



REVISIONS		
LTR	DESCRIPTION	DATE
F	REVISED PER ECO-11-006285	04/14/2011

NOTES:

- UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES.
- THE AD-1520 CRIMP TOOL IS DESIGNED TO MAKE WIRE SPLICES UTILIZING TYCO ELECTRONICS CRIMP SPLICES OF THE FOLLOWING SIZES:

TOOL CAVITY	12 - 16	16 - 20		
STUB CRIMP	I.D.	O.D.	I.D.	O.D.
SPLICER	.102	.153	.069	.106
SIZE	.097	.147	.064	.101
- WHEN MADE WITH A PROPERLY CALIBRATED AD-1520 CRIMP TOOL, THESE WIRE SPLICES WILL MEET THE VOLTAGE DROP AND TENSILE STRENGTH REQUIREMENTS OF THE APPLICABLE TYCO ELECTRONICS CUSTOMER DRAWING FOR CRIMP SPLICING SYSTEMS.
- A PROPERLY CALIBRATED AD-1520 CRIMP TOOL HAS THE FOLLOWING CHARACTERISTICS:
  - RATCHET ADJUSTMENT (SET AT THE FACTORY): A COMPRESSIVE FORCE OF 40-50 LBS, APPLIED 1.25 ± .12 INCHES FROM THE END OF THE HANDLES SHALL BE REQUIRED TO COMPLETELY CLOSE THE JAWS BEFORE THE RATCHET MECHANISM RELEASES THE HANDLES.
  - JAW CLOSING: WITH THE JAWS FULLY CLOSED (TIPS TOUCHING AND RATCHET IN LAST NOTCH), A "GO" GAUGE SHALL FIT IN THE SPACE BETWEEN THE INDENTER AND ITS CORRESPONDING CAVITY. A "NO GO" GAUGE SHALL NOT FIT IN THIS SPACE. GAUGE SIZES ARE AS FOLLOWS:

TOOL CAVITY	"GO"	"NO GO"
12 - 16	.058 DIA.	.068 DIA.
16 - 20	.036 DIA.	.046 DIA.

TYCO ELECTRONICS AD-1526 CRIMP TOOL GAUGE IS RECOMMENDED FOR THIS PURPOSE.

Raychem Application Equipment  
CUSTOMER DRAWING

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. METRIC DIMENSIONS ARE IN BRACKETS. DECIMAL TOLERANCES .XXX ± 0.005 [0.13 mm] .XX ± 0.01 [0.25 mm] .X ± 0.1 [0.50 mm] ANGLE TOLERANCE .X ± 1 DEG. TE CONNECTIVITY RESERVES THE RIGHT TO AMEND THIS DRAWING AT ANY TIME. USERS SHOULD EVALUATE THE SUITABILITY OF THE PRODUCT FOR THEIR APPLICATION. © 1975-2011 Tyco Electronics Corporation. All rights reserved.	DRAWN UNGUYEN	TE Connectivity		
	PART NUMBER 959039-000	TITLE AD-1520 S CRIMP TOOL ASSEMBLY		
	THIRD ANGLE PROJECTION	SIZE B	CODE IDENT. NO. 06090	DWG. NO. AD-1520-5

SCALE: NTS

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