

Table VIII

Contact Size	Wire Size AWG	VEAM Contact Number	AF8 or M22520/1-01 Hand Tools			Model 400 BHD Pneumatic		Model 500 D Pneumatic	
			Turret	Setting	Color	Die Part No.	Locator Part No.	Die Part No.	Locator Part No.
20P	20	46730-20P	616266	20/4	Red	.....	.....	.....	.....
20S	20	46731	616266	20/4	Green	.....	.....	.....	.....
18P	18	46740P	TH485	20/4	Yellow	.....	.....	.....	.....
18S	18	46740S	TH485	20/4	Red	.....	.....	.....	.....
18P	20-22	46740-15P	TH485	20/4	Yellow	.....	.....	.....	.....
18S	20-22	46740-15S	TH485	20/4	Red	.....	.....	.....	.....
18P	16	46740-22P	TH485	16/6	Yellow	.....	.....	.....	.....
18S	16	46740-22S	TH485	16/6	Red	.....	.....	.....	.....
16S P	16	27911	616266	16/6	Red	414DA-16N	4314-2	.....	.....
16S S	16	27961	616266	16/6	Red	414DA-16N	4314-1	.....	.....
16S P	20-24	27911-13	616266	20/4	Red	.....	.....	.....	.....
16S S	20-24	27961-13	616266	20/4	Red	.....	.....	.....	.....
16S P	20	27911-15	616266	18/5	Red	414DA-16N	4314-2	.....	.....
16S S	20	27961-15	616266	18/5	Red	414DA-16N	4314-1	.....	.....
16S P	14-16	27911-20	616266	16/6	Red	414DA-12N or 16N	4314-2	.....	.....
16S S	14-16	27961-20	616266	16/6	Red	414DA-12N or 16N	4314-1	.....	.....
16S P	12-14	27911-26	616266	12/8	Red	414DA-12N	4314-1	.....	.....
16S S	12-14	27961-26	616266	12/8	Green	414DA-12N	4314-2	.....	.....
16 P	16	27913	616266	16/6	Blue	414DA-16N	4332	.....	.....
16 S	16	27963	616266	16/6	Green	414DA-16N	4332	.....	.....
16 P	24-26	27913-08	616266	20/4	Blue	.....	.....	.....	.....
16 S	24-26	27963-08	616266	20/4	Green	.....	.....	.....	.....
16 P	20-22	27913-12	616266	20/4	Blue	.....	.....	.....	.....
16 S	20-22	27963-12	616266	20/4	Green	.....	.....	.....	.....
16 P	20-24	27913-13	616266	20/4	Blue	.....	.....	.....	.....
16 S	20-24	27963-13	616266	20/4	Green	.....	.....	.....	.....
16 P	18-20	27913-15	616266	20/5	Blue	414DA-16N	4332	.....	.....
16 S	18-20	27963-15	616266	20/5	Green	414DA-16N	4333	.....	.....
16 P	14-16	27913-20	616266	16/6	Blue	414DA-12N or 16N	4332	.....	.....
16 S	14-16	27963-20	616266	14/7	Green	414DA-12N or 16N	4333	.....	.....
16 P	12-14	27913-26	616266	12/8	Blue	414DA-12N	4332	.....	.....
16 S	12-14	27963-26	616266	12/8	Green	414DA-12N	4333	.....	.....
12 P	8	27914-8	.....	.....	.....	414DA-8HEX or 8N	4330M	.....	.....
12 S	8	27964-8	.....	.....	.....	414DA-8HEX or 8N	4331M	.....	.....
12 P	20-22	27914-12	616266	20/4	Green	.....	.....	.....	.....
12 S	20-22	27964-12	616266	20/4	Green	.....	.....	.....	.....
12 P	14-18	27914-20	616266	12/8	Green	414DA-10N	4330	.....	.....
12 S	14-18	27964-20	616266	12/8	Green	414DA-10N	4331	.....	.....
12 P	2.5mm <sup>2</sup>	27914-22	616266	12/8	Green	414DA-10N	4330	.....	.....
12 S	2.5mm <sup>2</sup>	27964-22	616266	12/8	Green	414DA-10N	4331	.....	.....
12 P	12	27914-26	616266	12/8	Green	414DA-12N or 10N	4330	.....	.....
12 S	12	27964-26	616266	12/8	Green	414DA-12N or 10N	4331	.....	.....
12 P	4mm <sup>2</sup>	27914-30	.....	.....	.....	414DA-10N	4330	.....	.....
12 S	4mm <sup>2</sup>	27964-30	.....	.....	.....	414DA-10N	4331	.....	.....
12 P	10	27914-38	.....	.....	.....	414DA-10N	4330	.....	.....
12 S	10	27964-38	.....	.....	.....	414DA-10N	4331	.....	.....

