

SAE Technical Standards Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

SAE reviews each technical report at least every five years at which time it may be reaffirmed, revised, stabilized or cancelled. SAE invites your written comments and suggestions.

SAE AS5259/3

FEDERAL SUPPLY CLASS
5120

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.

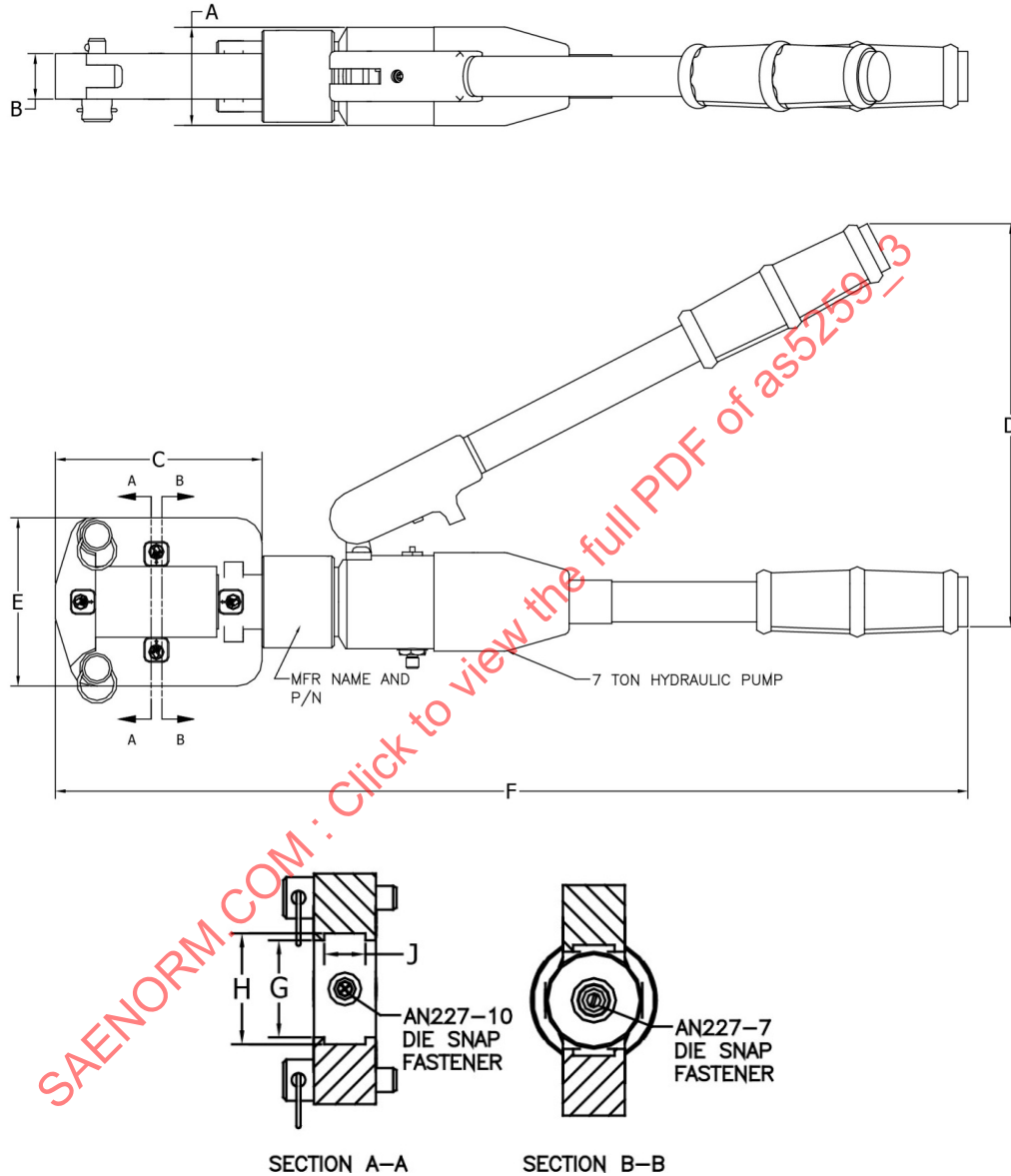
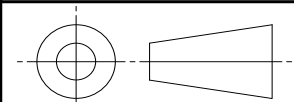


FIGURE 1 - AS5259/3-01 BASIC CRIMPING TOOL WITHOUT DIES

SAE values your input. To provide feedback
on this Technical Report, please visit
<http://www.sae.org/technical/standards/AS5259/3>

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

Copyright 2012 SAE International

All rights reserved. No part of this publication may be reproduced, stored in a retrieval system or transmitted, in any form or by any means, electronic, mechanical, photocopying, recording, or otherwise, without the prior written permission of SAE.

TO PLACE A DOCUMENT ORDER: Tel: 877-606-7323 (inside USA and Canada)
Fax: 724-776-0790

Tel: +1 724-776-4970 (outside USA)
Email: CustomerService@sae.org

SAE WEB ADDRESS: <http://www.sae.org>

ISSUED 2012-02

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

4. CRIMP COMPRESSION FORCE SHALL BE 14 000 lbs.
5. CORROSION TEST NOT REQUIRED.
6. BASIC TOOL PART NUMBER SHALL BE M5259/3-01.
7. SUPPLIER SYMBOL, IF USED, SHALL BE IN ACCORDANCE AIR 1351.
8. 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.