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REV.
B

AS5259™/3

FEDERAL SUPPLY CLASS
5120

RATIONALE

CRIMP FORCE WAS INCREASED TO 12 US TONS OF FORCE ON THE DIES AT COMPLETION OF THE CRIMP CYCLE. THIS WAS NEEDED TO UTILIZE ALL THE CRIMPING DIES WHICH ARE AVAILABLE TO THIS TOOL, AND TO TERMINATE CRIMP BARREL SIZES 8 THRU 4/0.

NOTICE

THE COMPLETE REQUIREMENTS FOR PROCURING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF SAE AS5259.

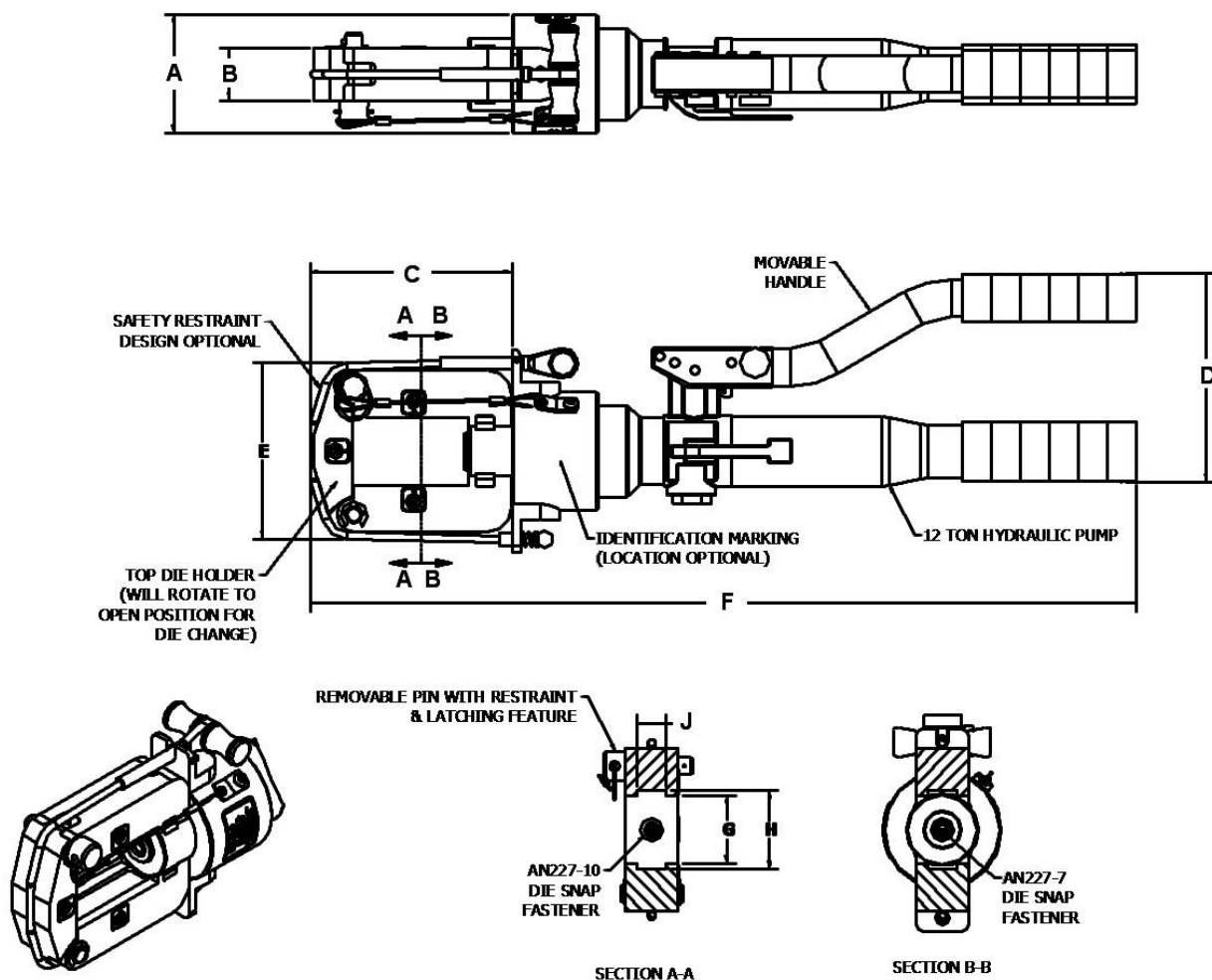
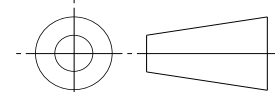