Table VIII

Contact Size	Wire Size AWG	VEAM Contact Number	AFB Hand Tool	Model 400 BHD Pneumatic		Pneumatic Model 500 D	
			Turret	Die Part Number	Locator Part Number	Die Part Number	Locator Part Number
8P	4 mm sq	27915-30	---	414DA-10N	4329	---	---
8S	4 mm sq	27935-30	---	414DA-10N	4329	---	---
8P	10	27915-38	---	414DA-10N	4329	---	---
8S	10	27935-38	---	414DA-10N	4329	---	---
8P	6	27915-58	---	414DA-8 HEX	4329	514DA-8 HEX	5497
8S	6	27935-58	---	414DA-8 HEX	4329	514DA-8 HEX	5497
8P	8	27915	---	414DA-8 HEX OR 8N	4329	514DA-8 HEX	5404
8S	8	27935	---	414DA-8 HEX OR 8N	4329	514DA-8 HEX	5404
8P	12-14	27915-26-62	---	414DA-8N	4329	514DA-8 HEX	5404
8S	12-14	27935-26-62	---	414DA-8N	4329	514DA-8 HEX	5404
8P	12-14	27915-26	---	414DA-10N	4329	---	---
8S	12-14	27935-26	---	414DA-10N	4329	---	---
4P	4 AWG 6 AWG	27916	---	414DA-4 HEX 414DA-8N or 8 HEX	4043	514DA-4 HEX 514DA-8N or HEX	5497
4S	4 AWG 6 AWG	27936	---	414DA-4 HEX 414DA-8N or 8 HEX	4043	514DA-4 HEX 514DA-8N or HEX	5497
4P	2.5 mm sq.	27916-22	---	414DA-12N	4043	---	---
4S	2.5 mm sq.	27936-22	---	414DA-12N	4043	---	---
4P	16 mm sq	27916-62	---	414DA-4 HEX	4043	514DA-4 HEX	5497
4S	16 mm sq	27936-62	---	414DA-A HEX	4043	514DA-4 HEX	5497
0P	0	27917V	---	---	---	---	---
0S	0	27937V	---	---	---	514DA-0 HEX	5441
0P	8	27917-45	---	---	---	514DA-0/8 HEX	5442
0S	8	27937-45	---	---	---	514DA-0/8 HEX	5441
0P	10 mm sq	27917-50	---	---	---	514DA-0/8 HEX	5442
0S	10 mm sq	27937-50	---	---	---	514DA-0/8 HEX	5441
0P	16 mm sq	27917-62	---	---	---	514DA-4 HEX	5442
0S	16 mm sq	27937-62	---	---	---	514DA-4 HEX	5441
0P	25 mm sq	27917-78	---	---	---	514DA-4 HEX	5442
0S	25 mm sq	27937-78	---	---	---	514DA-4 HEX	8002
0P	35 mm sq	27917-90	---	---	---	514DA-0 HEX	5442
0S	35 mm sq	27937-90	---	---	---	514DA-4 HEX	5442
0P	50 mm sq	27917-107	---	---	---	514DA-4 HEX	5442
0S	50 mm sq	27937-107	---	---	---	514DA-0 HEX	5441
0P	4	46646-0	---	---	---	514DA-4 HEX	5441-F
0S	4	4764-0	---	---	---	514DA-4 HEX	5441-F
4/0 P	2	47107-90	--	---	---	514DA-0 HEX	5498-1
4/0 S	2	47114-90	---	---	---	514DA-0 HEX	5498-2
4/0 P	0 (1/0)	47107-115	---	---	---	514DA-0 HEX	5498-1
4/0 S	0 (1/0)	47114-115	---	---	---	514DA-0 HEX	5498-2
4/0 P	2/0	47107-135	---	---	---	514DA-2/0 HEX	5498-1
4/0 S	2/0	47114-135	---	---	---	514DA-2/0 HEX	5498-1
4/0 P	70 mm sq	47107-144	---	---	---	514DA-4/0 HEX	5487
4/0 S	70 mm sq	47114-144	---	---	---	514DA-4/0 HEX	5487
4/0 P	95 mm sq	47107-165	---	---	---	514DA-4/0 HEX	5487
4/0 S	95 mm sq	47114-165	---	---	---	514DA-4/0 HEX	5487
4/0 P	4/0	47107-165	---	---	---	514DA-4/0 HEX	5487
4/0 S	4/0	47114-165	---	---	---	514DA-4/0 HEX	5487

