



# ASTRO TOOL CORP.

## CONNECTOR ASSEMBLY TOOLING

AMT1701 CRIMP TOOL

M22520/17-01

### GENERAL

The Astro Tool Corp. AMT1701 tool is a cycle controlled, closed frame tool for crimping 60 8017 0313 contacts, per MIL-C-28731/20, and per wire spec MIL-W-16878E.

### WIRE STRIP DIMENSION:

7/64 inch +/- 1/64. for best results strands of wire should not be combed, frayed or untwisted.

### CONDUCTOR AND INSULATION SETTINGS:

With tool handle in open position, lift and turn knurled knob to line up red indicator mark on knob with number stamped on side plate. This number should correspond to suggested settings according to wire size being crimped (see data plate on tool).

### INSERTION OF CONTACT:

Insert contact through hole in insulation side of tool. Fully seat contact in locator. Points of U-shaped contact crimp area must be directed toward the cam adjustment knob.

### WIRE INSERTION AND CRIMPING PROCEDURE:

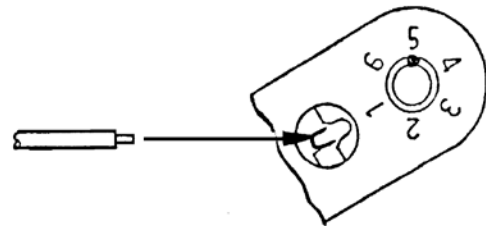
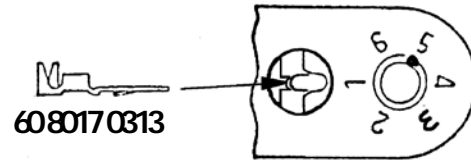
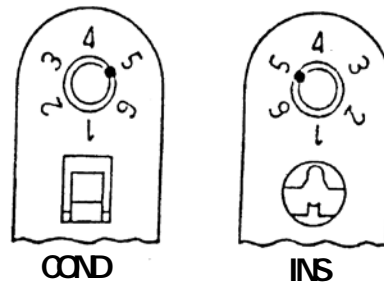
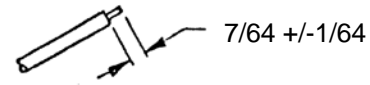
Insert wire until it touches wire stop. Close handle of tool to mechanical stop, completing crimp. Release handle and pull wire and contact assembly from locator.

### NOTE:

The tool is equipped with a ratchet mechanism which prevents handle from being opened until proper crimp pressure has been applied.

### SUGGESTED SETTINGS:

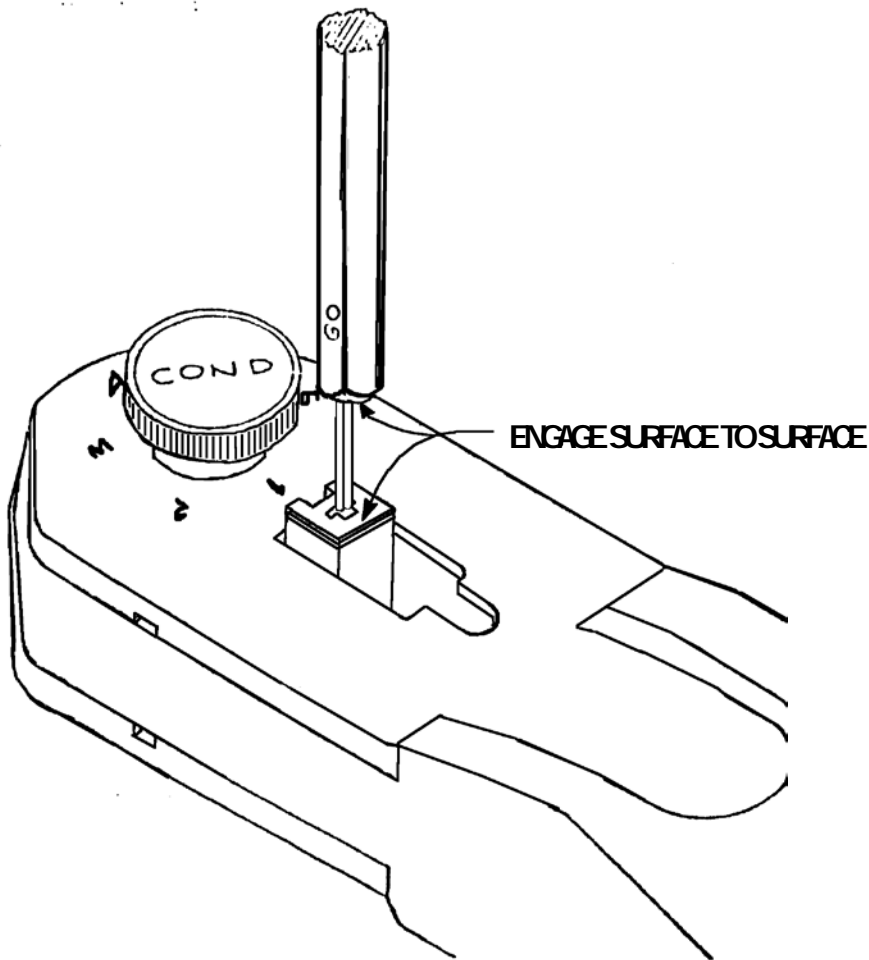
AWG SIZE	INS. DIA.	INS AND COND SETTING
18	.064-.074	6
20	.054-.062	5
22	.046-.054	4
24	.044-.048	3
26	.035-.043	2



**IN-SERVICE GAGE M22520/18-1  
TO GAGE  
CRIMPING TOOL M22520/17-01  
ASTRO PART NO. AMT1701**

Position the CONDUCTOR and INSULATOR knobs on (1) setting.  
Insert gage into "cond" side as shown. See illustration for surface to surface contact on total engagement.  
NEVER ATTEMPT TO GAGE TOOL FROM "INS" SIDE

Activate the tool to the fully closed position. The "GO" gage shall be freely inserted in the space between the opposing closed indenters or dies of the tool. With the "GO" pins in this position, the pressure on the tool handles shall be released, and the tool shall automatically return to its fully open position.  
Remove the "GO" end of gage. Close the tool to fully closed position. The "NO GO" pins of the gage shall not be insertable between the opposing indenter or dies of the tool.



**ASTRO TOOL CORP. MANUFACTURERS OF INSERTION, REMOVAL,  
CRIMP TOOLS AND CONNECTOR SERVICE KITS**

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