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REV.
A

AS22520™/6

FEDERAL SUPPLY CLASS
5220

RATIONALE

REVISION REQUIRED TO ADD ADDITIONAL GAGES FOR M22520/5 AND /10 CRIMP DIES AND ADDRESS MINOR TECHNICAL CHANGES.

NOTICE

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

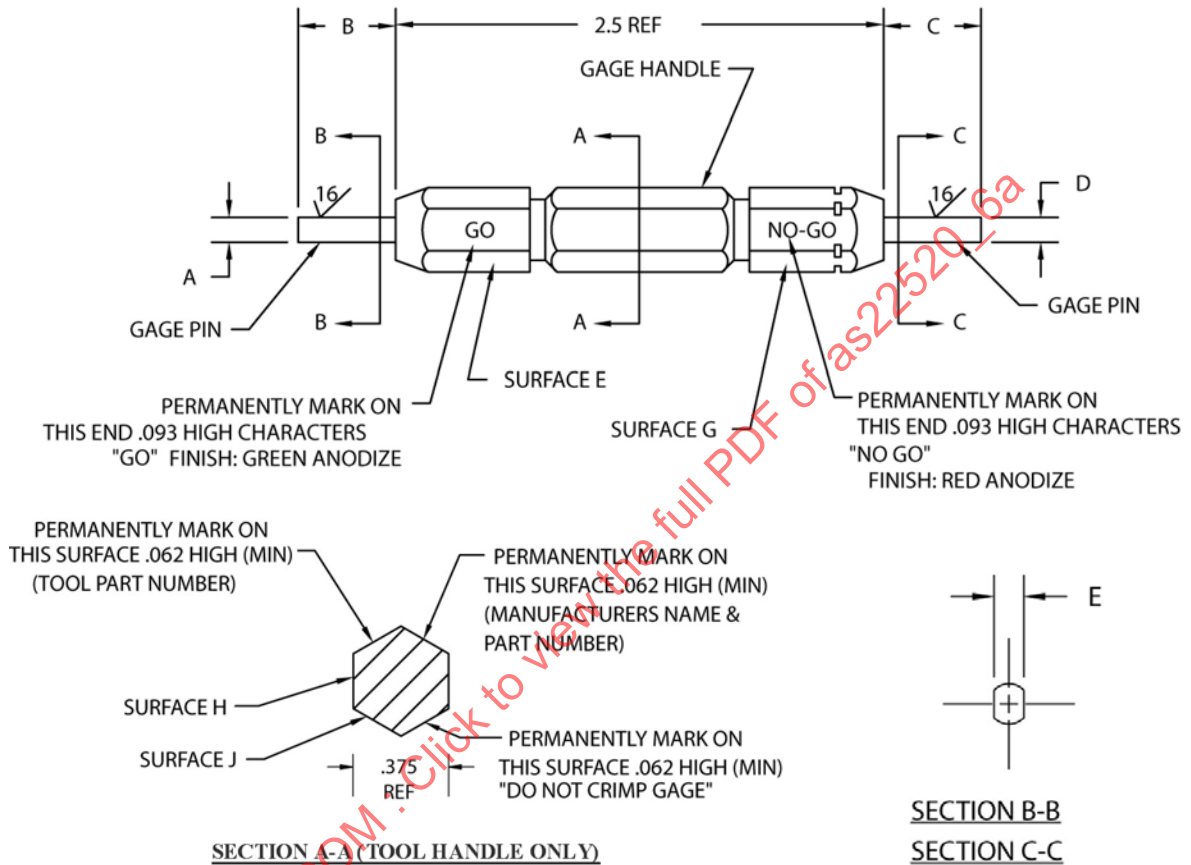
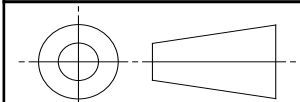


FIGURE 1 - INSPECTION GAGE

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS22520/6A>

THIRD ANGLE PROJECTION



CUSTODIAN: AE-8/AE-8C2

PROCUREMENT SPECIFICATION: AS22520



AEROSPACE STANDARD

(R) CRIMPING TOOLS, TERMINAL, HAND, WIRE TERMINATION; IN-SERVICE INSPECTION GAGES FOR TYPE III AS22520/5, /10, AND MIL-T-22520/32 (CANCEL) CRIMP TOOLS

AS22520™/6
SHEET 1 OF 4

REV.
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ISSUED 2012-04 REVISED 2015-12

