

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

**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 AF8 (M22520/1-01) refers to basic tool without positioner.
2. Wire crimp range 26 to 12 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. Press positioner trigger latch which releases turret to indexing position.
3. Place positioner onto retaining ring with alignment pin in alignment hole.
4. After positioner is seated against retainer ring, tighten socket head screws with 9/64" hex. key.
5. Refer to dataplate on positioner. From 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, rotate until color coded insert is in line with the index mark. Press turret until it snaps in latched position.
7. Refer to dataplate. From wire size column, determine the selector setting that corresponds with the contact being used.
8. Remove spring clip from selector knob and rotate until correct setting is in line with selector mark.

## CRIMPING INSTRUCTIONS:

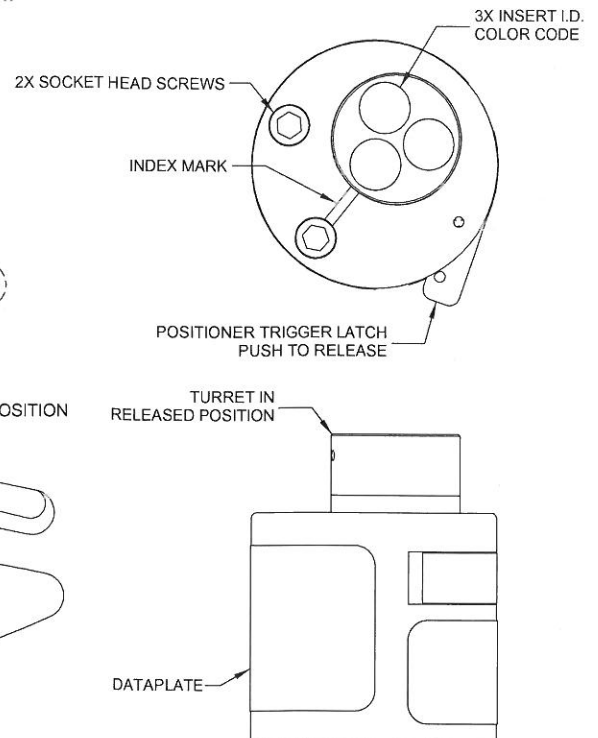
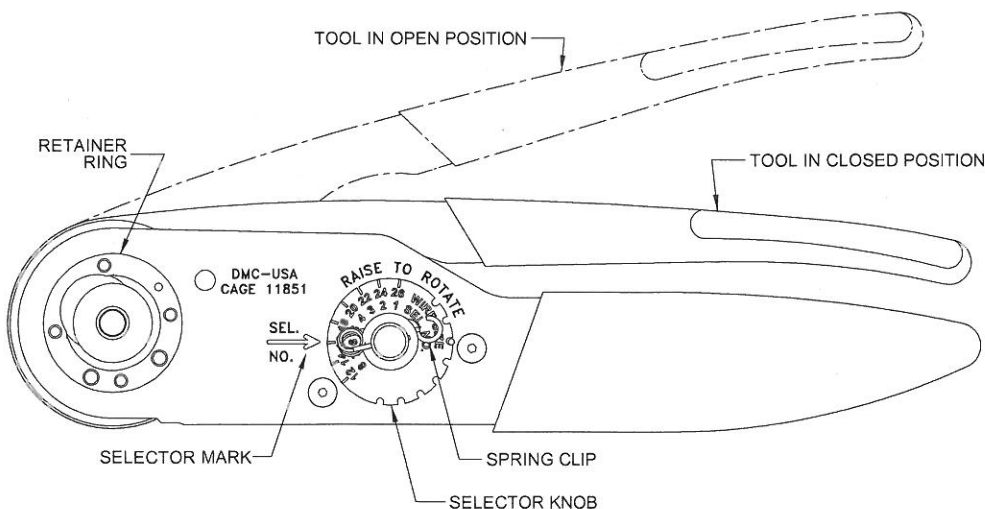
1. Insert contact and prepared wire through the indenter opening into the positioner.
2. Squeeze handles together until ratchet releases. Handle will return to open position.