\* TH378 & TH379 maybe combined into one turret under P/N 616266

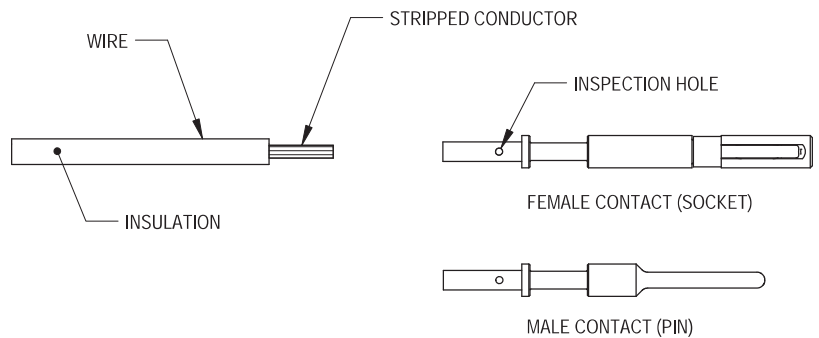


1. Select the proper crimp tool and contact locator for the contact used from Table VIII. Contacts Size 8 and larger require a pneumatic crimper (See Page 22).
2. Install the proper turret or contact positioner onto the crimp tool frame. Per Table VIII.
3. Check crimp tool calibration with a Go No-Go gauge (refer to page 21 for AF8 calibration). Go No-Go inspection gauges are available- consult factory.
4. Set the tool for the contact being crimped as per Table VIII, page 17.
5. Insert stripped wire into the contact wire bucket.
6. Check inspection hole to see if the wire strands are evident. If you cannot see them, conductor strip length is too short. See Figure 15

Table IX

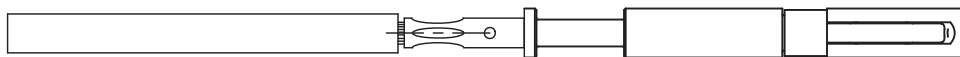
Crimp Retention Forces Per MIL-C-39029B		
Wire Sizes	Silver or Tin-Plated Copper Wire Pounds Minimum	Nickel Plated Copper Wire Pounds Minimum
20	20	19
16	50	37
14	70	60
12	110	100
10	150	135
8	220	200
6	300	270
4	400	360
0	700	630
4/0	875	785

Figure 15



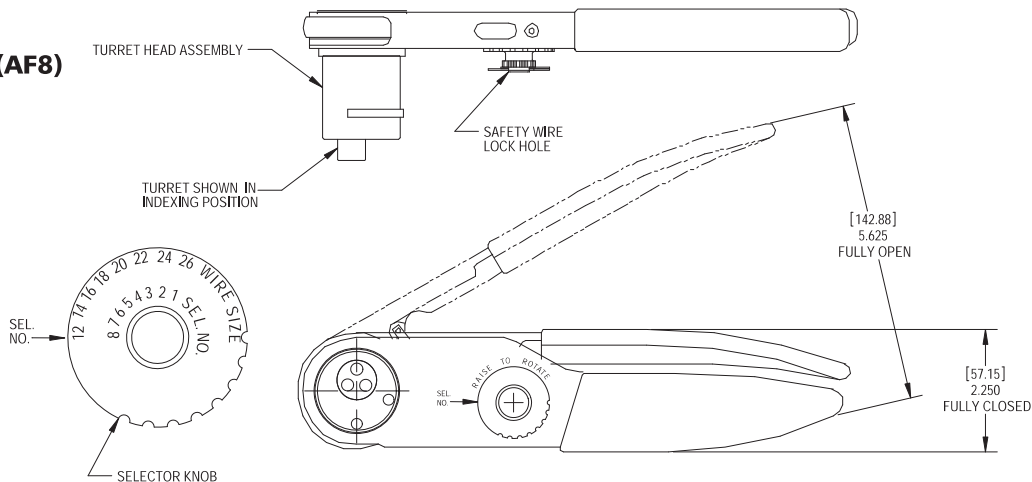
7. Insert the contact with the wire installed into the contact locating hole in the crimp tool positioner until it "bottoms" in the locating hole.
8. Activate crimp tool through one complete cycle.  
*Important: Tool ratchet action will not allow the contact to be removed in mid cycle.*
9. Examine the crimp joint for proper crimp location (see Figure 16). Loose wire strands or cracks in the contact crimp area must not be allowed. Proper crimp retention forces are detailed in Table IX.

