

PROJECT No. 5136-0031

FED. SUP CLASS  
5136

USER SYMBOLS:

NAVY - SH, MC

REVIEWER SYMBOLS:

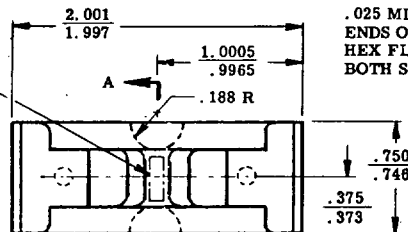
NAVY - OS, EC  
ARMY - GL

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

10-32 UNF-2 SCREW  
SEE DETAIL HMS27980-6N  
DIE SNAP  
FASTENER

DIE RETAINER

DIE HALF  
2 PIECES REQD  
PER SET  
OF DIESSHUT  
HEIGHTMS27980-15N  
DIE SNAP  
FASTENERASSEMBLYENGRAVE TERMINAL  
SIZE IN REVERSE  
CHARACTERS (SEE  
ENGRAVING IN  
TABLE).025 MIN RADIUS  
ENDS OF  
HEX FLATS  
BOTH SIDES.062 X 45°  
CHAMFER  
(TYP)

32

A

32

A

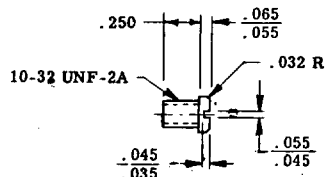
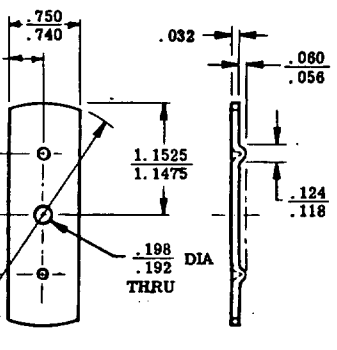
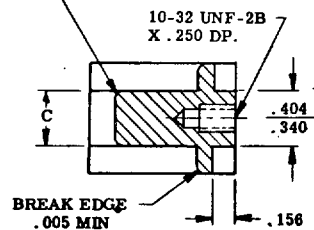
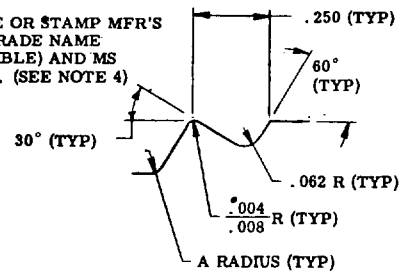
60°  
(TYP)

SEE DETAIL F

B

2

.750 R

.141 DIA X .062 DP.  
(2 - HOLES)1.252  
1.248.626  
.624ENGRAVE OR STAMP MFR'S  
NAME (TRADE NAME  
PERMISSIBLE) AND MS  
PART NO. (SEE NOTE 4)DIEDETAIL HSTEEL SCREWDIE RETAINERSECTION A-ADETAIL FFLASH CUTTER

(E) FOR CHANGES SEE SHEETS 1 &amp; 2

P.A.  
NAVY - AS  
Other CustARMY - EL  
USAF - 84PROCUREMENT SPECIFICATION  
MIL-T-22909

TITLE

DIES, CRIMPING TOOL, FOR USE WITH MS20659  
UNINSULATED WIRE TERMINALS AND EXTERNAL POWER PLUG  
SOCKET CONTACTS (FOR WIRE SIZES 8 THROUGH 4/0)

SUPERSEDES:

AN3427 FOR NAVAIR USE, MS90485(AS)

MILITARY STANDARD

MS90485

SHEET 1 OF 2

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

PLATE NO. 23065

APPROVED 27 JUN 67  
REVISED (A)  
18 DEC 1968  
(B) 5 JUN 1970  
(C) 21 FEB 1972  
(D) 15 FEB 1973  
(E) 30 AUG 74

USGQ BYHQDLO:  
NAVY - SH, MC

REVIEWER SYMBOLS:  
NAVY - OS, EC  
ARMY - GL

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5136

DASH NO.	WIRE SIZE	A $\pm$ .005	B $\pm$ .002	C $\pm$ .003	ENGRAVING	GAGE NO.
-8	8	.062	.210	.310	8 CU	MS90486-8
-6	6		.240		6 CU	MS90486-6
-4	4		.299	.435	4 CU	MS90486-4
-2	2		.377		2 CU	MS90486-2
-1	1		.417		1 CU	MS90486-1
-01	0	.094	.456	.502	1/0 CU	MS90486-01
-02	00		.500		2/0 CU	MS90486-02
-03	000		.562		3/0 CU	MS90486-03
-04	0000		.618		4/0 CU	MS90486-04

#### ADDITIONAL REQUIREMENTS:

1. MATERIAL: DIE, SAE 4340 OR FEDERAL SPECIFICATION QQ-T-570-CLASS 01; DIE RETAINER, SAE 1060 OR 1080 SPRING STEEL.
2. FINISH: CHROMIUM OR NICKEL PLATED IN ACCORDANCE WITH QQ-C-320 OR QQ-N-290 RESPECTIVELY, 63 MICROINCHES ALL OVER EXCEPT THE HEX CRIMPING SURFACES WHICH SHALL BE 32 MICROINCHES OR FINER. CALMIUM PLATING SHALL NOT BE USED.
3. UNLESS OTHERWISE SPECIFIED, ALL HEX ENGRAVINGS SHALL BE LOCATED CENTRALLY IN HEX, CUT TO A DEPTH .015 - .020.
4. ENGRAVING OR STAMPING TO BE AS LARGE AS PRACTICABLE.
5. HEAT TREAT: DIE TO ROCKWELL C42-46, DIE RETAINER SPRING-TEMPER.
6. THESE DIES ARE DESIGNED TO CRIMP MIL-T-7928 UNINSULATED COPPER TERMINALS AND EXTERNAL POWER PLUG SOCKET CONTACTS FOR WIRE SIZES 8 THRU 4/0 INCLUSIVE, USING MS25441 CRIMPING TOOL.
7. REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
8. THREAD DIMENSIONS AND DESIGNATIONS SHALL BE INTERPRETED IN ACCORDANCE WITH HANDBOOK H28.
9. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS  $\pm$  .015, ANGLES  $\pm$  1°.
10. FOR SERVICE USE, CHECK SHUT HEIGHT WITH MS90486 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 - AS Other Cust	TITLE DIES, CRIMPING TOOL, FOR USE WITH MS20659 UNINSULATED WIRE TERMINALS AND EXTERNAL POWER PLUG SOCKET CONTACTS (FOR WIRE SIZES 8 THROUGH 4/0)	MILITARY STANDARD <b>MS90485</b>
ARMY - EL USAF - 84	SUPERSEDES: AN3427 FOR NAVAIR USE, MS90485(AS)	SHEET 2 OF 2
PROCUREMENT SPECIFICATION MIL-T-22909		

DD FORM 672-1 (Coe. dated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

PLATE NO. 23065

APPROVED 27 JUN 67 REVISED (E) FOR CHANGES SEE SHEETS 1 AND 2