

AFM8 (M22520/2-01)

Miniature Adjustable Crimp Tools



LOWER RANGE CRIMP TOOL AFM8 M22520/2-01

Qualified to MIL-DTL-22520/2*, the DMC AFM8 is designed for most of the miniature and sub-miniature connector types that are so widely used in electronic systems. The AFM8 meets the need for a miniature tool accommodating wire sizes 20 through 32 AWG.

The AFM8 gives a Mil-Standard 8 impression crimp, which assures maximum tensile strength. The cycle controlled precision ratchet assures consistently accurate crimps every time. The tool frame has a built-in 8 step selector knob for ease in dialing the correct crimp depth setting for the wire being used.

Positioners adapt the tool frame to a particular application. The data plate on each positioner designates which contacts the positioner accommodates for its wire size and indicates selector position. The positioner is easily removed and changed.

Periodic gaging is recommended to insure accurate calibration. This is easily accomplished with the M22520/3-1 "GO/NO-GO" gage (DMC part no. G125) on SEL setting #8. The AFM8 is 6 3/4" in length and weighs approximately 10 oz.

Other than keeping the tool clean and properly stored when not in use, no operator maintenance is required.



The DMC274 tool kit contains the AFM8 tool frame, tool gage, and all mil-spec positioners. Also included in the DMC274 are tool instruction sheets and a tool selection chart.

* Change to SAE AS22520 in process consult DMC for status.



MILITARY P/N	DMC P/N	DESCRIPTION	NSN
M22520/2-01	AFM8	TOOL FRAME	5120-01-335-8572
M22520/2-02	K1S	POSITIONER	5120-01-335-8592
M22520/2-03	K60S	POSITIONER	5120-01-335-8593
M22520/2-04	K151	POSITIONER	5120-01-335-8594
M22520/2-05	K3	POSITIONER	5120-01-335-8595
M22520/2-06	K41	POSITIONER	5120-01-335-8624
M22520/2-07	K40	POSITIONER	5120-01-335-8625
M22520/2-08	K13-1	POSITIONER	5120-01-335-8626
M22520/2-09	K42	POSITIONER	5120-01-335-8627
M22520/2-10	K43	POSITIONER	5120-01-335-8628
M22520/2-11	K287	POSITIONER	5120-01-335-8629
M22520/2-12	K286	POSITIONER	5120-01-335-8630
M22520/2-13	K338	POSITIONER	5120-01-335-8631
M22520/2-14	K340	POSITIONER	5120-01-335-8632
M22520/2-15	K341	POSITIONER	5120-01-335-8633
M22520/2-16	K339	POSITIONER	5120-01-335-8634
M22520/2-17	K342	POSITIONER	5120-01-335-8635
M22520/2-18	K343	POSITIONER	5120-01-335-8636
M22520/2-19	K330-2	POSITIONER	5120-01-335-8637
M22520/2-20	K331-2	POSITIONER	5120-01-335-8638
M22520/2-21	K332-2	POSITIONER	5120-01-335-8609
M22520/2-22	K212	POSITIONER	5120-01-335-8610
M22520/2-23	K267-1	POSITIONER	5120-01-335-8611
M22520/2-24	K75S-1	POSITIONER	5120-01-335-8612
M22520/2-25	K261-1	POSITIONER	5120-01-335-8613
M22520/2-26	K262-1	POSITIONER	5120-01-335-8614
M22520/2-27	K269-1	POSITIONER	5120-01-335-8615
M22520/2-28	K373-1	POSITIONER	5120-01-335-8616
M22520/2-29	K372-1	POSITIONER	5120-01-335-8617
M22520/2-30	K404	POSITIONER	5120-01-335-8618
M22520/2-31	K406	POSITIONER	5120-01-335-8619
M22520/2-32	K496	POSITIONER	5120-01-335-8620
M22520/2-33	K74S	POSITIONER	5120-01-335-8621
M22520/2-34	K323	POSITIONER	5120-01-335-8622
M22520/2-35	K532-1	POSITIONER	5120-01-335-8623
M22520/2-36	K473	POSITIONER	5120-01-335-8596
M22520/2-37	K709	POSITIONER	5120-01-361-9666
M22520/3-1	G125	GAGE	5220-01-016-6002
	SK2/2	ADJUSTABLE POSITIONER	5120-01-171-1569
	DMC274	M22520/2 TOOL KIT	5180-01-259-0512



MIDDLE RANGE INDENT CRIMP TOOL MH860 M22520/7-01

Qualified to MIL-DTL-22520/7*, the DMC MH860 is a recent addition to the military specification. It was developed to meet the demonstrated need for supporting the majority of electrical systems with one versatile crimp tool frame.

