

219-0448 380-6935 390-4830

STANDARD ADJUSTABLE CRIMP TOOL AF8 (M22520/1-01)

DANIELS
MANUFACTURING
CORPORATION

DATA SHEET

HOW TO USE THE DANIELS AF8 (M22520/1-01) HAND CRIMPING TOOL & RELATED TURRETS

GENERAL INSTRUCTIONS

1. The tool has a double acting ratchet. Note that tool cannot be opened without completing cycle.
2. Designation AF8 (M22520/1-01) refers to basic tool without turrets. Wire crimp range 12 AWG to 26 AWG.

SETTING UP INSTRUCTIONS

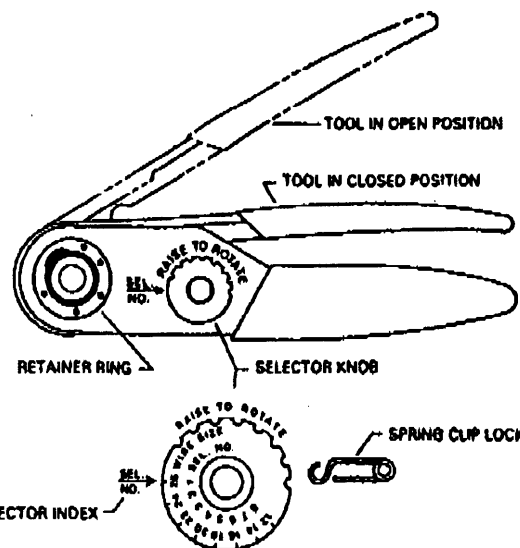
1. Tool must be in open position.
2. Press turret trigger latch which releases turret to indexing position.
3. Place selected turret head assembly onto retainer ring with socket head screws lined up with tapped holes.
4. After turret head is seated against retainer ring, tighten socket head screws with 9/64 inch socket head screw key. Turret should index easily without binding.
5. Refer to data plate on turret head. From the color code column, select the positioner color that corresponds with the appropriate part number and size of contact to be crimped.
6. With tool in open position, and turret in indexing position, rotate turret until color coded positioner is in line with index mark. Press turret until it snaps into latched position.
7. Refer to data plate on turret head. From the proper wire size column, determine the selector number that corresponds with the contact being used.
8. Remove spring clip lock wire from selector knob. Raise selector knob and rotate until selector number is in line with index mark. Replace spring clip lock wire (optional).

CRIMPING INSTRUCTIONS

1. Insert contact and prepared wire through the indenter opening into positioner.
2. Squeeze handles together until ratchet releases. Handle will return to open position. Remove crimped contact and wire.

REMOVING TURRET HEAD

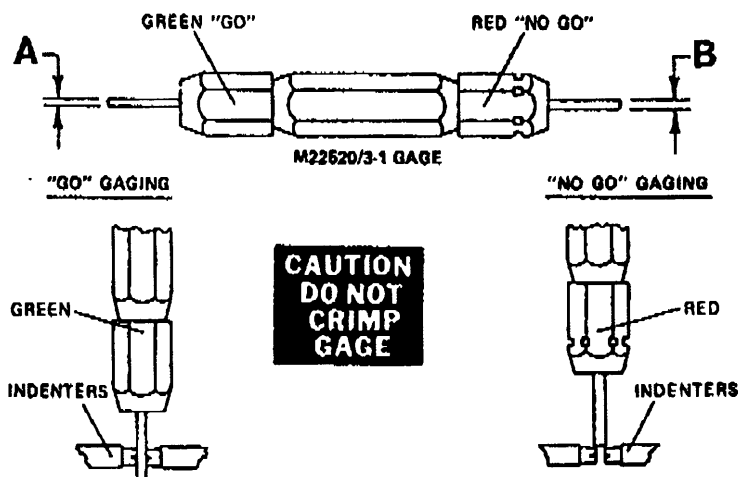
1. Loosen socket head screws until threads are disengaged from retainer ring and remove with a straight lifting motion.



GAGING INSTRUCTIONS

GAGE PART NO.	A GO DIA	B NO GO DIA	CRIMP TOOL	SELECTOR NO.
M22520/3-1	.0390	.0440	AF8	4

Only One Gage Necessary for Periodic In-Service Inspection



**CAUTION
DO NOT
CRIMP
GAGE**

Operate tool to fully closed position. Insert "GO" gage end as shown. Gage must pass freely between indenter tips.

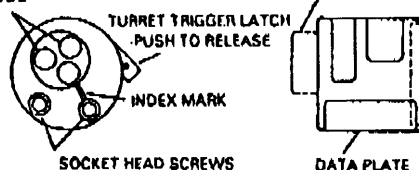
Operate tool to fully closed position. Insert "NO GO" gage end as shown. Gage must not pass between indenter tips.

