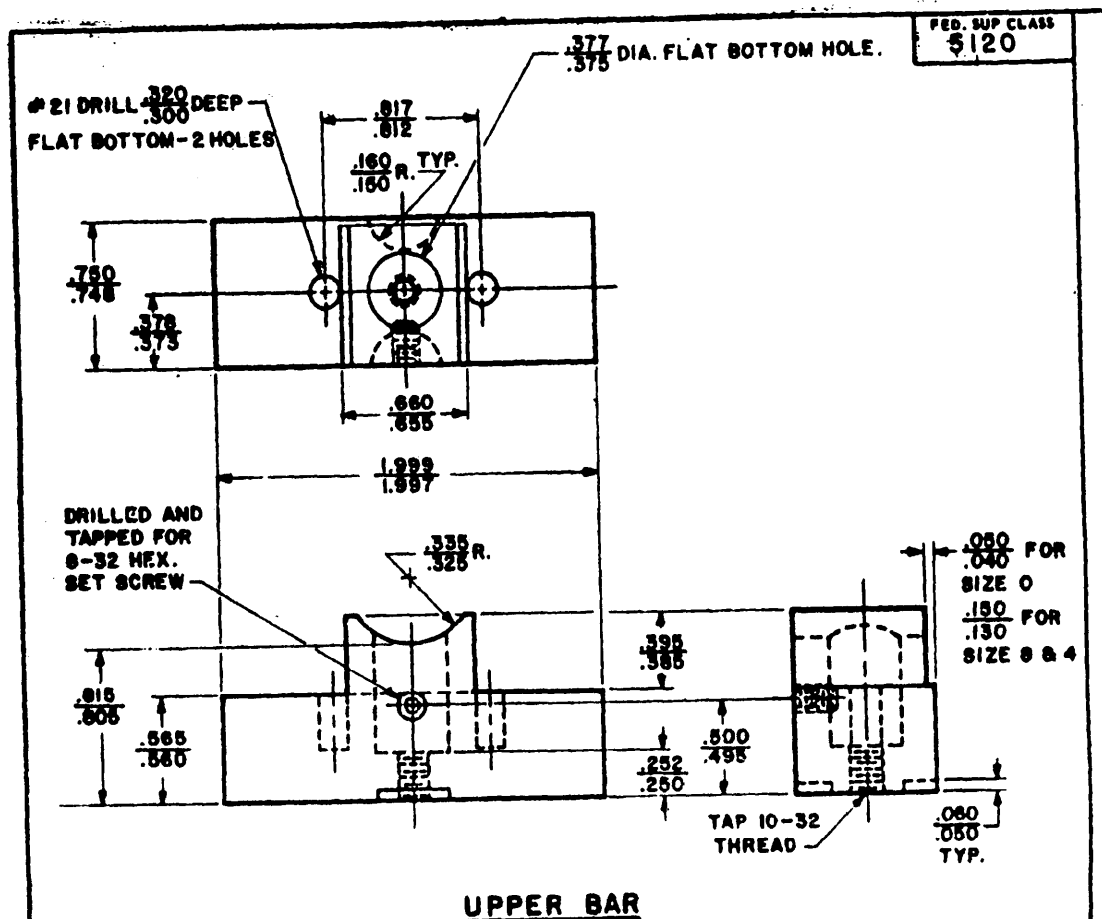


TOP VIEW		BOTTOM VIEW		FED. SUP. CLASS 5120																						
<p>AN227-7 DIE SNAP FASTENER</p> <p>2.625 MAX. OPEN</p> <p>AN227-10 DIE SNAP FASTENER</p>	<p>MS 3150-8</p> <p>CRIMPING DIE ASSEMBLY P/N (TYP)</p> <p>UPPER BAR</p> <p>DIE SPRING</p> <p>HINGED INDENTER</p> <p>MAIN BODY</p> <p>INDENTER SPRING</p> <p>DIE SPRING</p> <p>LOWER FIXED INDENTER</p> <p>LOWER YOKE</p> <p>MS 3150-8</p>	<p>UPPER FIXED INDENTER</p> <p>FLAT WASHER (AN 980-XC10L)</p> <p>CLEVIS PIN (MS 20392-2C35)</p> <p>COTTER PIN (MS 24865-151)</p> <p>FLAT WASHER (AN 980-XC10L)</p>																								
<p><b>NOTES:</b></p> <ol style="list-style-type: none"> <li>1. DIE SPRINGS, (2), IN LOWER YOKE: O.D. 3/8 IN., LG. 7/8 IN., COMP. 7 LBS.</li> <li>2. DIE SPRINGS, (2), IN UPPER BAR: O.D. 5/32 IN., LG. 1/2 IN., COMP. 1.5 LBS.</li> <li>3. BASIC CRIMPING DIE CONSISTS OF ASSEMBLY WITHOUT INDENTERS.</li> <li>4. IDENTIFICATION ENGRAVING SHALL BE CUT TO A DEPTH OF .020/.015, MIN. HEIGHT .094.</li> <li>5. CRIMPED CONTACT BARRELS SHALL NOT EXCEED THEIR SPECIFIED MAXIMUM DIAMETERS BY 0.015 INCH.</li> <li>6. DRAWING NOT TO SCALE.</li> </ol>																										
