CLEARLY MARKED AS SHOWN IN FIGURE 3. ALL LABELS SHALL HAVE BLACK LETTERS PRINTED ON A CONTRASTING BACKGROUND. LABELS SHALL STILL BE ATTACHED AND LEGIBLE AFTER ALL AS22520 REQUIREMENTS. OTHER UNSPECIFIED LABELS ARE PERMISSIBLE ON TOOL FRAME AND POSITIONER.

	AEROSPACE STANDARD	AS22520™/46 SHEET 3 OF 7	REV. A
	CRIMPING TOOLS, TYPE 1, TERMINAL, HAND, WIRE TERMINATING FOR MINIATURE CO-AXIAL AND TRI-AXIAL INNER CONTACTS		

M22520/46-02, -03, -04, AND -05 POSITIONERS

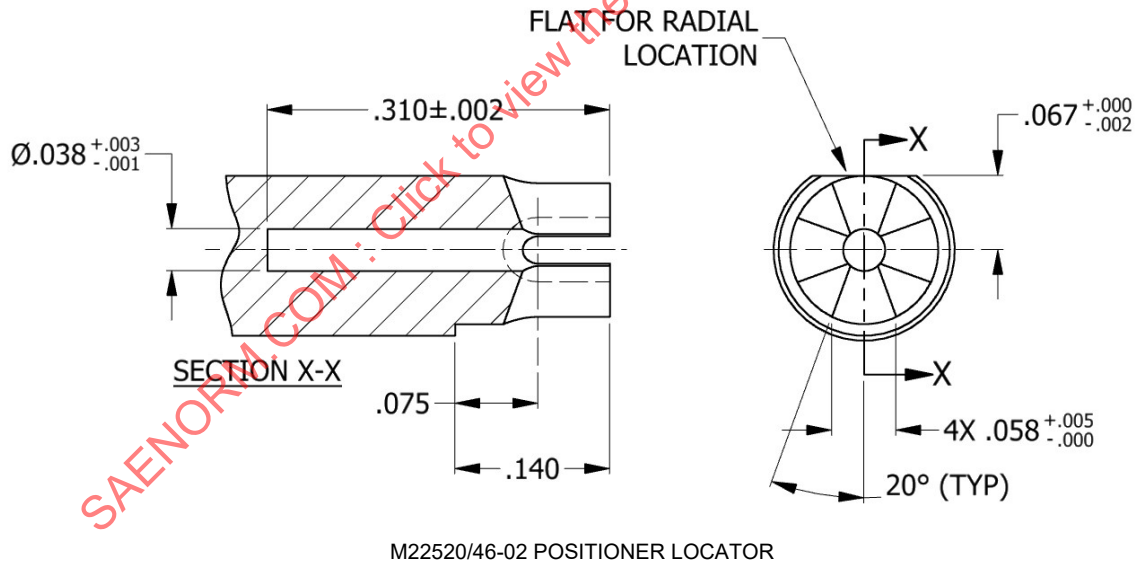
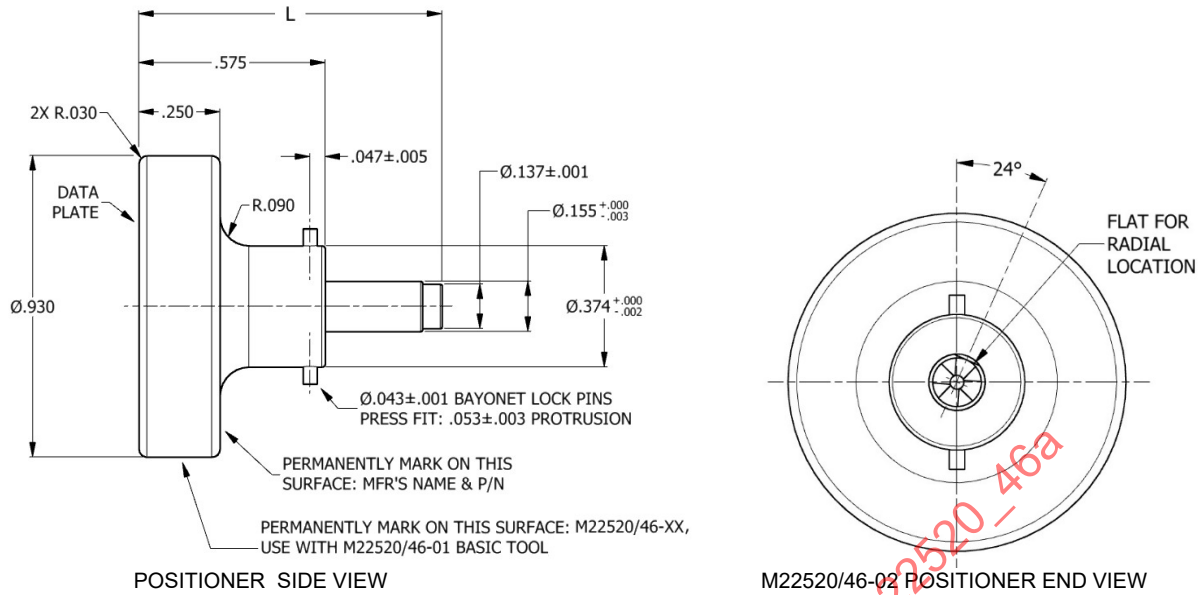


FIGURE 2 - M22520/46-02, 03, -04 , AND -05 POSITIONERS