

SAE Executive Standards Committee Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

SAE reviews each technical report at least every five years at which time it may be revised, reaffirmed, stabilized, or cancelled. SAE invites your written comments and suggestions.

AS5259™/4

FEDERAL SUPPLY CLASS
5120

RATIONALE

AS5259/4 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 SAE AS5259.

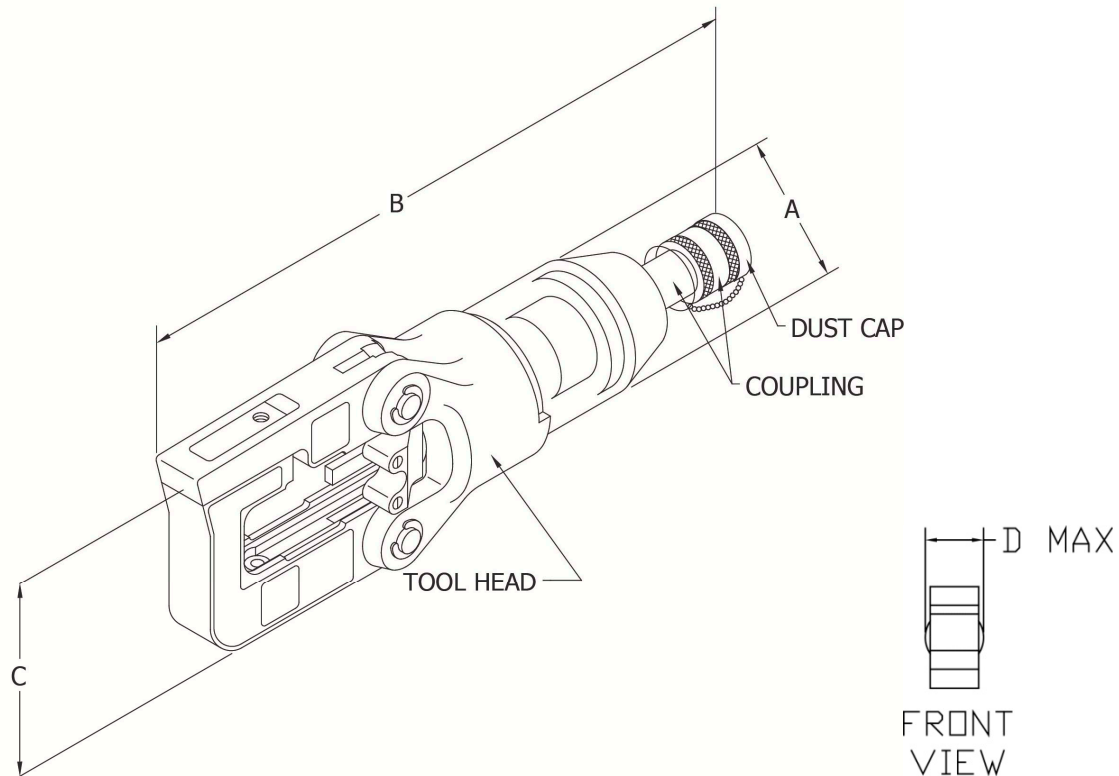


FIGURE 1 - AS5259/4-01 BASIC CRIMPING TOOL WITHOUT DIES

TABLE 1 - BASIC CRIMPING TOOL CONFIGURATION WITHOUT DIES

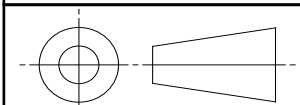
PART NO 1/	A DIA MAX	B MAX 2/	C MAX	D MAX
M5259/4-01	2.5	9.25	3.0	2.25

1/ DETAIL INTERFACE DIMENSIONS ARE SPECIFIED ON THE DIES (SEE TABLE 2 AND AS5259/7).

2/ OVERALL MAXIMUM LENGTH AFTER ASSEMBLY.

For more information on this standard, visit
<https://www.sae.org/standards/content/AS5259/4/>

THIRD ANGLE PROJECTION



CUSTODIAN: AE-8/AE-8C2

PROCUREMENT SPECIFICATION: AS5259



AEROSPACE STANDARD

CRIMPING TOOL AND ACCESSORIES,
REMOTE CRIMP HEAD, HYDRAULIC,
WIRE SIZE 8 TO 00 UN-INSULATED AND
8 THRU 2 INSULATED CRIMP BARRELS

AS5259™/4
SHEET 1 OF 3

Documents

Copyright © 2022 SAE International

All rights reserved. No part of this publication may be reproduced, stored in a retrieval system or transmitted, in any form or by any means, electronic, mechanical, photocopying, recording, or otherwise, without the prior written permission of SAE.

