

## RATIONALE

AS22520/47 IS REQUIRED TO PROVIDE A STANDARD CRIMP TOOL FOR THE AS7928/15 FLAG TERMINAL SIZES 22-10.

AS22520/47 HAS BEEN REAFFIRMED TO COMPLY WITH THE SAE FIVE-YEAR REVIEW POLICY.

## NOTICE

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

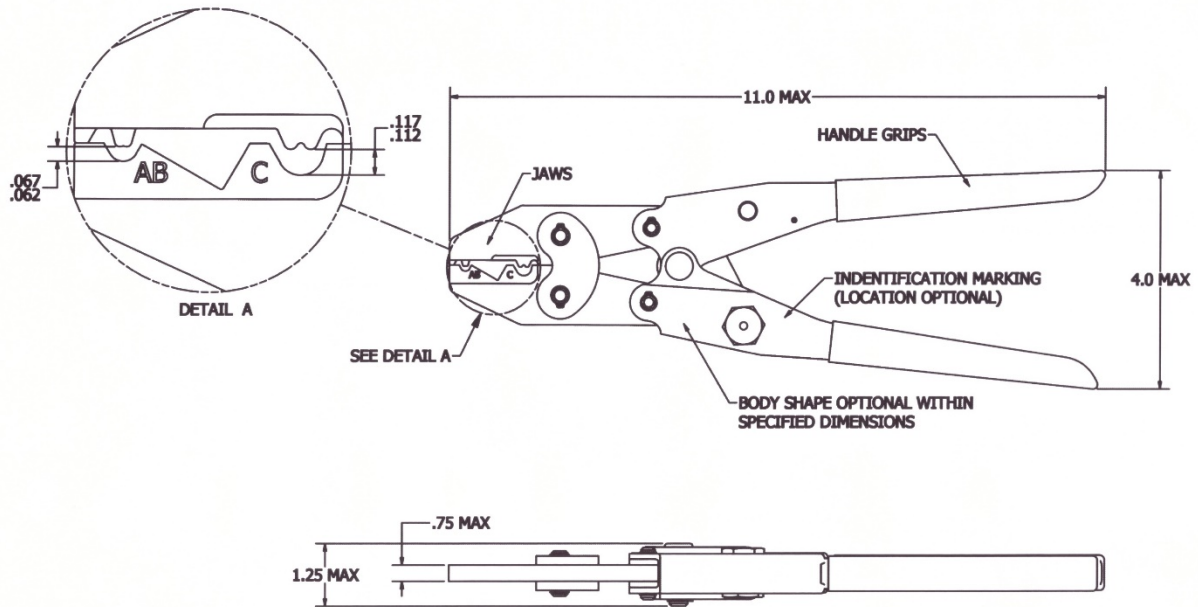


FIGURE 1 - TOOL FRAME

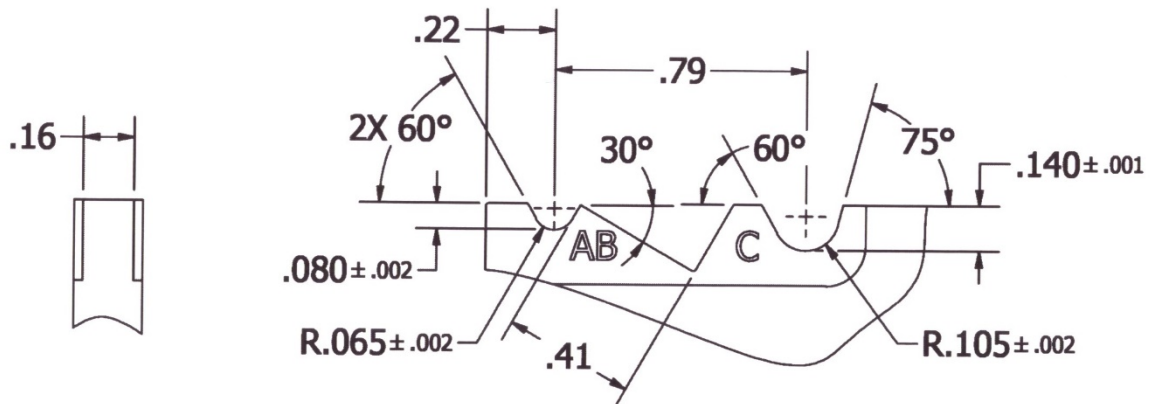
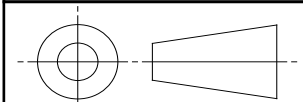


FIGURE 2 - LOWER DIE FOR TOOL FRAME JAWS (SEE REQUIREMENT 1)

For more information on this standard, visit  
<https://www.sae.org/standards/content/AS22520/47/>

