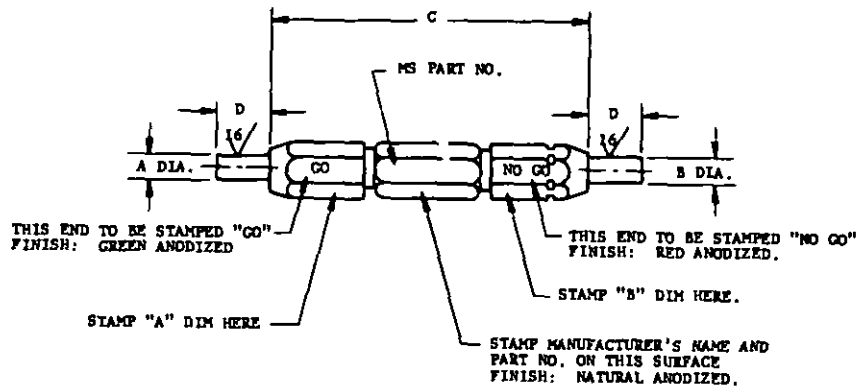


PROJECT NO. 5220-0133

FED. SUP CLASS
5220USER SYMBOLS:
NAVY - MC
ARMY - CLREVIEWER SYMBOLS:
ARMY -
NAVY - SH, OS

DASH NO.	CRIMPING DIE (REF)	A +.0002 -.0000	B +.0000 -.0002	C REF	D ±.030
-8	MS90485-8	.2078	.212	3.12	.440
-6	-6	.2378	.242	3.12	
-4	-4	.2968	.301	3.59	.482
-2	-2	.3748	.379	4.18	.545
-1	-1	.4148	.419		
-01	-01	.4538	.458		
-02	-02	.4978	.502	4.53	.612
-03	-03	.5418	.546		.737
-04	MS90485-04	.6158	.620		.856

NOTES:

1. MATERIAL: GAGE PIN; 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.
2. FINISH: GAGE PINS; CHROME FLASH, .0002 TO .0003 THICK, PER SPECIFICATION QQ-C-320, CLASS 2d.
3. DIMENSIONS OF A AND B ARE AFTER CHROME FLASHING. TOLERANCE: CLASS 2, PER HANDBOOK H-28.
4. DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED.
5. ALL STAMPING TO BE .093 HIGH AND INDENTED.
6. THESE GAGES ARE FOR INSPECTION OF MS90485 CRIMPING DIES FOR WIRE SIZES 8 THRU 4/0 COPPER UNINSULATED TERMINALS.
7. GAGES AND GAGE HANDLE SHALL BE FABRICATED IN ACCORDANCE WITH DEPT. OF COMMERCE COMMERCIAL STANDARD C88.

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

(B) ENTIRE STANDARD REDRAWN.

P.A. NAVY - AS Other Code ARMY - EL USAF - 84	TITLE GAGE, IN-SERVICE-INSPECTION; FOR USE WITH MS90485 CRIMPING DIES. (FOR USE WITH COPPER UNINSULATED TERMINALS)	MILITARY STANDARD MS 90486
PROCUREMENT SPECIFICATION DEPT OF COMMERCE C88	SUPERSEDES.	SHEET 1 OF 1

DD FORM 572-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

PLATE NO. 2286

APPROVED 27 JUN 67
REVISED
9 NOV 1972

This military standard is approved for use by all Departments
in accordance with the Department of Defense. Selection for all use
engineering and design applications and for routine use shall
be made from this document.

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