Figure 16



Crimping Tools - Set up and Calibration

Figure 17 Crimp Tool (AF8)



**Crimp Tool Set Up - AF8 or M22520/1-01**

1. Select proper turret from Table VIII, Page 17 and install it onto the AF8 crimp tool frame with the hex wrench supplied with the tool (9/64 hex).

Changing Turret Head

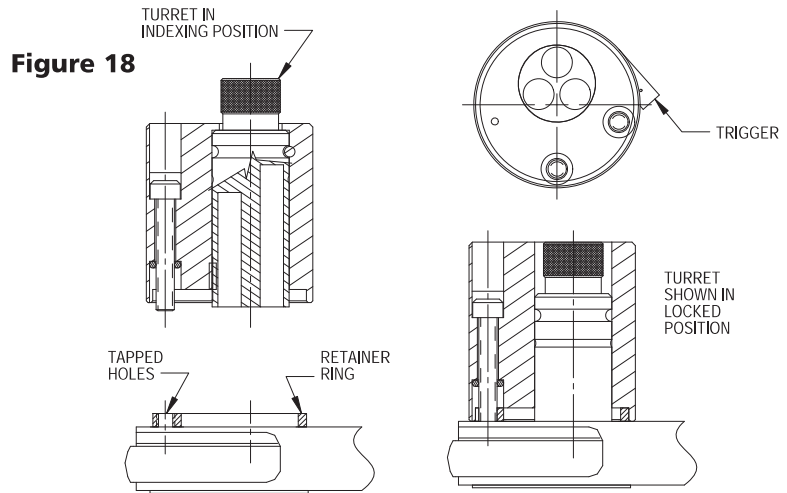
All turrets are attached by means of two socket head screws.

Press the trigger which releases the Turret to the indexing position.

With screws lined up with the tapped holes, place the selected Turret Head Assembly onto the retainer ring.

After the Turret Head Assembly is seated against the ring, tighten the socket head screws with a 9/64 inch Allen Wrench. Turret should index easily without binding.

To remove, loosen socket head screws until the threads are disengaged from the retainer ring and remove with a straight lifting motion.



**Figure 18**

Using Indentor Closure Selector

Refer to data plate on Turret Head Assembly and Table VIII, page 17 for wire and contact size (Figure 19a).

Remove the spring clip lock from selector knob.

The tool must be in the open position when using selector.

Raise selector knob and rotate to desired selector setting (Refer to Table VIII, page 17). Replace the spring clip. The tools is ready for use. Repeat the instruction procedure when changing contact and/or wire sizes.

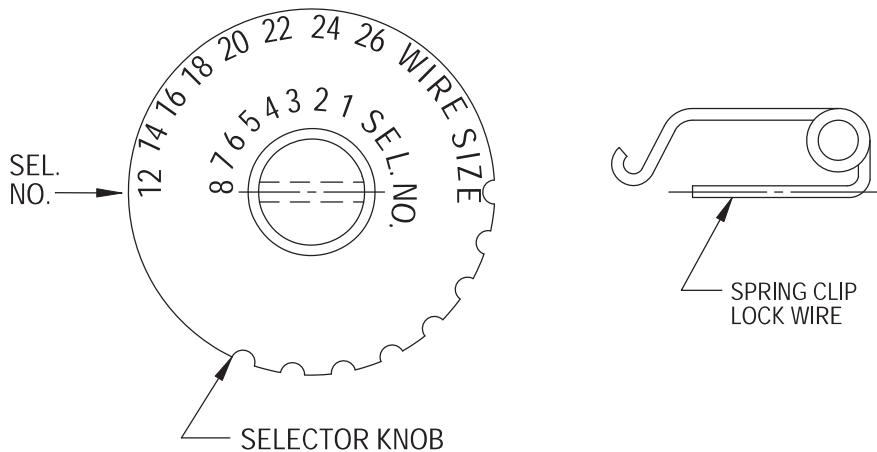
**Figure 19a**

Typical Data Plate

CONTACT	COLOR CODE	26	24	22	20	18	16	14	12	WIRE SIZE
-20	RED	1	2	3	4					SEL. No.
-16	BLUE				4	5	6			
-12	GREEN							7	8	

