



### Announcements

The next JSWAG/JFOWG Technical Interchange Meeting is scheduled for August 13-15, 2013 in Dayton, OH. Please contact a committee chair if interested in attending or send an email to [jswag@navy.mil](mailto:jswag@navy.mil). DCO/VTC capability should be available for those who cannot travel.

Nominations for the 2013 Lu Roberts award recipient has begun. Please visit <https://jswag.navair.navy.mil/> to make your nomination. Nominations will close August 31 for voting to begin. The winner will be announced at the 2014 Spring JSWAG/JFOWG Technical Interchange Meeting.

### Training Resources

- Aircraft Wiring Systems Awareness DVD- Defense Imagery PIN #806881.
- Fiber Optic Awareness DVD- Defense Imagery PIN #806707.
- Joint Services Wiring Manual Maintenance Techniques DVD- Defense Imagery PIN #806994.
- MIL-HDBK-522- Guidelines for Inspection of Aircraft Wiring Interconnect Systems- <https://assist.daps.dla.mil>.

### Newsletter Contact

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## Large Crimp Tool Standards

For large gauge crimping operations such as 8 to 0000, hydraulic assisted tools are usually required. Though infrequently employed, these are pivotal to maintaining wiring systems to required configuration. Safety is paramount for many reasons, as large gauge wire applications are usually for large current systems which may result in extensive damage or loss of life. The high reliability and cost of the tools is such that they are not frequently replaced unless required. The NAVAIR Wiring Systems Team (AIR-4.4.5.3) in cooperation with SAE (Society of Automotive Engineers) has helped standardize large hydraulic operated crimp tools. The military standard MIL-C-22909 for hydraulic operated crimp tools was last revised in 1972 and had become outdated. There were nine military standards, which were also outdated and required organization to separate tools, gauges and dies. There was also no qualified product listing for these tools, as it only required First Article Testing. As a result, NAVAIR decided to convert MIL-C-22909 to a SAE aerospace standard. These standards are organized the crimp tools (based on crimped wire size and hydraulic pressure requirements), along with inspection gauges and crimp dies into separate slash sheets. In addition, a qualification requirement was added to AS5259 and a Qualified Products List has been established. Tool specifications and application information (Table 1- AS5259 Large Gauge Crimp Tools below).

SAE Standard	Tool Description	
AS5259	Basic Standard	
AS5259/1 P/N MS25441-1	Remote Head Tool, 8 to 0000	
AS5259/2-01	10 Foot Hose / with Couplers	
AS5259/2-02	10,000 psi Pumps	Hand Pump
AS5259/2-03		Foot Pump
AS5259/2-04		DC Battery Pump
AS5259/2-05		AC Electric Pump
AS5259/2-06		Air to Hydraulic Pump
AS5259/3	Hand Operated Tool, 8 to 00	
AS5259/4	Remote Head Tool, 8 to 00	
AS5259/5	Hand Operated Tool, 8 to 00	
AS5259/6	Inspection Gages	
AS5259/7 Includes: MS23002, MS90485, MS90486	Crimp Dies for AS5259/1, /3, /4 & /5	

see Large Crimp Tool, page 2

## Large Crimp Tool from page 1

Currently, SAE aerospace standard AS5259 and slash sheets /1 through /7 have been published. In addition, all of the associated military specifications have been canceled and AS5259 and all of the slash sheets except /2 have been adopted for use by the DoD. Aerospace standard AS5259/2, which covers the various pumps, will be adopted by DoD once the Federal Supply Class is corrected in this slash sheet. Qualified Products List AS5259 has been published and two qualified sources for the MS25441-1, 12 Ton Tool Head with all dies and gauges have been added. Current plans are to complete qualification of the remaining crimp tools, pump and hose components, dies, and gages by the end of the calendar year 2013 with all part numbers and slash sheets covered. SAE is currently in the process of revising fourteen SAE standards (terminals and contacts) which were affected by the publication of AS5259. NAVAIR 01-1A-505-1 Work Package 013 00 is currently being revised to capture all of the AS5259 crimp tools, dies and gages, and their applications. The user should refer to the specification, NAVAIR-01-1A-505-1, or applicable aircraft specific technical manual when selecting crimp tool and dies for crimping terminals and contacts. Refer to the AS5259 slash sheets for performance requirements, applications, and die and gauge selections.

**NOTE:** The application and range of the crimp tools has been recently updated with a verification requirement that the crimp dies make physical, metal-to-metal contact, completely coming together to ensure a full cycle operation of the crimp tool. Failure to ensure full travel may lead to an inadequate crimp and result in a high resistance connection, overheat and fire.



**M S25441-1 (DMC TBHD1M)**  
AS5259/1, 12 Ton Remote  
Head Crimp Tool 8 to 0000



**MS259/3-01 (DMC HH80C)**  
AS5259/3, 7 Ton Hand Operated Crimp Tool 8 to 00



**MS259/4-01**  
AS5259/4, 5.5 Ton Remote Head Crimp Tool 8 to 00



**MS259/5-01 (DMC HD5M)**  
AS5259/5, 5.5 Ton Hand Operated Crimp Tool



AS5259/6, Go/No-Go Gauges

## JSWAG Website Updates

Per user requests we have uploaded all Program Guides back to Fall 2009. The Program Guides were made available at each JSWAG meeting and contain recent action chit work for the period. They are now available in their respective period, under Document Library/Meeting Information/Meeting Presentation folders. This feature is available to those on the Secure JSWAG site which requires a Common Access Card (CAC) for access.

Another update to the Secure JSWAG site comes as a result of recent security mandates. Any user who has not logged on for more than 35 days will be considered inactive, and their account will be deactivated. The next time the user tries to log in they will see a notification that "the Administrator has been notified". We will make every effort to promptly reactivate your account. You will then receive an email confirming reactivation. If you have any questions, or any website issue, please email us at [jswag@navy.mil](mailto:jswag@navy.mil). 