The MH860 accepts the entire middle wire range of 16 through 28 AWG, with positioners which adapt it to virtually all applications consistent with others in the MIL-DTL-22520 family.



The DMC123 tool kit contains the MH860 tool frame, tool gage, and all mil-spec positioners. Also included in the DMC123 are tool instruction sheets and a tool selection chart.

* Change to SAE AS22520 in process consult DMC for status.

MIL 860 PART NUMBERS			
MILITARY P/N	DMC P/N	DESCRIPTION	NSN
M22520/7-01	MH860	TOOL FRAME	5120-01-335-8573
M22520/7-02	86-1S	POSITIONER	5120-01-335-8597
M22520/7-03	86-2	POSITIONER	5120-01-335-8598
M22520/7-04	86-3	POSITIONER	5120-01-335-8599
M22520/7-05	86-4	POSITIONER	5120-01-335-8600
M22520/7-06	86-5	POSITIONER	5120-01-335-8601
M22520/7-07	86-6	POSITIONER	5120-01-335-8602
M22520/7-08	86-7	POSITIONER	5120-01-335-8603
M22520/7-09	86-11S	POSITIONER	5120-01-335-8604
M22520/7-10	86-12S	POSITIONER	5120-01-335-8605
M22520/7-11	86-19	POSITIONER	5120-01-335-8606
M22520/7-12	86-20	POSITIONER	5120-01-335-8607
M22520/7-13	86-21	POSITIONER	5120-01-335-8608
M22520/3-3	G145	GAGE	5120-00-338-0378
	86-37	ADJUSTABLE POSITIONER	
	DMC123	M22520/7 TOOL KIT	5180-01-355-5616



THE MIL-DTL-28840 TOOLING

MIL-DTL-28840 connectors were developed for the Navy, for use with jacketed cable for shipboard applications. They are a high density circular connector series utilizing a high shock threaded coupling system with front release crimped contacts.

For these connectors DMC has added a new crimping tool to its range, the M22520/34-01.

MIL-DTL-28840 TOOLING PART NUMBERS			
MILITARY P/N	DMC P/N	DESCRIPTION	NSN
M22520/34-01	39-000	BASIC CRIMP TOOL	5120-01-242-3516
M22520/34-02	39-102	POSITIONER	5120-01-242-1041
M22520/35	G345	GAGE	5220-01-392-1065
M81969/33-01	DAK55-22SA	INST. TOOL (STRAIGHT)	5120-01-230-1506
M81969/33-02	DAK55-22JA	INST. TOOL (OFFSET)	5120-01-335-8666
M81969/34-01	DRK56-22A	REMOVAL TOOL	5120-01-230-1507
	DMC782	MIL-C-28840 TOOL KIT	5180-01-363-1391

MINIATURE ADJUSTABLE CRIMP TOOL AFM8 (M22520/2-01)

DMC DANIELS
MANUFACTURING
CORPORATION
DATASHEET

THIS HAND TOOL MUST NOT BE USED IN ANY POWERED
"PRESS" AS DEFINED BY OSHA CFR 1910.211 (46)

SEE REVERSE SIDE FOR IMPORTANT INFORMATION CONCERNING
LIMITED WARRANTY, AND LIMITATION OF LIABILITY.

GENERAL INFORMATION:

1. Designation AFM8 (M22520/2-01) refers to basic tool without positioner.
2. Wire crimp range 20 to 32 AWG
3. The tool has a double action ratchet, and cannot be opened without completing the cycle.