2. Adjust the indentor closure selector per Figure 19b.

**Figure 19b**



3. Index the turret head assembly for the proper contact per Figure 20.

Indexing Turret Head

Assemblies:

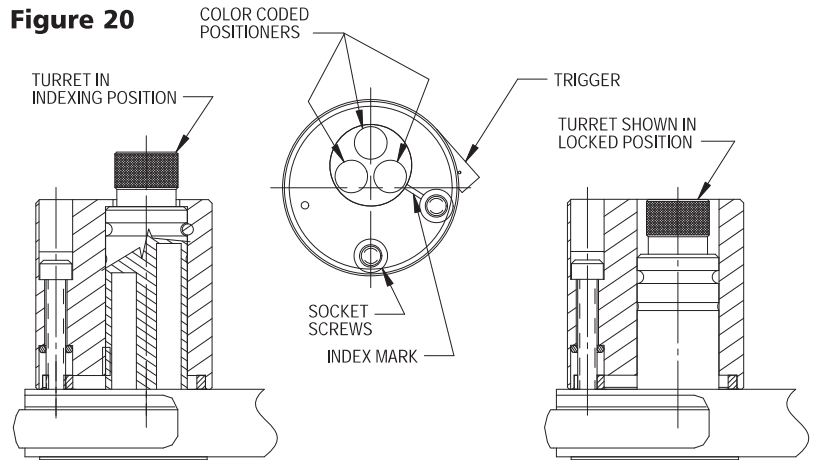
Press trigger to release the Turret to the indexing position.

Select the setting desired according to color coded data plate on Turret Head Assembly (Figure 19a) and Turret setting chart, page 17.

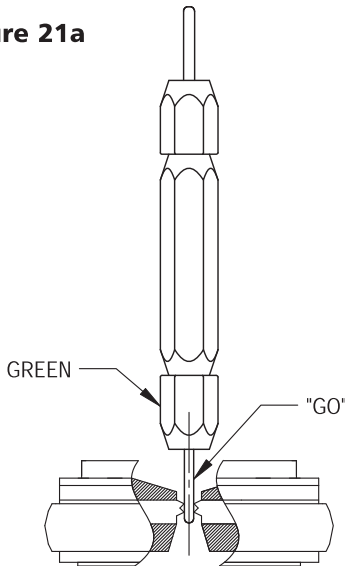
Index the Turret until the color coded positioner is lined up with the index mark on the Turret Head Assembly. The trigger will position the Turret.

Press the positioner until it snaps into locked position.

**Figure 20**



**Figure 21a**



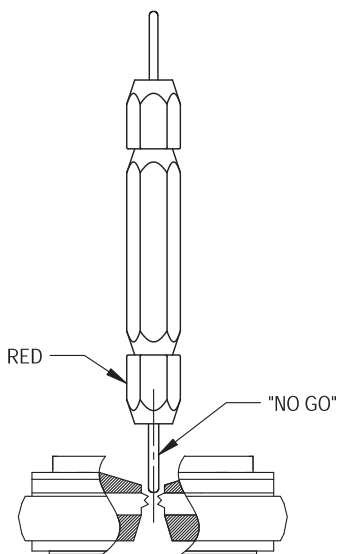
You are now ready to check calibration and crimp wire into the contact.

**Crimping Tools and Calibration - AF8**

1. Set the selector knob to position No. 4 (whether the turret is installed or not is immaterial).
2. Move the handles to the fully closed position.
3. Insert the "Go" gauge (G125) as shown in Figure 21a. The gauge must pass freely between the indenter tips. Remove the gauge.
4. Insert the "No-Go" gauge shown in Figure 21b. The gauge must not enter between the indenter tips.

**Caution: Do not crimp the gauge.**

**Figure 21b**



**Figure 21c**

