

TABLE 1 - DIMENSIONS FOR ALUMINUM TERMINAL DIES (SEE FIGURE 1)

PART NUMBER MS25442-	WIRE SIZE (REF)	A	B MAX	B MIN	C	D	E	ENGRAVING	INSPECTION GAGE PART NUMBER 1/
-8A	8	.062	.290	.286	.125	.516	1.031	8AL	MS25472-1
-6A	6	.062	.334	.330	.125	.656	1.312	6AL	MS25472-2
-4A	4	.094	.402	.398	.125	.703	1.406	4AL	MS25472-3
-2A	2	.094	.502	.498	.125	.781	1.562	2AL	MS25472-4
-1A	1	.125	.522	.518	.125	.812	1.625	1AL	MS25472-5
-01A	0	.094	.546	.542	.125	.812	1.625	1/0AL	MS25472-6
-02A	00	.094	.625	.621	.125	.844	1.688	2/0AL	MS25472-7
-03A	000	.094	.658	.654	.125	.438	.875	3/0AL	MS25472-8
-04A	0000	.094	.744	.740	.125	.500	1.000	4/0AL	MS25472-9

1/ REFER TO AS5259/6 FOR INSPECTION GAGE REQUIREMENTS.

FIGURE 1 REQUIREMENTS:

1. DIMENSIONS: DIMENSIONS ARE IN ACCORDANCE WITH FIGURE 1 AND TABLE 1. UNLESS OTHERWISE SPECIFIED, (INCHES) AND TOLERANCES (DECIMALS $\pm .015$ AND ANGLES $\pm 1^\circ$).
2. MATERIAL: DIE (SAE 4340 OR ASTM A681) AND DIE RETAINER (AMS5110 SAE 1060, 1070, OR 1080 SPRING STEEL).
3. FINISH: BLACK OXIDE (63 MICROINCHES) AND HEX CRIMPING (8 MICROINCHES BUFFED CHROME PLATED).
4. IDENTIFICATION MARKING: READABLE WITHOUT MAGNIFICATION AIDS (EXCLUDING GLASSES).
5. HEAT TREATMENT: DIE (ROCKWELL C-42-46) AND DIE RETAINER (SPRING-TEMPER).
6. EDGES: REMOVE ALL BURRS AND BREAK ALL EDGES.
7. INSPECTION GAGES ARE AS SPECIFIED IN TABLE 1.
8. MS25442-03A AND -04A REQUIRES A 12 TON CRIMP FORCE (SEE TABLE 9).

	AEROSPACE STANDARD	AS5259™/7 SHEET 2 OF 16	REV. B
	CRIMPING TOOL AND ACCESSORIES, DIES, WIRE SIZE 8 TO 0000 UN-INSULATED AND INSULATED CRIMP BARRELS		



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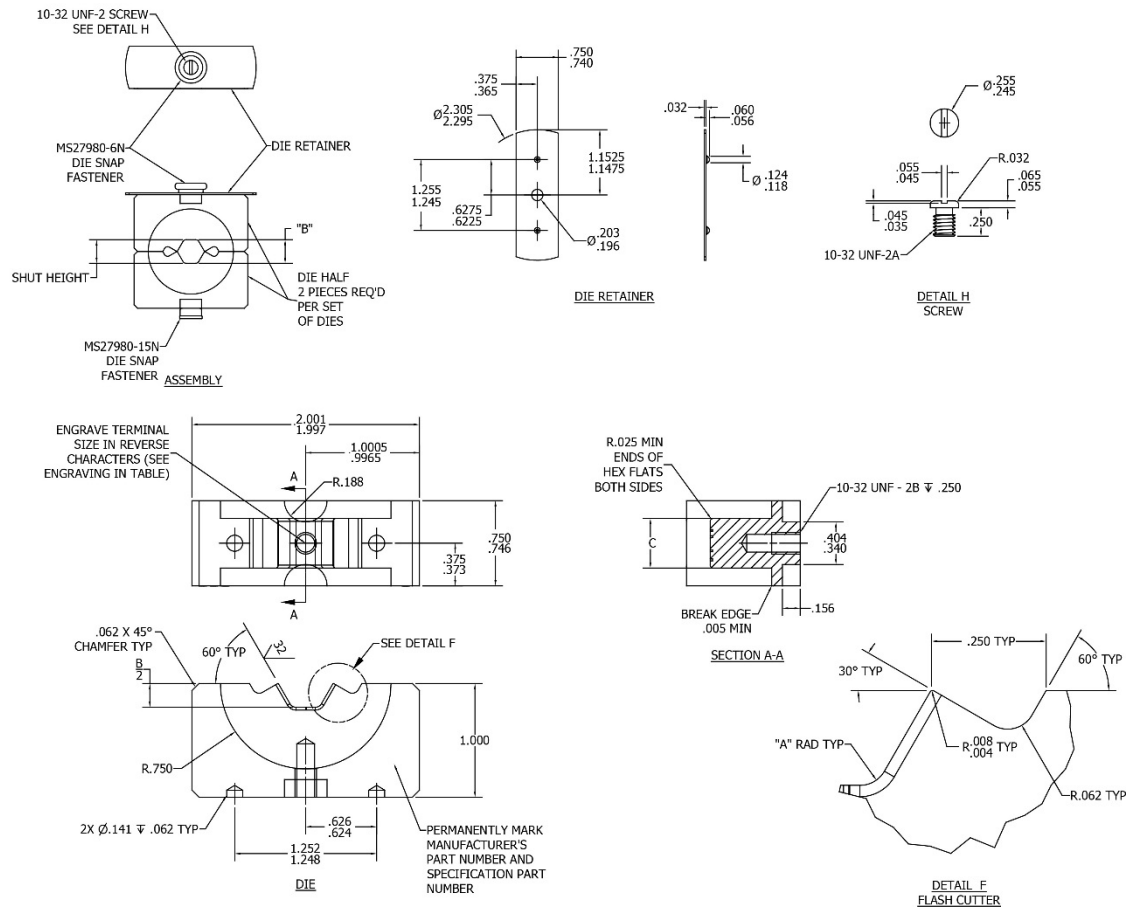