INSTALLATION OF POSITIONER:

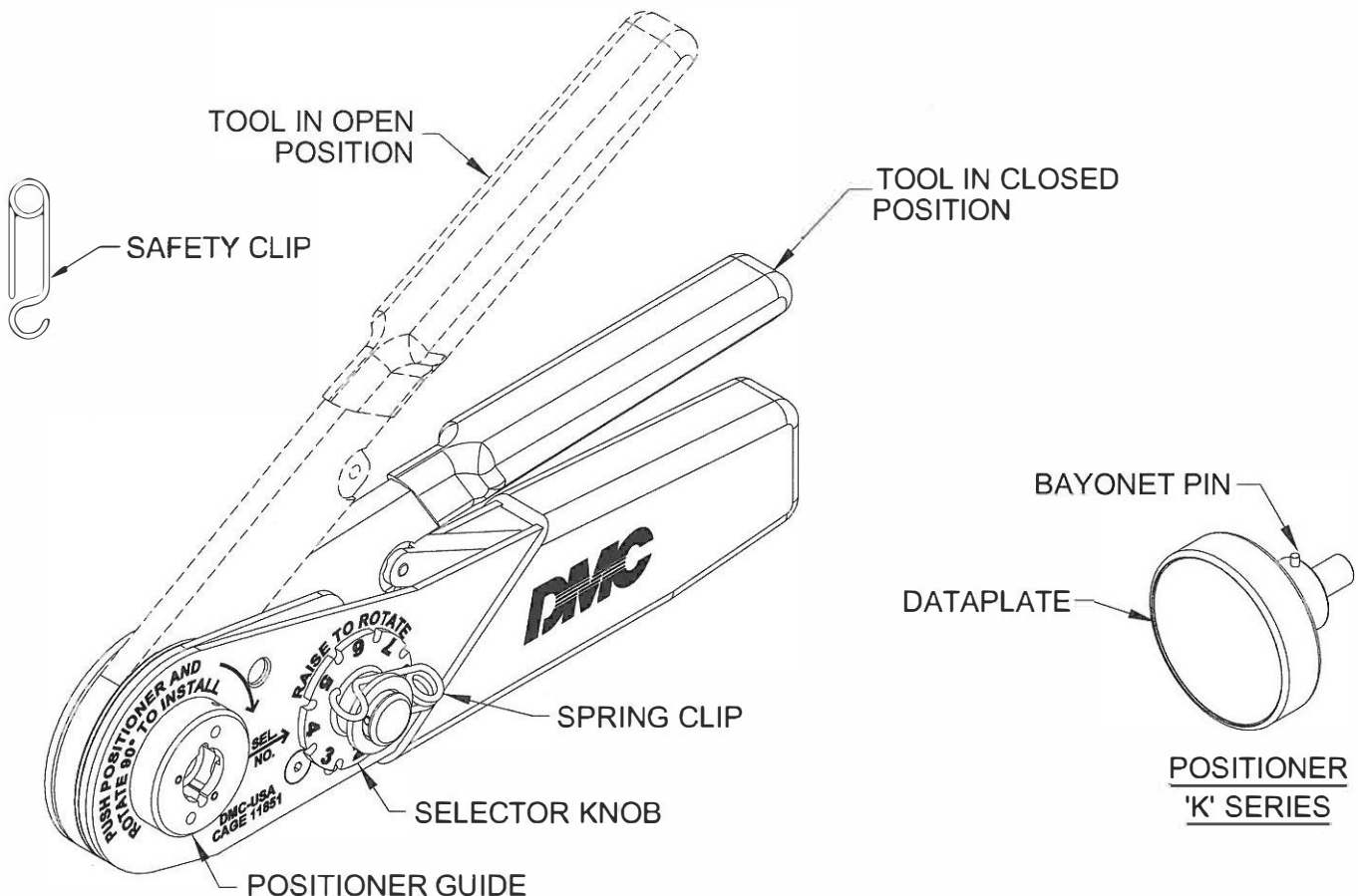
1. Tool must be in open position.
2. Remove safety clip from positioner guide.
3. Select correct positioner for contact to be crimped.
4. Insert positioner into positioner guide. Push down and turn 90 degrees until bayonet pins lock.
5. Wire size and corresponding selector numbers are shown on the dataplate.
6. With tool in open position, remove spring clip then raise and rotate selector knob until number indicated on dataplate for wire size to be crimped is in line with the Sel. No. arrow.