GAGING LIMITS

SELECTOR NO.	GAGE - INSPECTION	
	A GO DIA	B NO GO DIA
1	.0280	.0330
2	.0320	.0370
3	.0360	.0410
4	.0390	.0440
5	.0450	.0500
6	.0520	.0570
7	.0590	.0640
8	.0680	.0730

POSITIONER IDENTIFICATION
COLOR CODE

TURRET IN RELEASED POSITION



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SEE BACK FOR WARRANTY INFORMATION

DS-AF8

DANIELS MANUFACTURING CORPORATION
6103 ANNO AVENUE, ORLANDO, FLORIDA 32809 USA
PHONE: 407/855-8161 TELEX: 564321
FAX 407-855-8884



GENERAL INFORMATION

The volume of cross reference data accumulated over the past years, makes it possible for **DANIELS MFG. CORP.** to efficiently select the appropriate positioner for your application. If your requirement is not among the vast collection of positioners at **DANIELS**, then every effort will be made to have yours custom designed and manufactured.

CARE OF TOOL

There is virtually no maintenance required. However, it is a good practice to keep indenter tips free of residual color band deposits and other debris. A small wire brush may be used for this purpose.

We strongly recommend that you DO NOT:

1. Immerse tools in cleaning solution.
2. Spray oil into tool to lubricate.
3. Attempt to disassemble tool or make repairs.

This crimping tool is a precision tool and should be handled as such.

SPECIAL SERVICES

DANIELS offers a complete refurbishing and recalibration service.

DANIELS specially engineers and manufactures complete tool kits to satisfy individual customer requirements, such as total aircraft support, general shop maintenance or production, on board ship and vehicle service, etc..

LIMITED WARRANTY *

DANIELS MFG. CORP. warrants each new tool sold by it to be free from defects in material and workmanship under normal use and service. Its obligation under this warranty is limited to the free correction or, at its option, the refund of the purchase price of any such unit which proves defective within ninety (90) days after delivery to the first user, provided that the unit is returned to it with all transportation charges prepaid and which shall appear to its satisfaction, upon inspection by it, to have been defective in material and workmanship. This warranty shall not cover any damage to such tools which in the opinion of **DANIELS MFG. CORP.** was caused by normal wear, misuse, improper operation or accident.

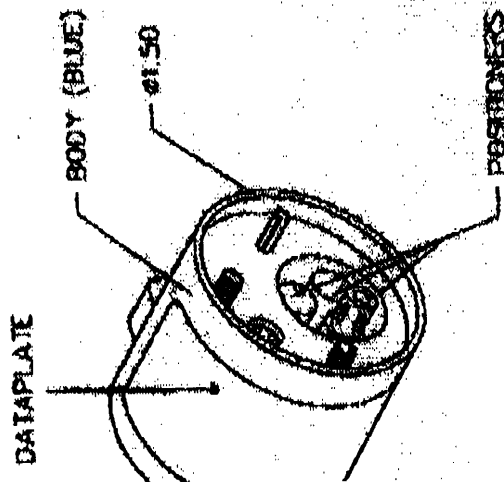
DANIELS MFG. CORP. is not liable for consequential or special damages of any nature or kind resulting from the use of any of its products. This warranty is in lieu of all other warranties expressed or implied. No warranty, expressed or implied, is made or authorized to be made or assumed with respect to the products of **DANIELS MFG. CORP.**, other than that herein set forth.