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="2">IDENTIFICATION</th> </tr> <tr> <th>BASIC DIE</th> <th>MAIN BODY</th> </tr> </thead> <tbody> <tr> <td>BD 1</td> <td>M 1</td> </tr> <tr> <td>BD 2</td> <td>M 2</td> </tr> <tr> <td>BD 3</td> <td>M 3</td> </tr> </tbody> </table>					IDENTIFICATION		BASIC DIE	MAIN BODY	BD 1	M 1	BD 2	M 2	BD 3	M 3												
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<p>P.A. NAVY - AB</p> <p>Other Cust</p>		<p><b>TITLE</b> DIES FOR CRIMPING MS3190 TYPE B CONTACT WIRE BARRELS (INSTALL DIES IN MS25441-1 HEAD)</p>																								
<p>PROCUREMENT SPECIFICATION MIL-C-22909</p>		<p><b>MILITARY STANDARD</b></p> <p>MS 3150 (NAVY)</p> <p>SHEET 1 OF 6</p>																								
<p>DD FORM 672-1 (Limited circulation)</p> <p>Project No. 5120-N736</p>																										

This standard has been approved by the Department of the Navy and is hereby made a part of the activity. All other military standards are required to comply with standard when issued.

APPROVED 1 APR 1951 REVISED



### UPPER BAR

#### NOTES:

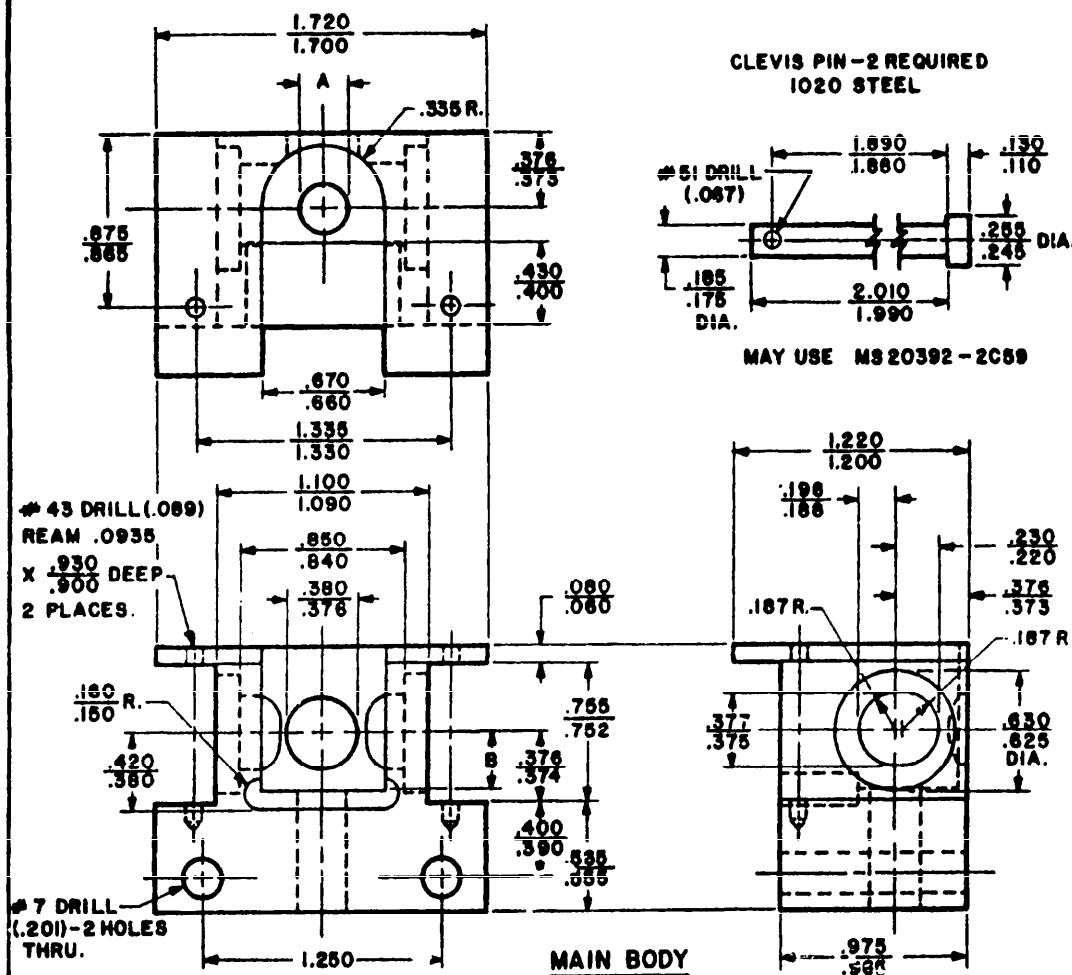
1. MATERIALS; OIL HARDENED TOOL STEEL, HARDENED TO ROCKWELL "C" 48-52.
2. FINISH; BLACK OXIDE 63 MICROINCHES (  $\sqrt{3}$  ).
3. UNLESS OTHERWISE SPECIFIED: TOLERANCES; DECIMALS  $\pm .002$ , ANGLES  $\pm 1^\circ$ .
4. IDENTIFICATION ENGRAVINGS SHALL BE CUT TO A DEPTH OF .020/.015, MIN. HEIGHT .094.
5. DRAWING NOT TO SCALE.