CRIMPING INSTRUCTIONS:

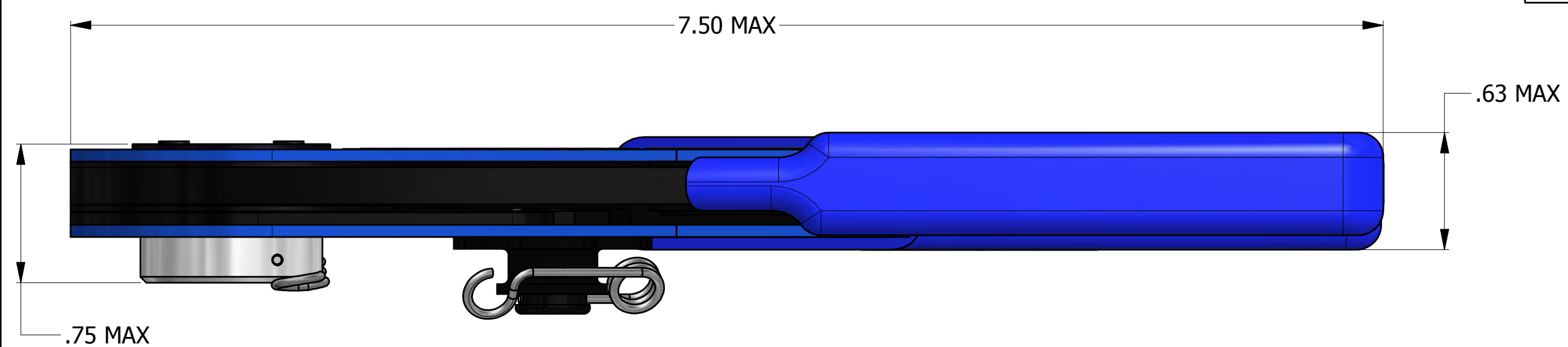
1. Insert contact and prepared wire through the indenter opening into the positioner.
2. Squeeze handles together until ratchet releases. Handle will return to open position.

REMOVING POSITIONER:

1. Push down on positioner to release bayonet pins from positioner guide. Turn 90 degrees and remove from tool.

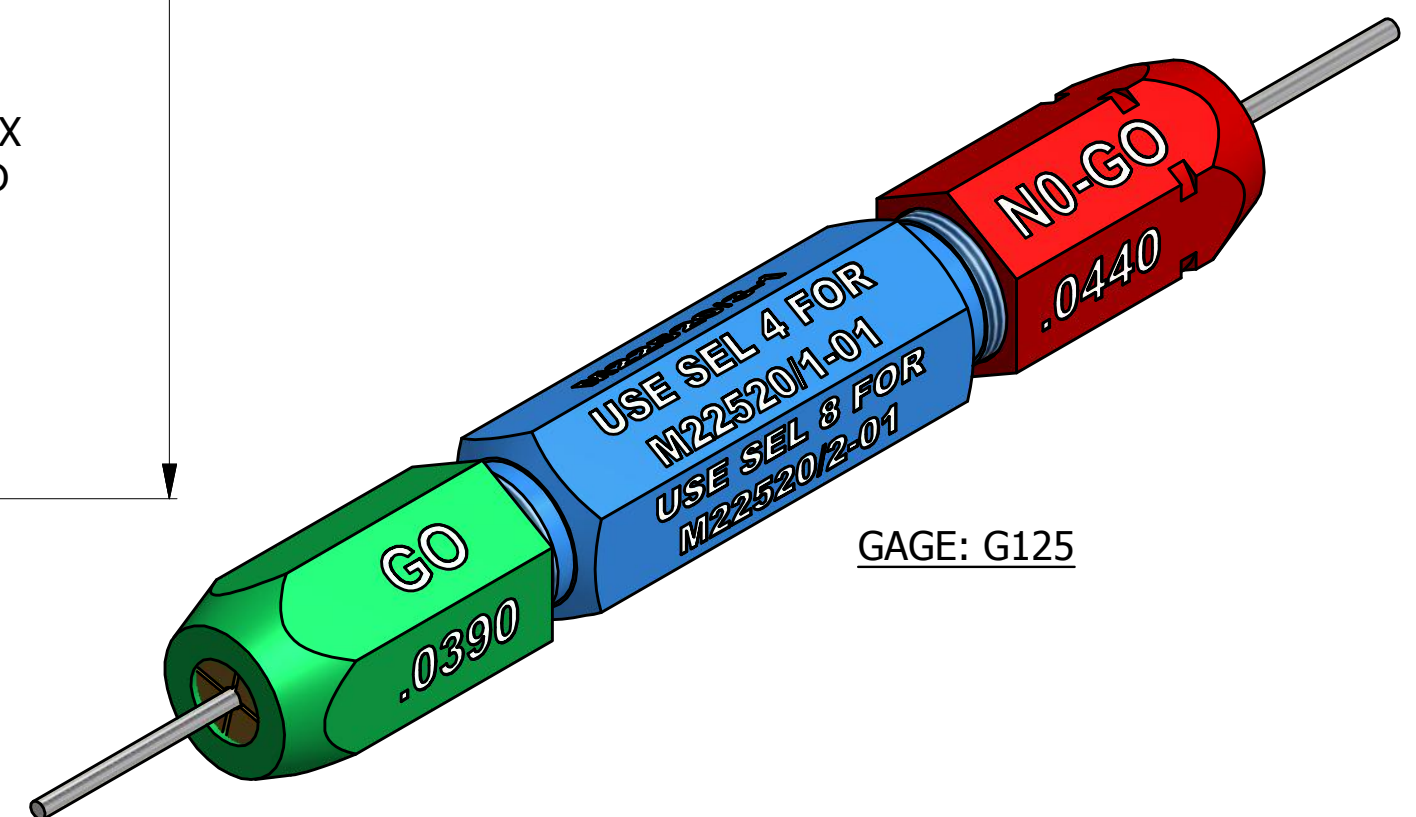


REVISIONS						
REV	ECO NO.	DESCRIPTION	BY	DATE	APP'D BY	DATE
2		REDRAWN	AAM	10/22/1999	RRR	10/22/1999
3	23590	UPDATED AND ADDED GAGE	TD	11/27/2014		



GAGING LIMITS OF INDENTERS		
SEL NO	INSPECTION GAGE	
	Ø GO ±.0001	Ø NO-GO ±.0001
1	.0130	.0180
2	.0160	.0210
3	.0190	.0240
4	.0220	.0270
5	.0260	.0310
6	.0300	.0350
7	.0340	.0390
8	.0390	.0440

CHECK WITH GAGE: G125 SEL #8



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WILL NOT BE UPDATED**
DIMENSIONS IN INCHES - UNLESS OTHERWISE SPECIFIED

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CREATED FROM AN INVENTOR MODEL. CHANGES MUST BE REFLECTED IN THE 3D PART
DO NOT SCALE DRAWING

MATERIAL	ITEM	PART NO.	QTY.	DESCRIPTION / REMARKS
N/A	DRN. LME CHK'D. MGS	DATE 9/8/1986 DATE 9/23/1986		DANIELS MANUFACTURING CORP. ORLANDO, FLORIDA CAGE 11851
HEAT TREAT N/A	NOTE: THIS DRAWING IS AN OUTLINE DRAWING OF THE RESPECTIVE DMC PART NUMBER INDICATED. ACTUAL DMC PART NUMBER IS CAD PART NUMBER WITHOUT THE "-ENV" SUFFIX		TITLE CRIMP TOOL (M22520/2-01) ENVELOPE DRAWING	
FINISH N/A	WHERE USED:	SIZE C	SCALE 1.75X	CAD P/N AFM8-ENV DWG. NO. AFM8 SHEET 1 OF 1 REV. 3