* As defined by PL93-637

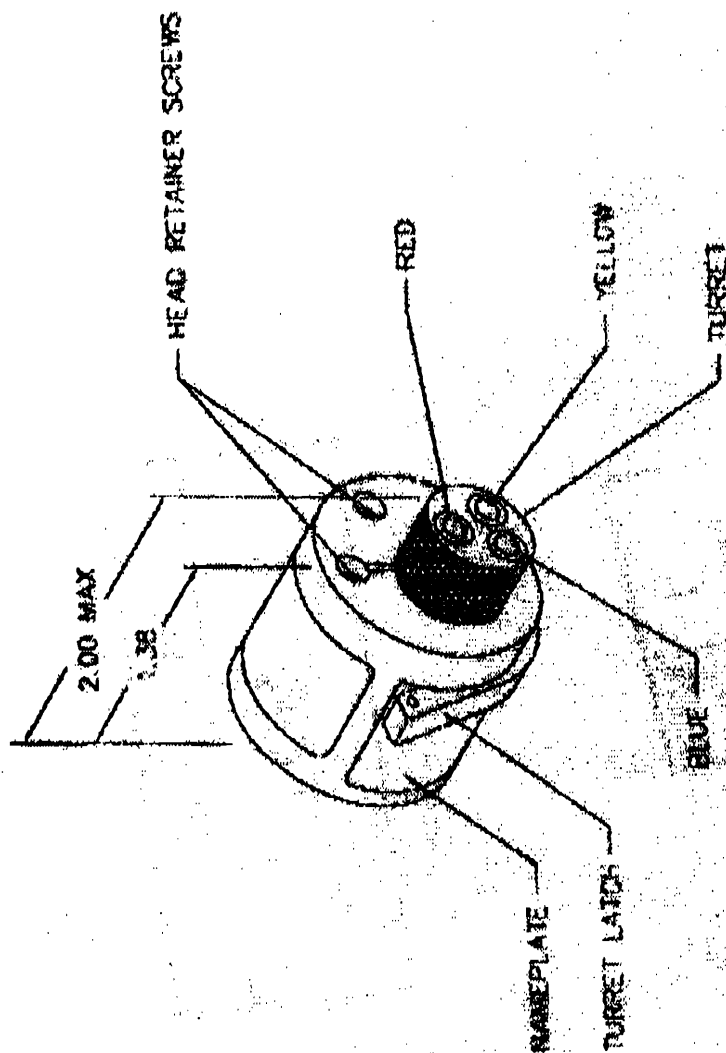
**UNCONTROLLED DOCUMENT
WILL NOT BE UPDATED**

26	24	22	20	18	16	14	12	WIRE SIZE
1	2	3	4					
1	2	3	4					
1	2	3	4	5	6			
			4	5	5	7	8	

WIRE GAUGE MS2420-055 MS2420-055
 1. /A, /N, /Z
 2. /S, /T, /V, /W, /X, /Y, /Z
 3. /S, /T, /V, /W, /X, /Y, /Z



CR	HOLE DIMENSIONS	ADDITIONAL FEATURES
	0.081 ± 0.14 MM	0.126 ± 0.30
	0.125 ± 0.04 MM	0.156 ± 0.355
	0.173 ± 0.04 MM	0.206 ± 0.365



REV	LOG NUMBER	DESCRIPTION	BY	DATE	REV DATE
1		ORIGINAL RELEASE		2-1-80	1-1-80
2		REVISED DATAPLATE		2-1-80	2-1-80

VIEW	FILE NO.	QTY.	DESCRIPTION/REMARKS
FRONT	100-1000-1000	1	FRONT VIEW
TOP	100-1000-1000	1	TOP VIEW
LEFT	100-1000-1000	1	LEFT VIEW
RIGHT	100-1000-1000	1	RIGHT VIEW
ISOMETRIC	100-1000-1000	1	ISOMETRIC VIEW

REV	DATE	BY	DESCRIPTION
1	2-1-80	100-1000-1000	100-1000-1000
2	2-1-80	100-1000-1000	100-1000-1000

REV	DATE	BY	DESCRIPTION
1	2-1-80	100-1000-1000	100-1000-1000
2	2-1-80	100-1000-1000	100-1000-1000

DO NOT SCALE DRAWING

Other than keeping the unit clean and properly stored when not in service, no operator maintenance is required. DMC offers complete factory service by knowledgeable technicians within a reasonable turnaround time. Complete instructions concerning the use, care and warranty are supplied with each tool. Additional copies are available on request.

MILITARY P/N	P/N	DESCRIPTION	NSN
M22520/1-01	AF8	TOOL FRAME	5120-01-335-8571
M22520/1-02	TH1A	TURRET	5120-01-335-8834
M22520/1-03	TH4	TURRET	5120-01-335-8835
M22520/1-04	TH163	TURRET	5120-01-335-8836
M22520/1-05	UH2-5	UNIVERSAL POSITIONER	5120-01-335-8583
M22520/1-06	TP46	POSITIONER	5120-01-335-8584
M22520/1-07	TP85	POSITIONER	5120-01-335-8585
M22520/1-08	TH199S	TURRET	5120-01-335-8837
M22520/1-09	TP360	POSITIONER	5120-01-335-8586
M22520/1-10	TP365	POSITIONER	5120-01-335-8587
M22520/1-11	TP465	POSITIONER	5120-01-335-8588
M22520/1-12	TH270	TURRET	5120-01-335-8838
M22520/1-13	TH285	TURRET	5120-01-335-8839
M22520/1-14	TH286	TURRET	5120-01-335-8840
M22520/1-15	TP485	POSITIONER	5120-01-335-8589
M22520/1-16	TP513	POSITIONER	5120-01-335-8590
M22520/1-17	TP651	POSITIONER	5120-01-335-8591
M22520/3-1	G125	GAGE	5220-00-165-7604

