



MS PART NO.	CRIMPING DIE MS PART NO.	A $\begin{smallmatrix} +.0002 \\ -.0000 \end{smallmatrix}$	B $\begin{smallmatrix} +.0000 \\ -.0002 \end{smallmatrix}$	C $\pm .030$	D $\pm .030$
MS23003-8	MS23002-8	.1678	.172	2.468	.360
MS23003-6	MS23002-6	.1998	.204	3.125	.427
MS23003-4	MS23002-4	.2518	.256		.490
MS23003-2	MS23002-2	.3098	.314		.615
MS23003-1	MS23002-1	.3368	.341	3.593	.552
MS23003-01	MS23002-01	.3678	.372		.677
MS23003-02	MS23002-02	.4018	.406		.740
MS23003-03	MS23002-03	.4358	.440	4.187	
MS23003-04	MS23002-04	.4708	.475		

GAGES SHALL BE FABRICATED IN ACCORDANCE WITH DEPT. OF COMMERCE COMMERCIAL STANDARD CS8.

MATERIAL:

GAGE PINS; ALLOY TOOL STEEL, SPECIFICATION MIL-S-5696, GRADE IV, HARDEN TO ROCKWELL C55-60 AND GRIND.

GAGE HANDLES; ALUMINUM ALLOY, PER DEPT. OF COMMERCE COMMERCIAL STANDARD CS8.

FINISH:

GAGE PINS; CHROME FLASH, .0002 TO .0003 THICK, PER SPECIFICATION QQ-C-320.

DIMENSIONS OF A AND B ARE AFTER CHROME FLASHING. TOLERANCE; CLASS Z, PER HANDBOOK H-28.

DIMENSIONS IN INCHES, UNLESS OTHERWISE SPECIFIED.

ALL STAMPING TO BE .093 HIGH AND INDENTED.

THESE GAGES ARE FOR INSPECTING MS23002 CRIMPING DIES FOR WIRE SIZES 8 THRU 4/0 COPPER INSULATED TERMINALS.

FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.

(B) ENTIRE DRAWING REVISED

P.A. Navy - Nops Other Cust USAF - ASD	TITLE GAGES- INSPECTION FOR MS23002 CRIMPING DIES (FOR USE WITH MS25036 INSULATED TERMINALS)	MILITARY STANDARD
PROCUREMENT SPECIFICATION CS8	SUPERSEDES:	MS23003(ASG) SHEET 1 OF 1