P.A. NAVY - AS Other Code	TITLE <b>DIES FOR CRIMPING MS3190 TYPE B CONTACT WIRE BARRELS (INSTALL DIES IN MS2544I-1 HEAD)</b>	MILITARY STANDARD	
PROCUREMENT SPECIFICATION MIL-C-22909	SUPERSEDES	MS 3150 (NAVY)	
		SHEET 2 OF 6	

DD FORM 672-1 (Limited coordination)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

APPROVED 1 Apr 1971 REVISED

FED. SUP CLASS  
5120

## NOTES:

1. MATERIALS; OIL HARDENED TOOL STEEL, HARDENED TO ROCKWELL "C" 48-52.
2. FINISH; BLACK OXIDE 63 MICROINCHES (.0005").
3. UNLESS OTHERWISE SPECIFIED: TOLERANCES; DECIMALS  $\pm .002$ , ANGLES  $\pm 1^\circ$ .
4. IDENTIFICATION ENGRAVINGS SHALL BE CUT TO A DEPTH OF .020/.015, MIN. HEIGHT .094.
5. DRAWING NOT TO SCALE.

MAIN BODY IDENTIFICATION	CONTACT SIZE	A DIA.	B
M 1	3	.260 .255	.252 .248
M 2	4	.344 .339	.252 .248
M 3	0	.536 .531	.352 .348

P.A. NAVY - AS  
Other CostTITLE  
DIES FOR CRIMPING MS3190 TYPE B  
CONTACT WIRE BARRELS  
(INSTALL DIES IN MS25441-1 HEAD)

MILITARY STANDARD

MS 3150 (NAVY)