FIGURE 2 - DIES FOR ALL COPPER UN-INSULATED AS7928 STRAIGHT TONGUE TERMINALS (EXCEPT AS25189 FLAG TERMINALS), AND AS7974 CONTACTS (SEE APPLICATION NOTES)

TABLE 2 - DIE DIMENSIONS FOR COPPER UN-INSULATED STRAIGHT TONGUE TERMINALS AND CONTACTS (SEE FIGURE 2)

PART NUMBER MS90485-	WIRE SIZE (REF)	A ±.005	B ±.002	C ±.003	ENGRAVING	INSPECTION GAGE PART NUMBER 1/
-8	8	.031	.210	.310	8 CU	MS90486-8
-6	6	.062	.240	.435	6 CU	MS90486-6
-4	4		.299		4 CU	MS90486-4
-2	2		.377		2 CU	MS90486-2
-1	1		.417		1 CU	MS90486-1
-01	0		.456		1/0 CU	MS90486-01
-02	00	.094	.500	.502	2/0 CU	MS90486-02
-03	000		.562	.627	3/0 CU	MS90486-03
-04	0000		.618	.740	4/0 CU	MS90486-04

1/ REFER TO AS5259/6 FOR INSPECTION GAGE REQUIREMENTS.

FIGURE 2 REQUIREMENTS:

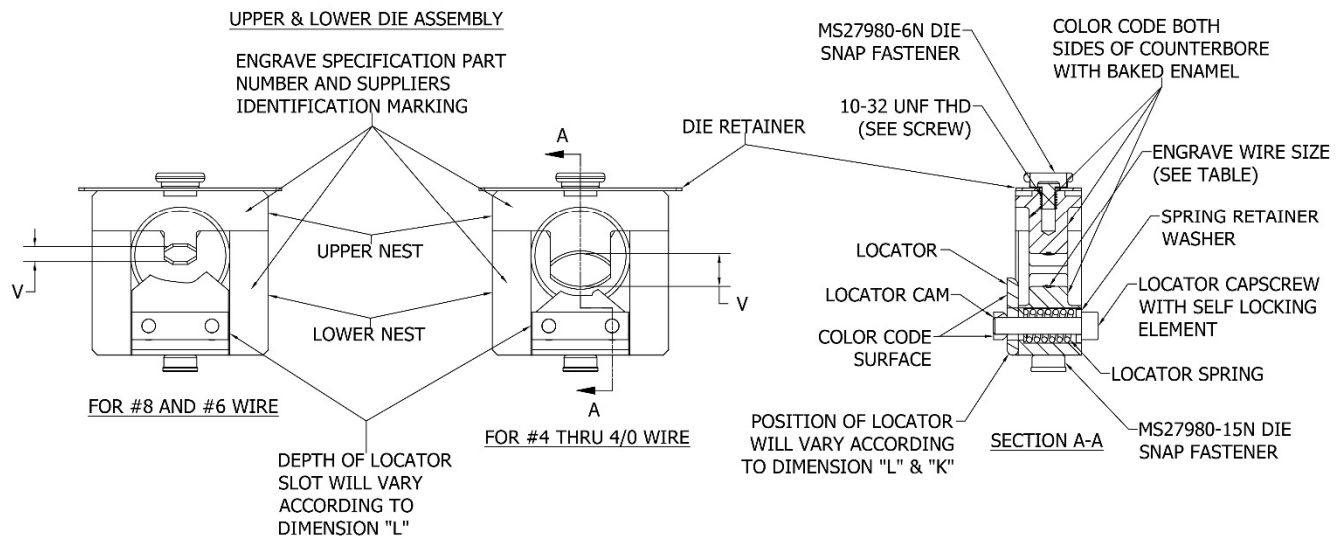
1. DIMENSIONS: DIMENSIONS ARE IN ACCORDANCE WITH FIGURE 2 AND TABLE 2. UNLESS OTHERWISE SPECIFIED, (INCHES) AND TOLERANCES (DECIMALS ±.015 AND ANGLES ±1) AND THREADS (FED-STD-228).
2. MATERIAL: DIE (SAE 4340 OR ASTM A681) AND DIE RETAINER (AMS5110 SAE 1060 OR 1080 SPRING STEEL).
3. FINISH: CHROMIUM (AMS-QQ-C-320) OR NICKEL (AMS-QQ-C-290). OVERALL SURFACE (63 MICROINCHES) AND CRIMPING SURFACE (32 MICROINCHES) OR FINER. CADMIUM SHALL NOT BE USED.
4. IDENTIFICATION MARKING: READABLE WITHOUT MAGNIFICATION AIDS (EXCLUDING GLASSES).
5. HEAT TREATMENT: DIE (ROCKWELL C-42-46) AND DIE RETAINER (SPRING-TEMPER).
6. EDGES: REMOVE ALL BURRS AND BREAK ALL EDGES.
7. INSPECTION GAGES ARE AS SPECIFIED IN TABLE 2.
8. MS90485-03 AND -04 REQUIRES A 12 TON CRIMP FORCE (SEE TABLE 9).

