

RATIONALE

FEDERAL SUPPLY CLASS
5220

AS22520/39 PERMITS THE CANCELLATION AND SUPERSESION OF MIL-DTL-22520 /39 WITH THIS DOCUMENT. IT INCLUDES APPLICABLE ENGINEERING POSITION LETTERS, MILITARY SPECIFICATION AMENDMENTS, AND MINOR TECHNICAL CHANGES REQUIRED TO REFLECT THE APPROVED QUALIFIED TOOLS. GOVERNMENT DOCUMENTATION REFERENCES ARE REMOVED.

NOTICE

THE REQUIREMENTS FOR PROCURING THE CONTACTS DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION AND THE LATEST ISSUE OF: SAE AS22520

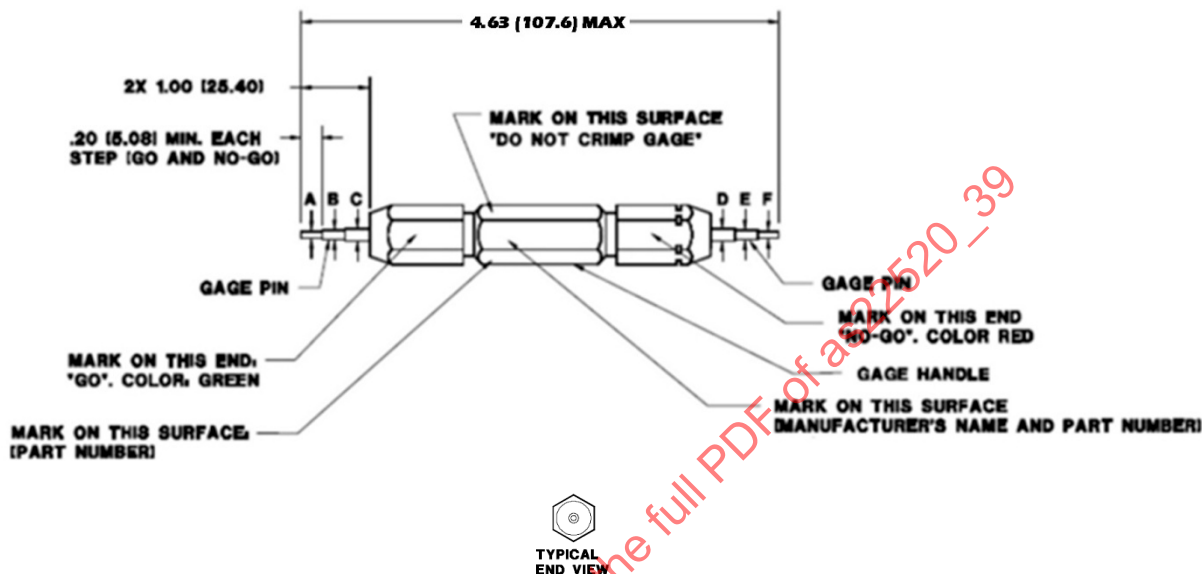
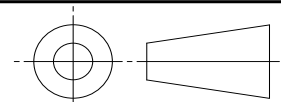


FIGURE 1 – AS22520/39-01 GAGE FOR AS22520/37-01 AND AS22520/44-01 CRIMPING TOOLS

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS22520/39>

THIRD ANGLE PROJECTION



CUSTODIAN: AE-8/AE-8C1

PROCUREMENT SPECIFICATION: AS22520

SAE Aerospace
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AEROSPACE STANDARD

CRIMPING TOOL, TERMINAL, HAND, ACTUATED, WIRE TERMINATION, IN-SERVICE INSPECTION GAGE FOR AS22520/5, /37, /38, AND /44 CRIMP TOOLS

SAE AS22520/39
SHEET 1 OF 3

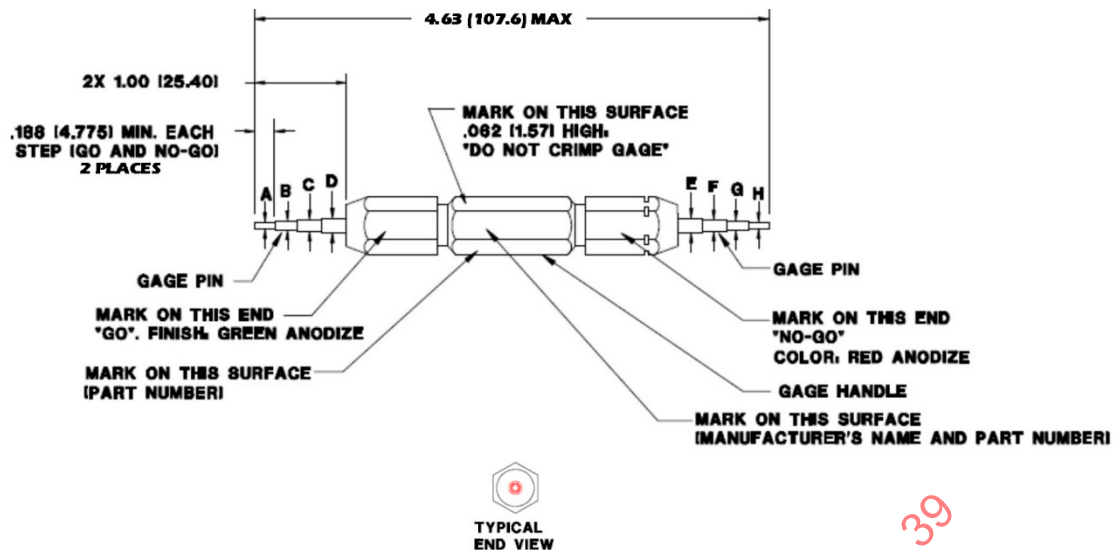


FIGURE 2 – AS22520/39-02 GAGE FOR AS22520/38-01 CRIMPING TOOL

TABLE 1 – GAGE PIN DIMENSIONS

PART NO.	GAGE TIP DIAMETER							
	A	B	C	D	E	F	G	H
M22520/39-01	0.0250 (0.635)	0.0420 (1.067)	0.0620 (1.575)	0.0720 (1.829)	0.0520 (1.321)	0.0350 (0.889)	---	---
M22520/39-02	0.030 (0.762)	0.0750 (1.905)	0.1140 (2.896)	0.1480 (3.759)	0.1540 (3.912)	0.1200 (3.048)	0.0950 (2.413)	0.0500 (1.27)
M22520/39-03	.068 (1.7)	.090 (2.3)	.096 (2.4)	.100 (2.5)	.094 (2.4)	.072 (1.8)	---	---

TABLE 2 - GAGE/CRIMP CAVITY APPLICATION

GAGE PIN SURFACE	M22520 CRIMP TOOLS 1/		M22520/38-02 TOOL	
	GAGE - DIE CAVITY	DIE COLOR CODE	GAGE - DIE CAVITY	DIE COLOR CODE
A	GREEN/GO - A	RED	GREEN GO - A/B	RED/BLUE
B	GREEN/GO - B	BLUE	GREEN GO - C	YELLOW
C	GREEN/GO - C	YELLOW	GREEN GO - E	WHITE
D	RED/NO GO - C	YELLOW	GREEN GO - D	GREEN
E	RED/NO GO - B	BLUE	RED NO GO - D	GREEN
F	RED/NO GO - A	RED	RED NO GO - E	WHITE
G	---	---	RED NO GO - C	YELLOW
H	---	---	RED NO GO - H	RED/BLUE

1/ APPLICABLE CRIMP TOOLS ARE AS22520/37-01, /44-01 AND /5-01 (DIES AS22520/5-107 AND -108)