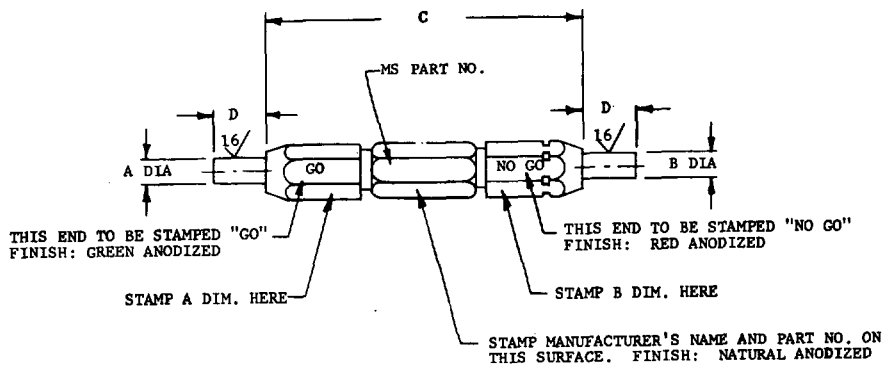


PROJECT NO. 5220-0132

FED. SUP CLASS  
5220USER SYMBOLS:  
ARMY - GLREVIEWER SYMBOLS:  
NAVY - 84  
USAF - 84

"Review/user information is current as of the date of this document.  
For future coordination of changes to this document, draft circulation  
should be based on the information in the current DODISS."

This military standard is approved for use by all Departments  
B. Agencies of the Department of Defense. Selection for all new  
engineering and design applications and for repetitive use shall  
be made from this document.



DASH NO.	CRIMPING DIE (REF)	A +.0002 -.0000	B +.0000 -.0002	C REF	D ±.030
-1	MS25442-8A	.2828	.293	3.59	1.156
-2	-6A	.3268	.337		1.437
-3	-4A	.3948	.405		1.531
-4	-2A	.4948	.505	4.18	1.687
-5	-1A	.5148	.525	4.53	1.750
-6	-01A	.5388	.549		1.750
-7	-02A	.6178	.628		1.781
-8	-03A	.6508	.661	4.65	1.000
-9	MS25442-04A	.7368	.747		1.125

## NOTES:

- MATERIAL: GAGE PINS; ALLOY, TOOL STEEL, SPECIFICATION QQ-T-570, CLASS L7, HARDEN TO 55-60 ROCKWELL C SCALE, AND FINISH GRIND WITHOUT DESTROYING SURFACE INTEGRITY. GAGE HANDLE, ALUMINUM ALLOY.
- FINISH: GAGE PINS; CHROMEFLASH, .0002 TO .0003 THICK, PER SPECIFICATION QQ-C-320, CLASS 2d.
- DIMENSIONS OF A AND B ARE AFTER FLASHING. TOLERANCE; CLASS Z, PER HANDBOOK H-28.
- DIMENSION IN INCHES, UNLESS OTHERWISE SPECIFIED.
- ALL STAMPING TO BE .093 HIGH AND INDENTED.
- THESE GAGES ARE FOR THE INSPECTION OF MS25442 CRIMPING DIES FOR WIRE SIZES 8 THRU 4/0 ALUMINUM TERMINALS.
- GAGES AND GAGE HANDLE SHALL BE FABRICATED IN ACCORDANCE WITH DEPARTMENT OF COMMERCE COMMERCIAL STANDARD CS8.

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 BIDS.

(G) ENTIRE STANDARD REDRAWN.

P.A. NAVY - AS. Other Cust ARMY - EL USAF - 84	TITLE	MILITARY STANDARD
	GAGE, IN-SERVICE-INSPECTION, FOR USE WITH MS25442 CRIMPING DIES (FOR USE WITH ALUMINUM WIRE TERMINALS)	MS25472
PROCUREMENT SPECIFICATION DEPT OF COMMERCE CS8	SUPERSEDES:	SHEET 1 OF 1

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

PLATE NO. 23085