TABLE 1 - CONFIGURATION AND GAGE APPLICATIONS

PART NO. M22520/6-	A DIA. +.0002 -.0000	B ±.02	C ±.02	D DIA. -.0002 +.0000	E -.005	STAMPING / MARKING			
						SURFACE E .093 HIGH	SURFACE G .093 HIGH	SURFACE H .062 HIGH	SURFACE J .062 HIGH STAMP OR MARK "DIE M22520/5- "
001	.1015	.50	.50	.1085	.062	.1015	.1085	FOR M22520/5 & /10 CRIMP DIES	03B,-33B
002	.1145			.1215	.062	.1145	.1215		17A,-04B
003	.1245			.1315	.062	.1245	.1315		03A,-06A,-35B
004	.1475			.1545	.062	.1475	.1545		37B
005	.1565			.1635	.125	.1565	.1635		39B
006	.1745			.1815	.125	.1745	.1815		09A,-05B,-41B
007	.1935			.2005	.125	.1935	.2005		43B
008	.2095			.2165	.125	.2095	.2165		05A,-11A,-57A, -19B
009	.2145			.2215	.125	.2145	.2215		45B
010	.2275			.2345	.125	.2275	.2345		45A
011	.2515			.2585	.125	.2515	.2585		07A,-13A,-19A, -59A
012	.2595			.2665	.125	.2595	.2665		15A
013	.2645			.2715	.125	.2645	.2715		43A
014	.2865			.2935	.125	.2865	.2935		41A
015	.3055			.3125	.125	.3055	.3125		39A
016	.3105			.3175	.125	.3105	.3175		37A
017	.3205			.3275	.125	.3205	.3275		29A,-35A,-55A
018	.3395			.3465	.125	.3395	.3465		33A
019	.3555			.3625	.125	.3555	.3625		47A
020	.3805			.3875	.125	.3805	.3875		23A
021	.3975			.4045	.125	.3975	.4045		49A
022	.4255			.4325	.125	.4255	.4325		25A,-61A
023	.4275			.4345	.125	.4275	.4345		51A
024	.4505			.4575	.125	.4505	.4575		53A
025	.4715			.4785	.125	.4715	.4785		21A
026	.4975			.5045	.125	.4975	.5045		31A
027	.5285			.5355	.125	.5285	.5355		27A
028	.1345			.1415	.125	.1345	.1415		04A
029	.0645			.0715	.062	.0645	.0715		02B,-09B,-11B, -13B,-15B
030	.0875			.0945	.062	.0875	.0945		02A
031	.0965			.1035	.062	.0965	.1035		25B,-29B,-57B, -59B
032 1/	.1025			.1065	.062	.1025	.1065	M22520/32-01 TOOL	HEX

1/ M22520/6-032 IS NOT RECOMMENDED FOR USE. MIL-T-22520/32-01 WAS CANCELED WITHOUT REPLACEMENT.



AEROSPACE STANDARD

(R) CRIMPING TOOLS, TERMINAL, HAND, WIRE TERMINATION;
IN-SERVICE INSPECTION GAGES FOR TYPE III AS22520/5, /10,
AND MIL-T-22520/32 (CANCEL) CRIMP TOOLS

AS22520™/6
SHEET 2 OF 4

REV.
A

REQUIREMENTS: AS SPECIFIED IN AS22520.

1. DIMENSIONS: UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES AS SPECIFIED IN FIGURE 1 AND TABLE 1. CONFIGURATION IS OPTIONAL WITHIN DEFINED DIMENSIONS. TOLERANCES ARE DECIMALS $\pm .010$ INCHES. DIMENSIONS A AND D APPLY AFTER PROTECTIVE COATING (SEE REQUIREMENT 3).

2. MATERIAL:

GAGE PINS: ALLOY TOOL STEEL PER ASTM A681, ASTM A295, OR EQUIVALENT (CLASS OPTIONAL). HARDEN TO ROCKWELL C58-64.

GAGE HANDLE: ALUMINUM ALLOY, ASTM B211 ALUMINUM AND ALUMINUM-ALLOY BAR, ROD, AND WIRE.

3. FINISH: GAGE PINS; CHROME PLATE WITH ADEQUATE COVERAGE FOR CORROSION AND WEAR RESISTANCE PER AMS-QQ-C-320 PLATING CHROMIUM, CLASS I, TYPE II WITH A THICKNESS OF .00003 INCHES MINIMUM.

GAGE HANDLE: ANODIZED IN ACCORDANCE WITH MIL-A-8625 OR EQUIVALENT.

4. MARKING: UNLESS OTHERWISE SPECIFIED, STAMPING SHALL BE INDENTED. LASER ETCHING IS ALSO ACCEPTABLE.

5. STORAGE CONTAINER: EACH GAGE SHALL BE FURNISHED WITH A SUITABLE CONTAINER.

APPLICATION NOTES:

1. TOOL USED AS GO/NO-GO VERIFICATION INSPECTION GAGES FOR AS22520/5 AND /32 TOOLS SPECIFIED IN TABLE 1.

TABLE 2 - CRIMP TOOL APPLICATIONS OF INSPECTION GAGES

GAGE PART NUMBER M22520/6-	CRIMP TOOL PART NUMBERS			
	AS22520/5		AS22520/10	
	DIE CLOSURE A	DIE CLOSURE B	DIE CLOSURE A	DIE CLOSURE B
001		-03,-33	-11	-05
002	-17	-04	-09	-04
003	-03,-06	-35	-05, -08, -10, -13	
004		-37	-15	
005		-39	-06	
006	-09	-05,-41	-17	-07
007		-43	-19	
008	-05,-11,-57	-19	-07, -21	
009	-105	-45	-23	
010	-45		-25	
011	-07,-13,-19,-59		-03, -27	
012	-15			
013	-43			
014	-41			
015	-39			
016	-37			
017	-29,-35,-55			
018	-33			
019	-47			
020	-23			
021	-49			
022	-25,-61			
023	-51			
024	-53			
025	-21			
026	-31			
027	-27			
028	-04		-04	
029		-02,-09,-11,-13,-15		-02
030	-02		-02	
031		-25,-29,-57,-59		
032	M22520/32-01 <u>1/</u>			
.033	-	-	-105	
.034	-	-		-105

1/ MILITARY SPECIFICATION MIL-T-22520/32 IS CANCELED WITHOUT REPLACEMENT.

	AEROSPACE STANDARD	AS22520™/6 SHEET 3 OF 4	REV. A
	(R) CRIMPING TOOLS, TERMINAL, HAND, WIRE TERMINATION; IN-SERVICE INSPECTION GAGES FOR TYPE III AS22520/5, /10, AND MIL-T-22520/32 (CANCEL) CRIMP TOOLS		