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DIE ASSEMBLY

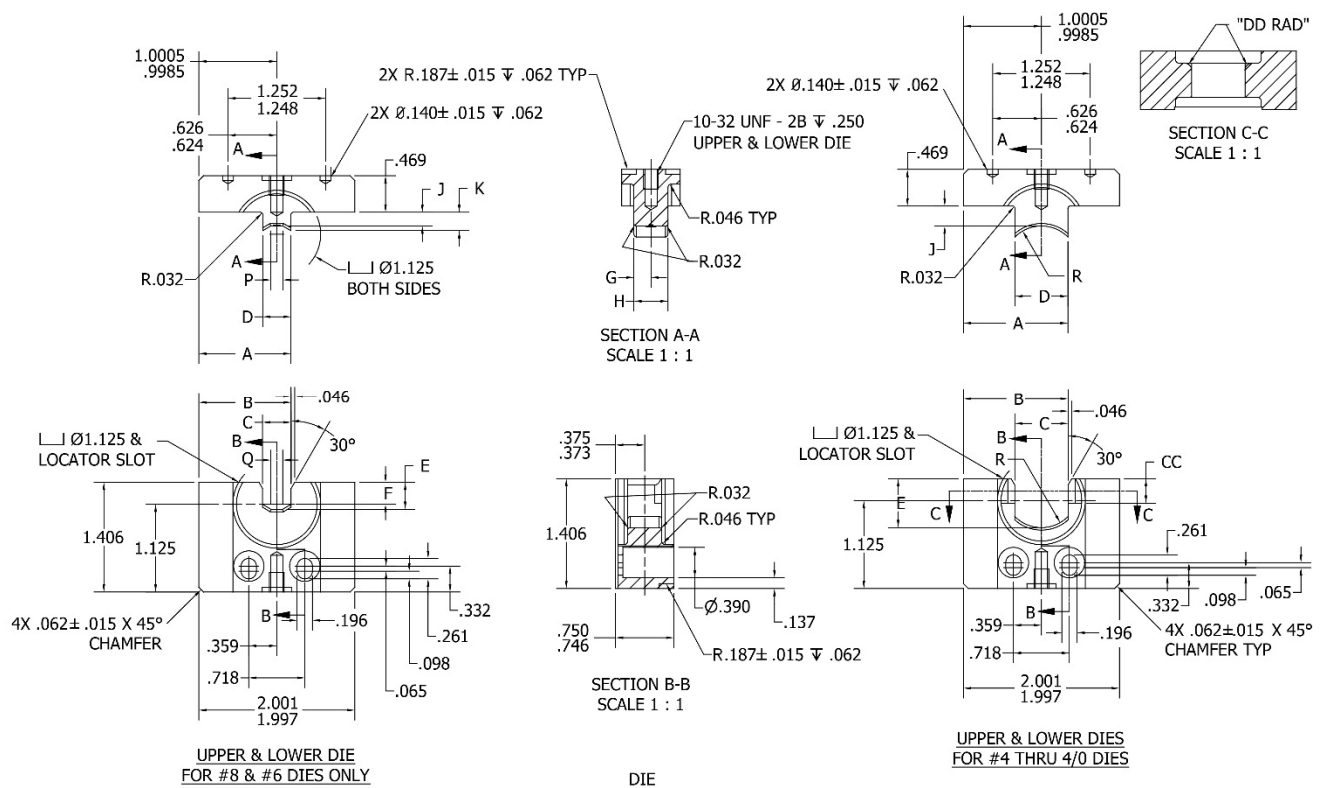


FIGURE 3 - DIES FOR INSULATED COPPER AS7928 TERMINALS (SEE APPLICATION NOTES)

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