TO PLACE A DOCUMENT ORDER: Tel: 877-606-7323 (inside USA and Canada)
Fax: 724-776-0790

Tel: +1 724-776-4970 (outside USA)
Email: CustomerService@sae.org

SAE WEB ADDRESS: <http://www.sae.org>

1. CONFIGURATION:

- A. DIMENSIONS SHALL BE IN INCHES AND IN ACCORDANCE WITH TABLE 1. UNLESS OTHERWISE SPECIFIED TOLERANCES SHALL BE ± 0.015 AND ANGLES ± 1 DEGREE.
- B. BASIC TOOL CONFIGURATION SHALL BE OPTIONAL WITHIN ENVELOPE DEFINED BY FIGURE 1.
- C. COUPLER SHALL BE A HYDRAULIC FEMALE COUPLER, QUICK CONNECT, 3/8 IN PIPE SIZE NPT, 10 000 PSI RATING AND FLOW RATE 10.8 GPM (REF).
- D. DUST CAP SHALL BE A METAL DUST CAP WITH CONSTRAINT DEVICE (CHAIN, ETC.) TO PREVENT LOSS.
- E. ALL BURRS REMOVED AND BREAK ALL EDGES.
- F. AS5259/4 TOOL DIES AND INSPECTION GAGES ARE SPECIFIED IN TABLE 2 (SEE TABLE 3 FOR SPECIFIC TERMINAL OR CONTACT APPLICATIONS).
- G. MAXIMUM WEIGHT WITH HEAVIEST DIE SPECIFIED IN TABLE 2 SHALL BE 6.0 LB.
- H. HEAD SHALL BE RATED FOR MINIMUM OF 10 000 PSI INPUT PRESSURE. HEAD SHALL GENERATE A MINIMUM OF 5.5 TONS OF FORCE AT THE DIE FACES WITH 10 000 PSI INPUT PRESSURE.

A. TOOL HEAD SHALL BE STEEL WITH A BLACK OXIDE FINISH DESIGNED TO MEET THE PERFORMANCE REQUIREMENTS OF AS5259.

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

6. HYDRAULIC PUMPS IN ACCORDANCE WITH AS5259/2 (SEE TABLE 2 FOR PUMP APPLICATION).

7. LIFE TEST NOT REQUIRED (CERTIFICATION TO 5000 CYCLE IS REQUIRED).

8. SUPPLIER NAME OR SYMBOL, SUPPLIER PART NUMBER AND SAE PART NUMBER (M5259/4-01) IS REQUIRED ON THE TOOL (LOCATION OPTIONAL) SUPPLIER SYMBOL SHALL BE IN ACCORDANCE AIR1351.

1	1	1
1	1	1
1	1	1
1	1	1

BASIC TOOL DASH NUMBER (SEE AS5259/7 FOR CRIMP DIES)

DETAIL SPECIFICATION NUMBER

PART NUMBER DESIGNATION (M) AND BASIC SPECIFICATION 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.

10. QUALIFICATION:

- A. TOOL PERFORMANCE MAY BE QUALIFIED BY SIMILARITY TO THE AS5259/5 AS AGREED TO BY THE QUALIFYING ACTIVITY.
- B. TOOL WILL BE TESTED WITH THE AS5259/2-01 FLEXIBLE HOSE AND AS5259/2-02 FOOT OPERATED PUMP OR THE -04 HAND OPERATED PUMP.

1. GO/NO-GO GAGE INSPECTION RECOMMENDED AT PERIODIC INTERVALS (SEE AS5259/6).

2. BASIC TOOL, DIES, AND GAGES ARE PROCURED SEPARATELY, BUT MAY ALL BE INCLUDED IN ONE STORAGE UNIT (SEE AS5259).
3. THE TOOLS SPECIFIED HEREIN ARE DESIGNED TO CRIMP THE COMPONENTS SPECIFIED IN TABLE 2 USING REMOTE HOSE AND PUMPS SPECIFIED IN AS5259/2.
4. CRIMPING IS LIMITED TO WIRE SIZES 8 THRU 2 FOR INSULATED TERMINALS AND 8 THRU 00 FOR UN-INSULATED TERMINALS AND CONTACTS (SEE TABLE 2).

