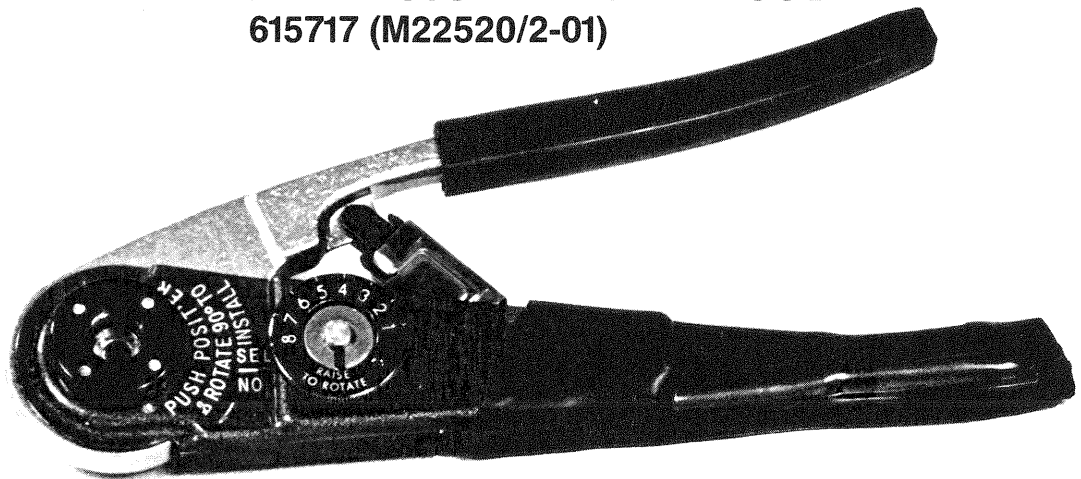


MINIATURE STEP ADJUSTABLE CRIMP TOOL 615717 (M22520/2-01)



- **8 indent crimp**
- **Uses bayonet positioners**

- **Dial selectable**
- **Cycle controlled ratchet**

The MIL-C-22520/2 qualified Astro 615717 miniature 8-step adjustable hand crimping tool's 8-indent crimp configuration provides excellent results on contacts sizes 20-28 and wire sizes 20-32 AWG.

A wide variety of MS and proprietary contacts and wire compositions can be crimped by simply attaching positioner in the bayonet-type socket and adjusting the selector to one of the 8 preselected settings. The tool is equipped with a positive ratchet that requires the completion of the crimp cycle to insure the integrity of each crimp.

Astro offers a wide variety of positioners (see opposite page) to accommodate various mil-spec and proprietary contacts. Each positioner has a data plate which provides the correct crimp depth setting for the contact and wire combination. Astro also offers two adjustable positioners (615179 & 615179-1) that allow you to adjust the crimp location according to your specific needs. Custom positioners are available upon request.

Astro recommends the periodic gaging of all its tools. A gage (615716, M22520/3-1) is available for this purpose.

The 615717 is 7½ inches long and weighs 11 ounces.

The 615717 is also available in a pneumatic version. See page 39.

For ultra precise crimps on miniature and subminiature contacts with very thin wire barrel dimensions Astro offers the 620613. This tool is built from the same tool frame as the 615717 (M22520/2-01) and utilizes the same positioners.

ASTRO TOOL CORP.

