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AS22520™/43

FEDERAL SUPPLY CLASS
5220

RATIONALE

AS22520/43 PERMITS THE CANCELLATION AND SUPERSESSION OF MIL-DTL-22520/43 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.

AS22520/43 HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

NOTICE

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

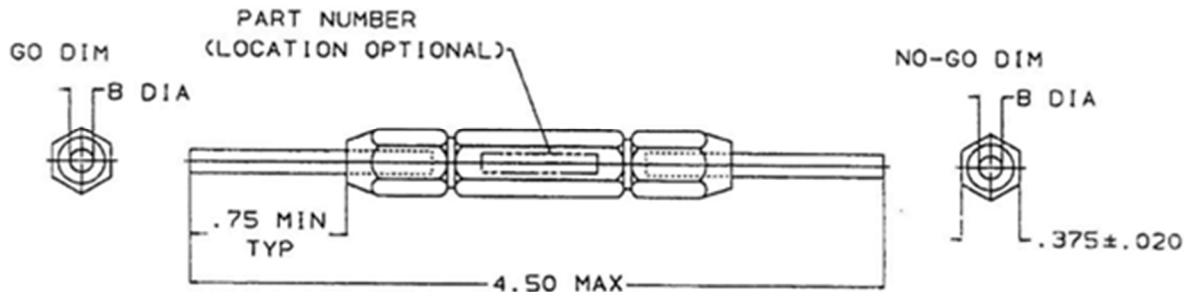


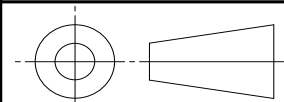
FIGURE 1 – CRIMP TOOL WIRE BARREL INSPECTION GAGE

TABLE 1 – WIRE BARREL INSPECTION GAGE DESIGN CONFIGURATION AND APPLICATION

TOOL PART NO.	WIRE RANGE	B GO DIM.	B NO-GO DIM.	TOOL TO BE INSPECTED
M22520/43-01	22-16	0.1090-0.1093	0.1149-0.1150	M22520/40-01
M22520/43-02	16-14	0.1190-0.1193	0.1249-0.1250	

For more information on this standard, visit
<https://www.sae.org/standards/content/AS22520/43/>

THIRD ANGLE PROJECTION



CUSTODIAN: AE-8C2

PROCUREMENT SPECIFICATION: AS22520



AEROSPACE STANDARD

CRIMPING TOOLS, TERMINAL, HAND, WIRE
TERMINATION; IN-SERVICE
INSPECTION GAGE FOR AS22520/40 CRIMP TOOLS

AS22520™/43
SHEET 1 OF 2

Documents

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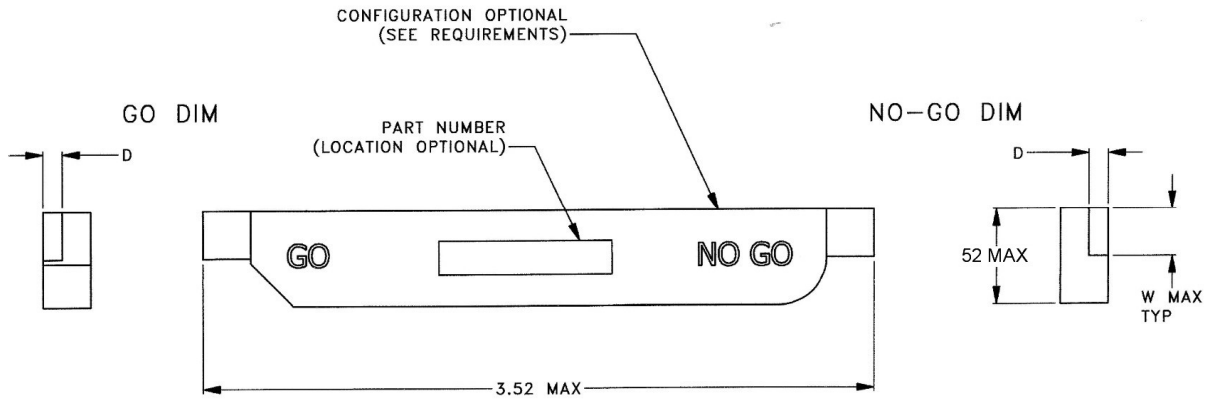


FIGURE 2 – CRIMP TOOL INSULATION BARREL INSPECTION GAGE

TABLE 2 – INSULATION BARREL INSPECTION GAGE DESIGN CONFIGURATION AND APPLICATION

TOOL PART NO.	WIRE RANGE	D GO DIM.	D NO-GO DIM.	W MAX	TOOL TO BE INSPECTED
M22520/43-03	22-16	0.0300-0.0303	0.1099-0.1100	0.125	M22520/40-01
M22520/43-04	16-14	0.0400-0.0403	0.1199-0.1200	0.125	

REQUIREMENTS: AS SPECIFIED IN AS22520.

- DIMENSIONS: UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES AS SPECIFIED IN FIGURES AND TABLES. CONFIGURATION IS OPTIONAL WITHIN DEFINED DIMENSIONS. TOLERANCES ARE DECIMALS ± 0.005 INCHES AND ± 5 DEGREES. DIMENSIONS B AND D APPLY AFTER PROTECTIVE COATING (SEE REQUIREMENT 3).
- MATERIAL:

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

WIRE BARREL GAGE HANDLE: ALUMINUM ALLOY, ASTM B211 ALUMINUM AND ALUMINUM-ALLOY BAR, ROD, AND WIRE
- FINISH: WIRE BARREL GAGE PINS AND INSULATION BARREL INSPECTION GAGE; 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. HANDLE IS ANODIZED.
- MARKING: UNLESS OTHERWISE SPECIFIED, STAMPING SHALL BE INDENTED OR LASER ETCHED. SUPPLIER NAME SHALL BE COMPLETE OR BE AN AIR1351 LISTED LOGO
- STORAGE CONTAINER: GAGES SHALL BE FURNISHED WITH A SUITABLE CONTAINER.

APPLICATION NOTES:

- TOOL IS USED AS A GO/NO-GO VERIFICATION INSPECTION GAGE FOR THE AS22520 TOOLS SPECIFIED IN TABLE 1 AND 2.

	AEROSPACE STANDARD	AS22520™/43 SHEET 2 OF 2	
	CRIMPING TOOLS, TERMINAL, HAND, WIRE TERMINATION; IN-SERVICE INSPECTION GAGE FOR AS22520/40 CRIMP TOOLS		



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