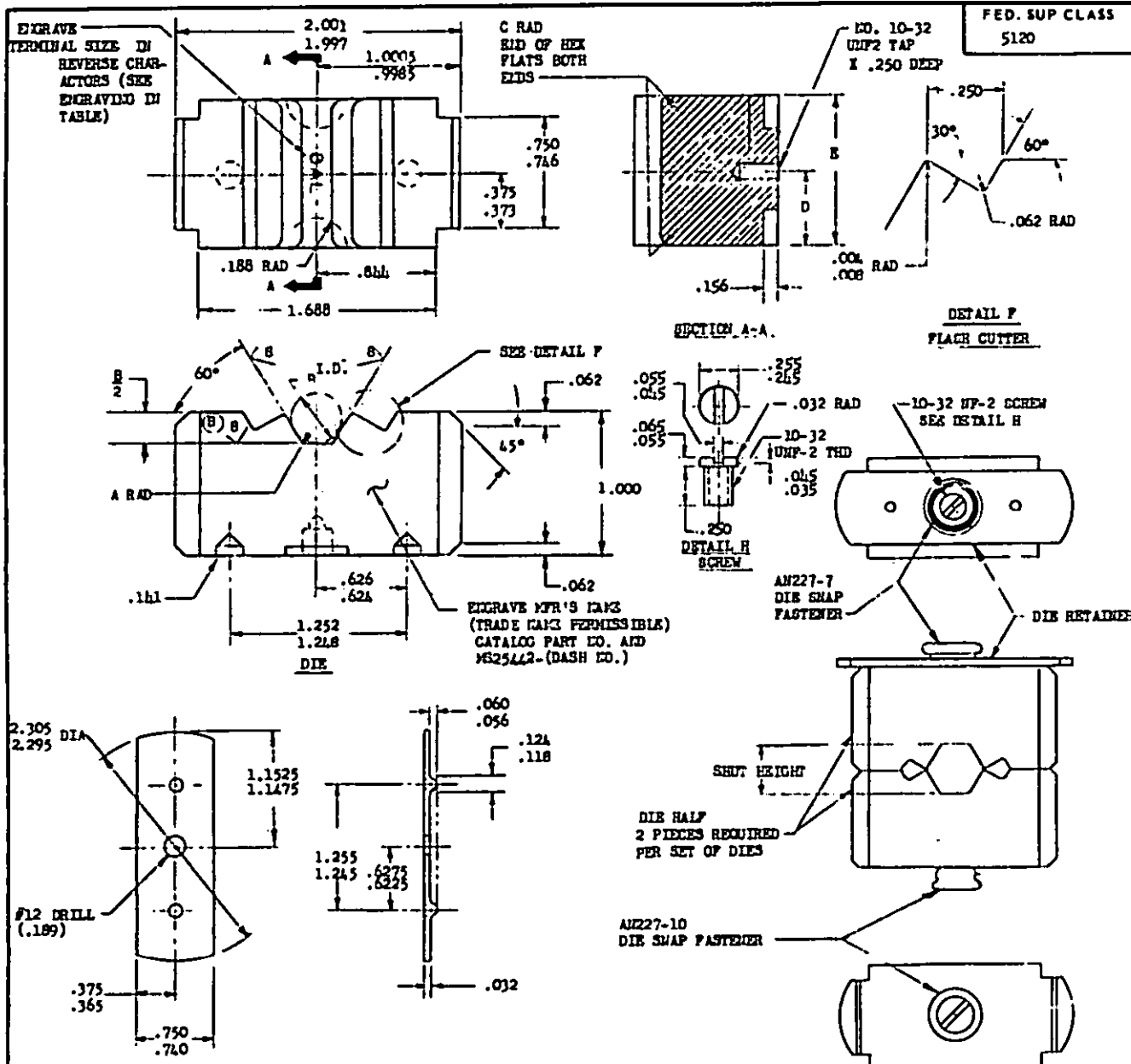


Reviewers and Users:
USAF - 11
Army - EL
Navy - Weps



DIE RETAINER

DIE INSTALLATION

DASH NO.	TERMINAL SIZE	A	B		C	D	E	EXGRAVING	CAGE NO.
			MAX	MIN					
-8A	8	.062	.290	.266	.125	.516	1.031	BAL	MS25472-1
-6A	6		.334	.330		.656	1.312	6AL	-2
-4A	4	.094	.602	.598		.703	1.606	BAL	-3
-2A	2		.502	.498		.781	1.562	2AL	-4
-1A	1	.125	.522	.518		.812	1.625	1AL	-5
-01A	0		.516	.512		.814	1.648	1/0AL	-6
-02A	00	.094	.625	.621		.814	1.648	2/0AL	-7
-03A	000		.658	.654		.838	.875	3/0AL	-8
-04A	0000		.764	.760		.500	1.000	4/0AL	MS25472-9

MATERIAL: DIE - SAE 4340, DIE RETAINER - SAE 1060 OR 1080 SPRING STEEL.
FINISH: BLACK OXIDE 63 MICROINCHES (8/), EXCEPT THE HEX CRIMPING AREA WHICH SHALL BE POLISHED AND BUFFED, THEN CHROME PLATED AND BUFFED 8 MICROINCHES (8/).

UNLESS OTHERWISE SPECIFIED, ALL HEX ENGRAVINGS SHALL BE LOCATED CENTRALLY IN HEX, CUT TO A DEPTH .015 -.020.

SIZE OF DIE, TRADEMARKS, AND ENGRAVING TO BE AS LARGE AS PRACTICAL.

HEAT TREAT: DIE TO ROCKWELL C-42-46, DIE RETAINER SPRING-TENFER.

THESE DIES ARE DESIGNED TO CRIMP MIL-T-7099 ALUMINUM TERMINALS. ONE COMPRESSION NECESSARY FOR SIZES 8 - 2/0 INCLUSIVE AND TWO COMPRESSIONS FOR SIZES 3/0 - 4/0 INCLUSIVE.

BREAK ALL SHARP EDGES.

DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DIMENSIONS $\pm .015$, ANGLES $\pm 1^\circ$.
FOR SERVICE USE CHECK SHUT HEIGHT WITH MS25472 GAGES.

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.

P.A. Navy-Weps

Other Cost

USAF- 11
ARMY-EL

TITLE

DIES, FOR MS25441, HYDRAULIC CRIMPING
TOOL (FOR USE WITH ALUMINUM WIRE TERMINALS)

MILITARY STANDARD

MS25442

PROCUREMENT SPECIFICATION

SUPERSEDES:

SHEET 1 OF 1