THIRD ANGLE PROJECTION



CUSTODIAN: AE-8/AE-8C2

PROCUREMENT SPECIFICATION: AS22520



## AEROSPACE STANDARD

CRIMPING TOOL, TERMINAL, HAND ACTUATED, WIRE TERMINATION, TYPE II, FOR FLAG SHAPE LUG TERMINAL SIZES 22-10

AS22520™/47  
SHEET 1 OF 4

Documents

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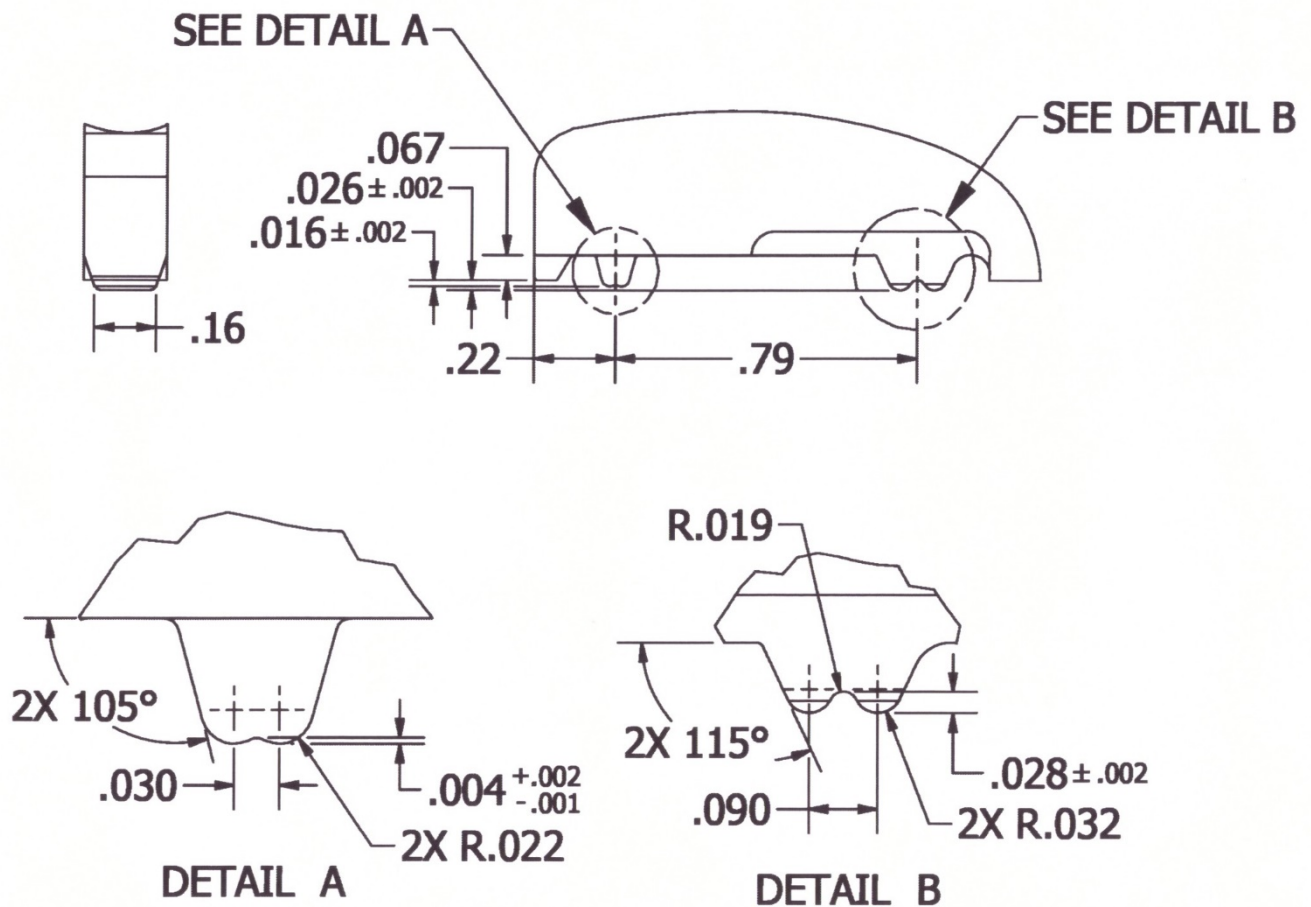


FIGURE 3 - UPPER DIE FOR TOOL FRAME JAWS (SEE REQUIREMENT 1)

#### REQUIREMENTS:

##### 1. CONFIGURATION:

TOOL SHALL BE AS SHOWN IN FIGURE 1. DIMENSIONS ARE INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES ARE ±.01 (0.25 MM) FOR TWO PLACE DECIMALS ±0.001, THREE PLACE DECIMALS, AND ANGLES ±.05°.

OUTLINE CONFIGURATION OPTIONAL WITHIN MAXIMUM DIMENSIONS SHOWN FOR A CLOSED HANDLE POSITION.

CRIMPING DIES, IF SUPPLIED, SHALL BE FIXED OR REMOVABLE. IF CRIMPING DIES ARE NOT USED, THE CRIMP CAVITIES SHOWN IN FIGURES 2 AND 3 SHALL BE CONFIGURED INTO THE CRIMP TOOL JAWS. REMOVABLE DIES SHALL BE INCLUDED AS PART OF THE CRIMPING TOOL (SEE MARKING). MANUFACTURER'S REMOVABLE DIE PART NUMBERS SHALL BE INCLUDED IN THE TOOL INSTRUCTION.

##### 2. MATERIALS:

JAWS SHALL BE 50 POINT CARBON MINIMUM ALLOY STEEL HEAT TREAT ROCKWELL C 43-54 OR EQUIVALENT.

HANDLES SHALL BE STEEL OR EQUIVALENT.

GRIPS SHALL BE PLASTIC, RUBBER, OR EQUIVALENT (COLOR ORANGE).

##### 3. FINISH:

STEEL SURFACES SHALL BE BLACK OXIDE OR EQUIVALENT.

|                                                                                     |                                                                                                                  |  |                    |                                                                                       |
|-------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------|--|--------------------|---------------------------------------------------------------------------------------|
|  | <b>AEROSPACE STANDARD</b>                                                                                        |  | <b>AS22520™/47</b> |  |
|                                                                                     | CRIMPING TOOL, TERMINAL, HAND ACTUATED, WIRE<br>TERMINATION, TYPE II, FOR FLAG SHAPE LUG TERMINAL<br>SIZES 22-10 |  | SHEET 2 OF 4       |                                                                                       |