PROCUREMENT SPECIFICATION  
MIL-C-22909

SUPERSEDES

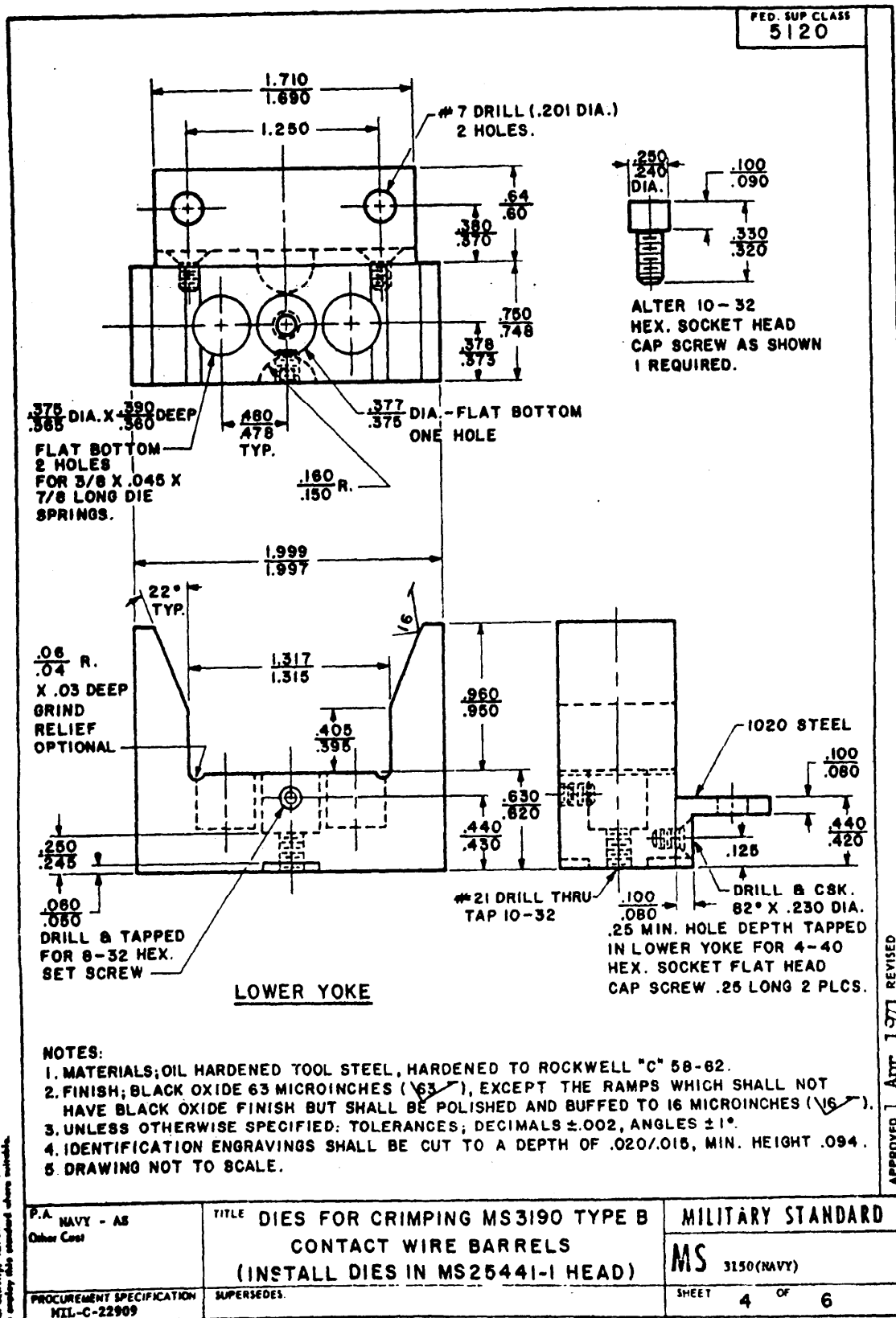
SHEET 3 OF 6

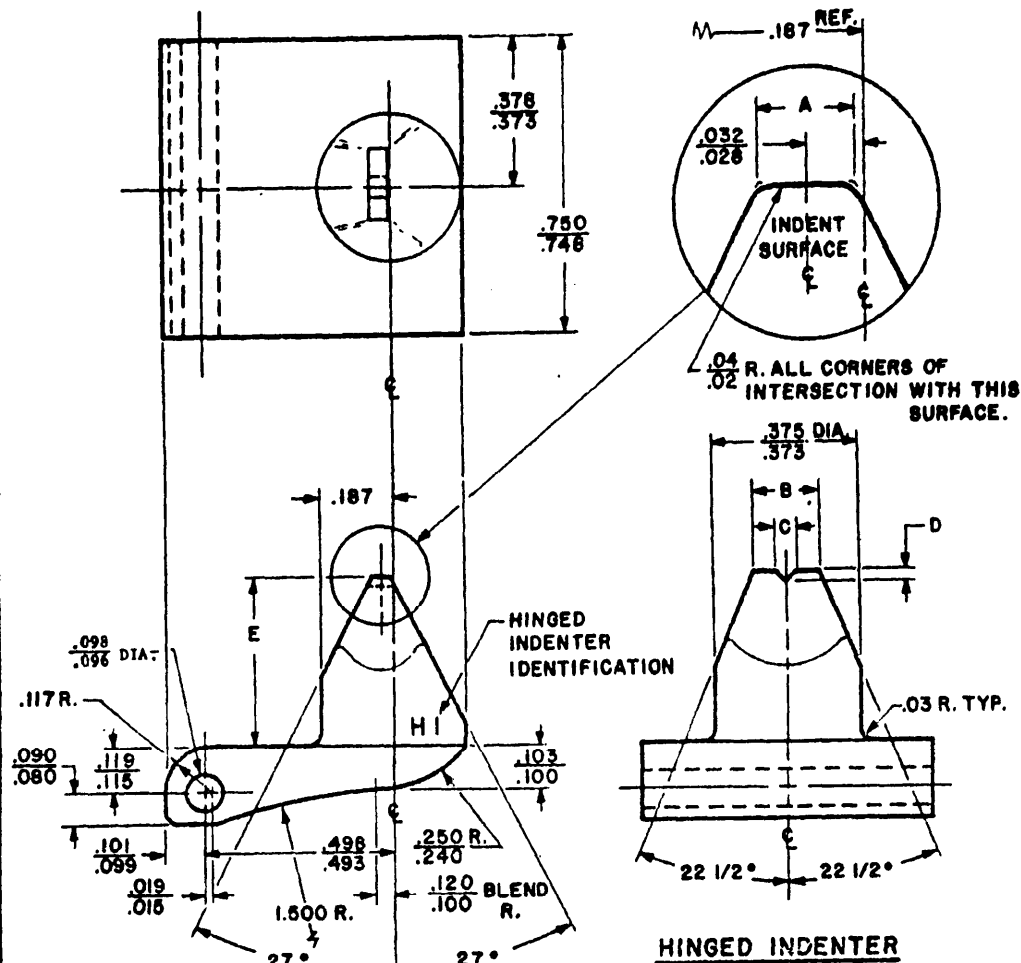
DD FORM 672-1 (Limited coordination)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

This drawing has been approved by the  
Bureau of Naval Ordnance and is intended for use by  
the Navy. All other military activities are required  
to comply with standards when suitable.

APPROVED 1 Apr 1971 REVISED



FED. SUP CLASS  
5120

HINGED INDENTER IDENTIFICATION	CONTACT SIZE	INDENTER DIMENSIONS				
		A	B	C	D	E
H 1	8	±.002	±.002	±.005	±.005	±.0005
H 2	4	.050	.170	.050	.050	.491
H 3	0	.065	.187	.060	.060	.458
		.095	.200	.070	.070	.391

## NOTES:

1. MATERIALS; OIL HARDENED TOOL STEEL, HARDENED TO ROCKWELL "C" 52-56.
2. FINISH; BLACK OXIDE 63 MICROINCHES ( $\sqrt{63}$ ), EXCEPT THE CRIMPING AREA WHICH SHALL BE POLISHED AND BUFFED, THEN CHROME PLATED AND BUFFED TO 4 MICROINCHES ( $\sqrt{4}$ ).
3. ALL INDENTER RADII MUST BLEND.
4. BREAK ALL SHARP EDGES.
5. UNLESS OTHERWISE SPECIFIED; TOLERANCES; DECIMALS  $\pm .002$ , ANGLES  $\pm 1^\circ$ .
6. IDENTIFICATION ENGRAVINGS SHALL BE CUT TO A DEPTH OF .020/.015, MIN. HEIGHT .094.
7. DRAWING NOT TO SCALE.