| MS NO. | ASTRO TOOL #. | DESCRIPTION | NSN | CONTACTS ACCOMMODATED |
|-------------|---------------|-------------|------------------|--|
| M22520/2-01 | 615717 | Tool Frame | 5120-00-165-3910 | |
| M22520/2-02 | 615718 | Positioner | 5120-00-165-3913 | MS3192-20-20, MS3193-20-20, MS24254-20P, MS24254-20S, MS18134-20, MS18136-20, M39029/4-110, M39029/5-115, M39029/9-132, -133, -134, -135, -136, M39029/10-138, -139, -140, -141, -142, M83723/33-20, M83723/34-20, M39029/31-223, -224, -225, -226, -227, -240, -241, -448, M39029/32-242, -243, -244, -245, -246, -259, -260, -449, M39029/92-532 |
| M22520/2-03 | 615719 | Positioner | 5120-00-016-7657 | MS3343-23-22 (A&B), MS3343-23-28 (A&B), MS90460-23-22 (A&B), MS90460-23-28 (A&B), MS90461-23-22 (A&B), MS90461-23-28 (A&B), M39029/33-262, -264, M39029/46-302, -304, M39029/47-312, -314 |
| M22520/2-04 | 615720 | Positioner | 5120-00-017-3640 | Inner P&S, MS18232-1, MS18233-1, MS18265-1, MS18265-2, MS18266-1, MS18266-2, M39029/40-281, M39029/41-282, M39029/42-283, -284, M39029/43-285, -286 |
| M22520/2-05 | 615721 | Positioner | 5120-00-017-3742 | M21097/9-01 |
| M22520/2-06 | 615722 | Positioner | 5120-00-017-3809 | MS27491-22, MS27491-22M, MS27491-22D, MS27492-22, MS27492-22M, MS27492-22D, M24308/12-1, M39029/57-354, -355, -356, M39029/89-494, -495, -496, -497, M39029/92-531 |
| M22520/2-07 | 615723 | Positioner | 5120-00-017-3827 | MS27490-22, MS27490-22M, MS27490-22D, M39029/56-348, -349, -350, M39029/88-482, -483, -484, -485 |
| M22520/2-08 | 615724 | Positioner | 5120-00-017-3921 | M24308/10-1, M24308/11-1, M39029/11-145, M39029/12-149, M39029/63-368, M39029/64-369, M39029/67-374, -375, -376, -377, -378, M39029/68-379, -380, -381, -382, -383, M39029/93-538, M39029/94-542 |
| M22520/2-09 | 615725 | Positioner | 5120-00-017-3927 | MS27493-22, MS27493-22M, MS27493-22D, MS27494-22, MS27494-22M, MS27494-22D, M24308/13-1, M39029/58-360, -361, -362, M39029/87-470, -471, -472, -473 |
| M22520/2-10 | 615726 | Positioner | 5120-00-017-3932 | MS27490-20, MS27491-20, MS27492-20, MS27493-20, MS27494-20, M39029/56-351, M39029/57-357, M39029/58-363, M39029/87-474, -475, -476, -477, M39029/88-486, -487, -488, -489, M39029/89-498, -499, -500, -501 |
| M22520/2-11 | 615727 | Positioner | 5120-00-017-3934 | M39029/1-100, -101, M39029/2-104, -105, M39029-107, -108 |
| M22520/2-12 | 615729 | Positioner | 5120-00-017-3935 | Inner Pin and Socket M39029/65-370, -371, M39029/66-372, -373 |
| M22520/2-13 | 616031 | Positioner | 5120-00-132-6939 | M39029/16-166, -167, M39029/18-176, -177 |
| M22520/2-14 | 616032 | Positioner | 5120-00-132-6962 | M39029/16-168, M39029/18-178 |
| M22520/2-15 | 616033 | Positioner | 5120-00-132-6978 | M39029/16-169, M39029/18-179 |
| M22520/2-16 | 616034 | Positioner | 5120-00-132-7868 | M39029/17-171, -172 |
| M22520/2-17 | 616035 | Positioner | 5120-00-132-7893 | M39029/17-173 |
| M22520/2-18 | 616036 | Positioner | 5120-00-132-7894 | M39029/17-174 |
| M22520/2-19 | 616037 | Positioner | 5120-00-132-7872 | M39029/15-22-22, M39029/15-22-28 |
| M22520/2-20 | 616038 | Positioner | 5120-00-132-9004 | M39029/15-164 |
| M22520/2-21 | 616039 | Positioner | 5120-00-133-0029 | M39029/15-165 |

A wide variety of Positioners are available, in addition to those listed above.

ASTRO TOOL CORP.

| MS NO. | ASTRO TOOL # | DESCRIPTION | NSN | CONTACTS ACCOMMODATED |
|-------------|--------------|-------------|------------------|---|
| M22520/2-22 | 615448 | Positioner | 5120-01-106-3737 | 10215913 (Army-Redstone) |
| M22520/2-23 | 616191 | Positioner | 5120-01-117-3905 | M39029/11-144, M39029/12-148, M39029/93-537, M39029/94-541 |
| M22520/2-24 | 616260 | Positioner | 5120-00-348-7531 | Inner P&S FSCM98230, ONO89558, M39029/54-343, M39029/55-345 |
| M22520/2-25 | 616411 | Positioner | 5120-00-132-6932 | M39029/6-121, -122, -123, -124, -125, M39029/13-153, -154, -155, -156, -157, M39029/14-159, -160, -161, -162, -163 |
| M22520/2-26 | 616412 | Positioner | 5120-00-133-3263 | M39029/6-120, M39029/13-152, M39029/14-158 |
| M22520/2-27 | 616413 | Positioner | | Inner Pin and Socket, M39029/7-126, -127, -128, M39029/8-129, -130, -131 |
| M22520/2-28 | 616414 | Positioner | 5120-00-124-3678 | Inner Pin and Socket, M39029/19-181, M39029/20-184, M39029/21-187 |
| M22520/2-29 | 616415 | Positioner | 5120-00-124-3682 | Inner Pin and Socket, M39029/19-182, -183, M39029/20-185, -186, M39029/21-188, -189 |
| M22520/2-30 | 616416 | Positioner | 5120-01-117-3905 | Inner Contact M83733/13, M83733/14, M39029/50-340, M39029/51-341 |
| M22520/2-31 | 616417 | Positioner | | Inner Pin and Socket MS27535-8, MS27536-8, M39029/59-366, M39029/60-367 |
| M22520/2-32 | 620261 | Positioner | | Inner Pin and Socket, M39029/1-507, M39029/25-204, -205, -206, M39029/26-207, -208, -209 |
| M22520/2-33 | 615257 | Positioner | | Inner Pin and Socket, M39029/54-342, M39029/55-344 |
| M22520/2-34 | 620499 | Positioner | | Inner Pin and Socket, M39029/27-210, -402, -403, -404, -405, -406, -407, -408, M39029/28-211, -409, -410, -411, -412, -413, -414, -415, M39029/75-416, -417, -419, -420, -421, -422, -423 |
| M22520/2-35 | 620517 | Positioner | | Inner Pin and Socket, M39029/76-424, -425, -426, -427, M39029/77-428, -429, -430, -431, M39029/78-432, -433, -434, -435 |
| M22520/2-36 | 616429 | Positioner | | M28804/9-1, M28804/10-1 |

A wide variety of Positioners are available, in addition to those listed above.