## REMOVING POSITIONER:

1. With tool in open position, release turret. Loosen screws until threads are disengaged from retainer ring and remove with a straight lifting motion.

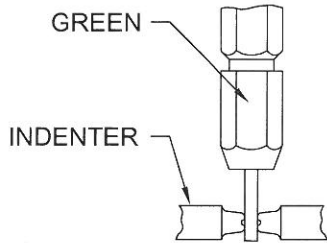
## CAUTION:

TOOL MUST BE IN OPEN POSITION WHENEVER  
POSITIONER IS BEING INSTALLED, REMOVED OR RELEASED.  
DAMAGE TO TURRET HEAD AND/OR CRIMP TOOL MAY RESULT  
IF THIS PROCEDURE IS NOT FOLLOWED.



"GO" GAGING

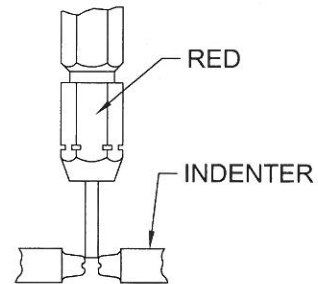
Operate the tool to the fully closed position. Maintain firm hand pressure on the tool handles. Insert the "GO" gage end as shown. The gage must pass freely between the indenter tips.



GAGING INSTRUCTIONS

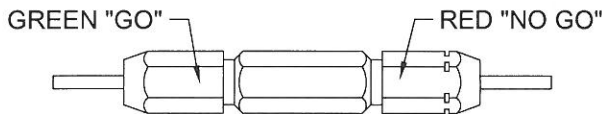
"NO-GO" GAGING

Operate the tool to the fully closed position. Maintain firm hand pressure on the tool handles. Try to insert the "NO-GO" gage end as shown. The "NO-GO" gage may partially enter the indenter opening, but must not pass completely through.



GAGING LIMITS

SEL NO	INSPECTION GAGE	
	Ø GO ±.0001	Ø NO-GO ±.0001
1	.0280	.0330
2	.0320	.0370
3	.0360	.0410
4	.0390	.0440
5	.0450	.0500
6	.0520	.0570
7	.0590	.0640
8	.0680	.0730



GAGE: USE G125 (M22520/3-1) ON SEL #4

**CAUTION!**  
**DO NOT CRIMP GAGE !!**

CARE OF TOOL

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

We strongly recommend that you:

1. DO NOT immerse tools in cleaning solution.
2. DO NOT spray oil into tool to lubricate.
3. DO NOT attempt to disassemble tool or make repairs.

This is a precision hand crimp tool and should handled as such.

DMC offers complete refurbishing and recalibrating services.

DMC 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.

LIMITATION OF LIABILITY

DANIELS MANUFACTURING CORPORATION IS NOT LIABLE FOR CONSEQUENTIAL OR SPECIAL DAMAGES OF ANY NATURE OR KIND RESULTING FROM THE USE, MISUSE, OF ANY OF ITS PRODUCTS. OWNERS AND USERS OF DMC PRODUCTS ASSUME FULL RESPONSIBILITY FOR INSTRUCTING THEIR EMPLOYEES IN THE PROPER AND SAFE USE OF SUCH PRODUCTS.

LIMITED WARRANTY

DMC (Daniels Manufacturing Corporation) warrants each new product sold by it to be free from defects in material and workmanship under normal use and service. DMC's obligation under this warranty is limited to the free correction or, at DMC's option, the refund of the purchase price of any such product which proves defective in normal service within ninety (90) days after delivery to the first user, provided that the product is returned to DMC with all transportation charges prepaid and which shall appear to DMC's satisfaction, after DMC's inspection, to have been defective in material or workmanship, it being understood that DMC products are not consumer products. This warranty shall not cover any damage to any products which, in the opinion of DMC, was caused by normal wear, misuse, improper operation, tampering, neglect or accident. This warranty is in lieu of all other warranties express or implied. No warranty, express or implied, is made or authorized to be made or assumed with respect to products of Daniels Manufacturing Corporation other than those herein set forth.