FIGURE 1 - M5259/3-01 BASIC CRIMPING TOOL WITHOUT DIES

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<http://standards.sae.org/AS5259/3B>

THIRD ANGLE PROJECTION



CUSTODIAN: AE-8/AE-8C2

PROCUREMENT SPECIFICATION: AS5259



AEROSPACE STANDARD

(R) CRIMPING TOOL AND ACCESSORIES, HAND OPERATED,
DIE TYPE, WIRE SIZES 8 TO 0000 UN-INSULATED AND
INSULATED CRIMP BARRELS

AS5259™/3
SHEET 1 OF 4

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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
M5259/3-01	3.13	1.5	5.25	6 CLOSED 14 OPEN	4.75	22.00	<u>1.781</u> 1.719	<u>2.015</u> 2.003	<u>.760</u> .755

REQUIREMENTS: AS SPECIFIED IN AS5259.

1. DESIGN AND CONFIGURATION:

- BASIC TOOL DIMENSIONS SHALL BE IN INCHES AND IN ACCORDANCE WITH TABLE 1 AND FIGURE 1. TOLERANCES SHALL BE $\pm .015$ AND ANGLES $\pm 1^\circ$.
- 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.
- MAXIMUM WEIGHT WITH HEAVIEST DIE SPECIFIED IN TABLE 2 SHALL BE 16 POUNDS MAXIMUM.
- 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.
- SAFETY RESTRAINT (DESIGN OPTIONAL) SHALL BE CAPABLE OF RESTRAINING METAL COMPONENTS IF A FRACTURE OCCURS UNDER PRESSURE. IT SHALL BE OF MINIMAL PROFILE AND DETACHABLE/RE-ATTACHABLE FOR DIE CHANGE OPERATION.

2. MATERIALS:

- REMOVABLE PINS, TOP DIE HOLDER, AND OTHER HEAD ASSEMBLY COMPONENT SHALL BE TOOL STEEL IN ACCORDANCE WITH AMS6359 HEAT TREATED TO 42 TO 44 HRC OR A COMPARABLE MATERIAL/HARDNESS. TO WITHSTAND A CRIMP FORCE OF 24000 POUNDS.
- FINISH SHALL BE BLACK OXIDE OR SUITABLE FINISH TO RESIST CORROSION.
- HANDLE GRIPS SHALL BE NON-SLIP COMPRESSIBLE PLASTIC OR RUBBER DESIGNED TO MEET THE PERFORMANCE REQUIREMENT OF AS5259.

3. DIES ARE IN ACCORDANCE WITH AS5259/7 (SEE TABLE 2 FOR DIE APPLICATION).

4. INSPECTION GAGES IN ACCORDANCE WITH AS5259/6 (SEE TABLE 2 FOR GAGE APPLICATION).

5. CRIMP COMPRESSION FORCE SHALL BE 24000 POUNDS.

6. CORROSION TEST NOT REQUIRED.

7. BASIC TOOL PART NUMBER SHALL BE M5259/3-01.

8. IDENTIFICATION MARKING SHALL BE SUPPLIER NAME OR SYMBOL, SUPPLIER PART NUMBER AND SAE INTERNATIONAL PART NUMBER (M5259/3-01). LOCATION IS OPTIONAL. SUPPLIER SYMBOL SHALL BE IN ACCORDANCE AIR1351.

M5259 /3 -01

| | | _____ TOOL DASH NUMBER
| | | _____ DETAIL SPECIFICATION NUMBER
| | | _____ BASIC PART NUMBER

9. 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.

APPLICATIONS

1. GO/NO-GO GAGE INSPECTION IS RECOMMENDED AT PERIODIC INTERVALS (SEE AS5259/6 FOR INSPECTION GAGES).
2. BASIC TOOL, DIES, AND GAGES ARE PROCURED SEPARATELY, BUT MAY ALL BE INCLUDED IN ONE STORAGE UNIT (SEE AS5259).

	AEROSPACE STANDARD	AS5259™/3 SHEET 2 OF 4	REV. B
	(R) CRIMPING TOOL AND ACCESSORIES, HAND OPERATED, DIE TYPE, WIRE SIZES 8 TO 0000 UN-INSULATED AND INSULATED CRIMP BARRELS		