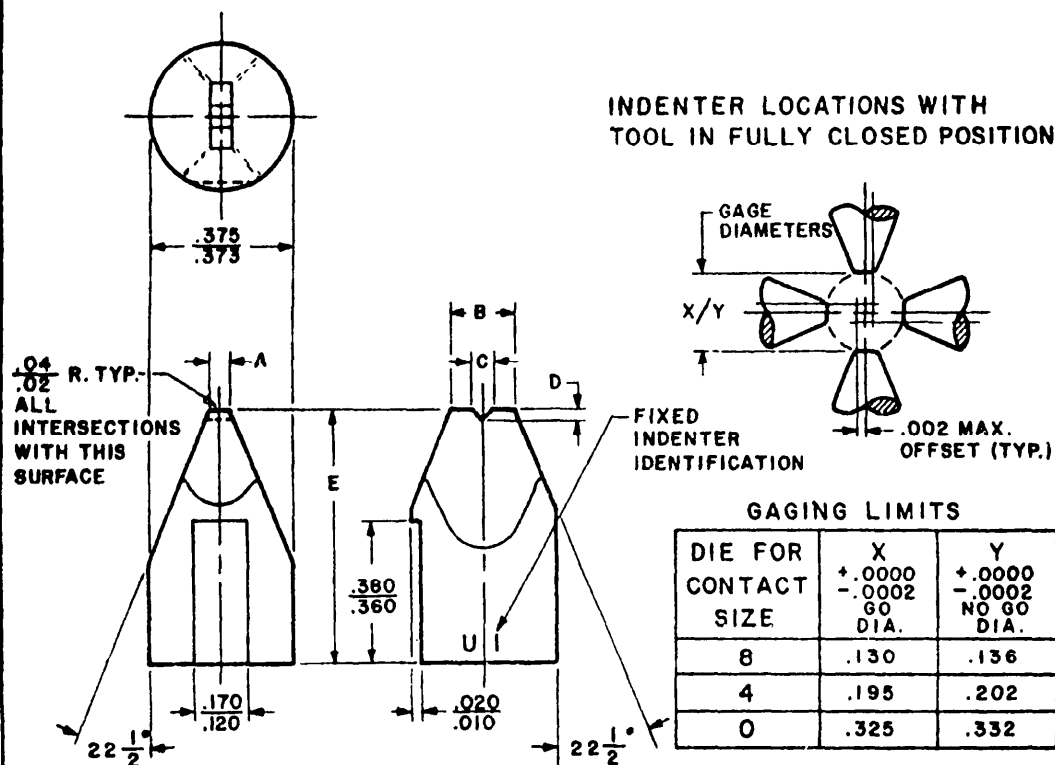
This standard has been approved by the Department of the NAVY, and is mandatory for use by their activity. All other military activities are required to comply with this standard where suitable.

APPROVED 1 Apr 1971 REVISED

P.A. NAVY - AS Other Cost	TITLE DIES FOR CRIMPING MS3190 TYPE B CONTACT WIRE BARRELS (INSTALL DIES IN MS25441-1 HEAD)	MILITARY STANDARD
PROCUREMENT SPECIFICATION MIL-C-22909	SUPERSEDES.	MS 3130 (NAVY)
		SHEET 5 OF 6

DD FORM 672-1 (Limited coordination)

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FED. SUP CLASS  
5120

## FIXED INDENTERS

FIXED INDENTER IDENTIFICATION		CONTACT SIZE	INDENTER DIMENSIONS					
			A ±.002	B ±.002	C ±.005	D ±.005	E ±.0005 UPPER	E ±.0005 LOWER
U1	L1	8	.050	.170	.050	.050	.823	.683
U2	L2	4	.065	.187	.060	.060	.790	.650
U3	L3	0	.095	.200	.070	.070	.725	.585

## NOTES:

1. MATERIALS; OIL HARDENED TOOL STEEL, HARDENED TO ROCKWELL "C" 58-62.
2. FINISH; BLACK OXIDE 63 MICROINCHES (✓), EXCEPT THE CRIMPING AREA WHICH SHALL BE POLISHED AND BUFFED, THEN CHROME PLATED AND BUFFED 4 MICROINCHES (✓).
3. ALL INDENTER RADII MUST BLEND.
4. BREAK ALL SHARP EDGES.
5. UNLESS OTHERWISE SPECIFIED: TOLERANCES; DECIMALS ±.002, ANGLES ±1°.
6. IDENTIFICATION ENGRAVINGS SHALL BE CUT TO A DEPTH OF .020/.015, MIN. HEIGHT .094.
7. DRAWING NOT TO SCALE.

P.A. NAVY - AS  
Other CustTITLE DIES FOR CRIMPING MS3190 TYPE B  
CONTACT WIRE BARRELS  
(INSTALL DIES IN MS2544I-1 HEAD)

MILITARY STANDARD

MS 3150 (NAVY)

PROCUREMENT SPECIFICATION  
MIL-C-22909

SUPERSEDES

SHEET 6 OF 6

DD FORM 672-1 (Limited coordination)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE

APPROVED 1 Apr 1971 REVISED

This standard has been approved by the Department of the Navy and is mandatory for use by that activity. All other military activities are requested to comply with this standard where feasible.