



MIDDLE RANGE INDENT CRIMP TOOL MH860 M22520/7-01

Qualified to MIL-DTL-22520/7*, the DMC MH860 is a recent addition to the military specification. It was developed to meet the demonstrated need for supporting the majority of electrical systems with one versatile crimp tool frame.

The MH860 accepts the entire middle wire range of 16 through 28 AWG, with positioners which adapt it to virtually all applications consistent with others in the MIL-DTL-22520 family.



The DMC123 tool kit contains the MH860 tool frame, tool gage, and all mil-spec positioners. Also included in the DMC123 are tool instruction sheets and a tool selection chart.

* Change to SAE AS22520 in process consult DMC for status.

MIL 860 PART NUMBERS			
MILITARY P/N	DMC P/N	DESCRIPTION	NSN
M22520/7-01	MH860	TOOL FRAME	5120-01-335-8573
M22520/7-02	86-1S	POSITIONER	5120-01-335-8597
M22520/7-03	86-2	POSITIONER	5120-01-335-8598
M22520/7-04	86-3	POSITIONER	5120-01-335-8599
M22520/7-05	86-4	POSITIONER	5120-01-335-8600
M22520/7-06	86-5	POSITIONER	5120-01-335-8601
M22520/7-07	86-6	POSITIONER	5120-01-335-8602
M22520/7-08	86-7	POSITIONER	5120-01-335-8603
M22520/7-09	86-11S	POSITIONER	5120-01-335-8604
M22520/7-10	86-12S	POSITIONER	5120-01-335-8605
M22520/7-11	86-19	POSITIONER	5120-01-335-8606
M22520/7-12	86-20	POSITIONER	5120-01-335-8607
M22520/7-13	86-21	POSITIONER	5120-01-335-8608
M22520/3-3	G145	GAGE	5120-00-338-0378
	86-37	ADJUSTABLE POSITIONER	
	DMC123	M22520/7 TOOL KIT	5180-01-355-5616



THE MIL-DTL-28840 TOOLING

MIL-DTL-28840 connectors were developed for the Navy, for use with jacketed cable for shipboard applications. They are a high density circular connector series utilizing a high shock threaded coupling system with front release crimped contacts.

For these connectors DMC has added a new crimping tool to its range, the M22520/34-01.

MIL-DTL-28840 TOOLING PART NUMBERS			
MILITARY P/N	DMC P/N	DESCRIPTION	NSN
M22520/34-01	39-000	BASIC CRIMP TOOL	5120-01-242-3516
M22520/34-02	39-102	POSITIONER	5120-01-242-1041
M22520/35	G345	GAGE	5220-01-392-1065
M81969/33-01	DAK55-22SA	INST. TOOL (STRAIGHT)	5120-01-230-1506
M81969/33-02	DAK55-22JA	INST. TOOL (OFFSET)	5120-01-335-8666
M81969/34-01	DRK56-22A	REMOVAL TOOL	5120-01-230-1507
	DMC782	MIL-C-28840 TOOL KIT	5180-01-363-1391

INTERMEDIATE ADJUSTABLE CRIMP TOOL MH860 (M22520/7-01)

DMC DANIELS
MANUFACTURING
CORPORATION
DATASHEET

THIS HAND TOOL MUST NOT BE USED IN ANY POWERED
"PRESS" AS DEFINED BY OSHA CFR 1910.211 (46)

SEE REVERSE SIDE FOR IMPORTANT INFORMATION CONCERNING
LIMITED WARRANTY, AND LIMITATION OF LIABILITY.

GENERAL INFORMATION:

1. Designation MH860 (M22520/7-01) refers to basic tool without positioner.
2. Wire crimp range 16 to 28 AWG
3. The tool has a double action ratchet, and cannot be opened without completing the cycle.

INSTALLATION OF POSITIONER:

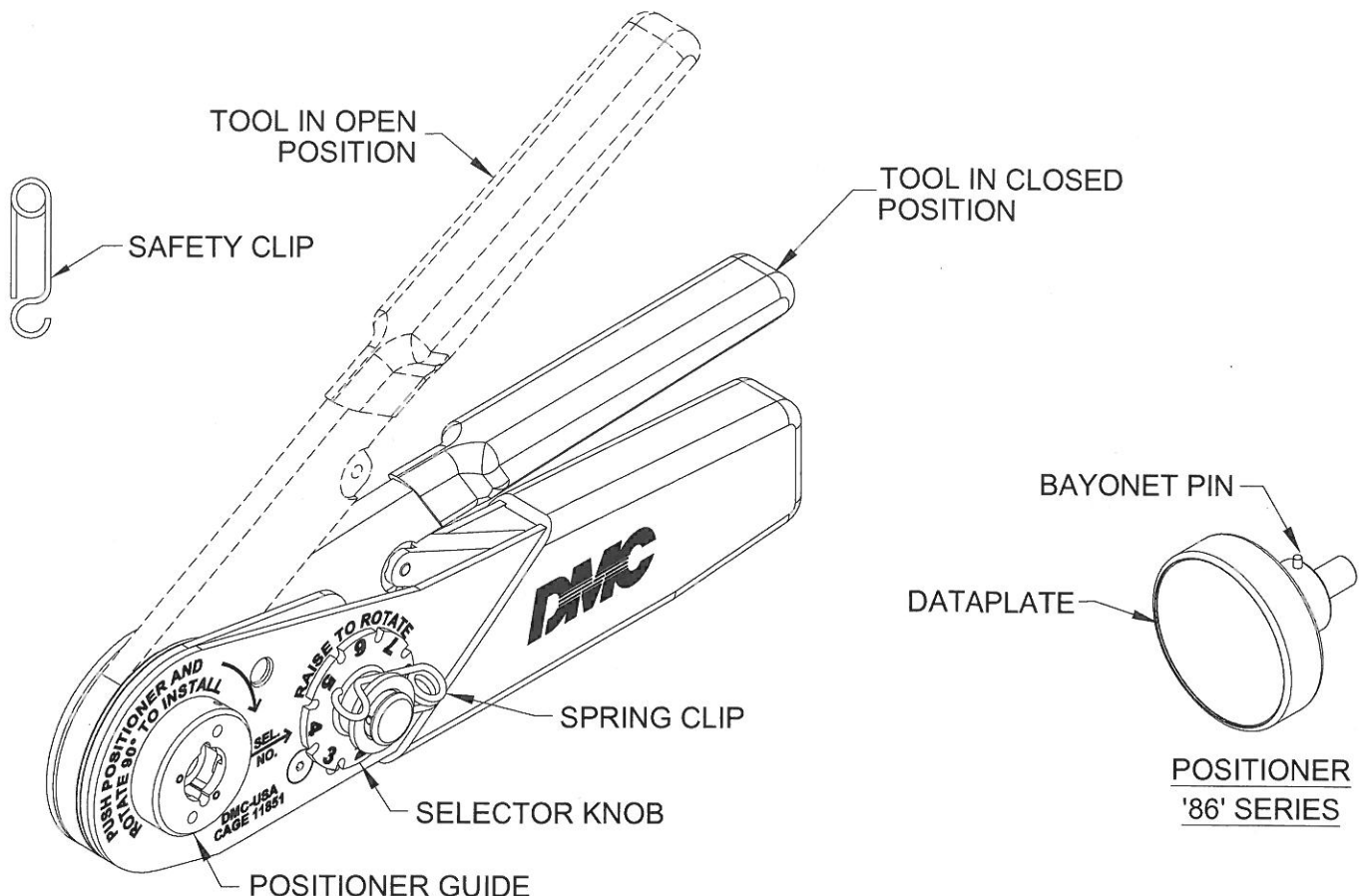
1. Tool must be in open position.
2. Remove safety clip from positioner guide.
3. Select correct positioner for contact to be crimped.
4. Insert positioner into positioner guide. Push down and turn 90 degrees until bayonet pins lock.
5. Wire size and corresponding selector numbers are shown on the dataplate.
6. With tool in open position, remove spring clip then raise and rotate selector knob until number indicated on dataplate wire size to be crimped is in line with the Sel. No. arrow.

CRIMPING INSTRUCTIONS:

1. Insert contact and prepared wire through the indenter opening into the positioner.
2. Squeeze handles together until ratchet releases. Handle will return to open position.

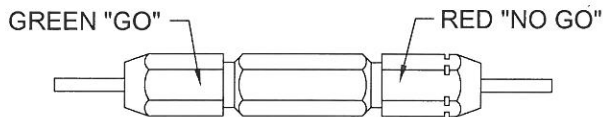
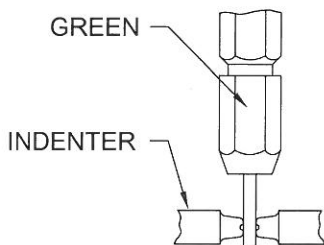
REMOVING POSITIONER:

1. Push down on positioner to release bayonet pins from positioner guide. Turn 90 degrees and remove from tool.



"GO" GAGING

Operate the tool to the fully closed position. Maintain firm hand pressure on the tool handles. Insert the "GO" gage end as shown. The gage must pass freely between the indenter tips.



GAGE: USE G145 (M22520/3-3) ON SEL #8

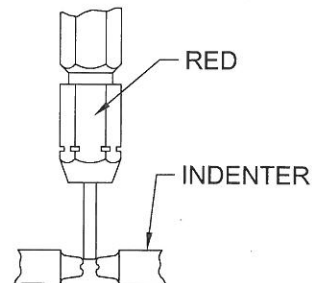
GAGING INSTRUCTIONS

GAGING LIMITS

SEL NO	INSPECTION GAGE	
	Ø GO ±.0001	Ø NO-GO ±.0001
1	.0160	.0210
2	.0190	.0240
3	.0220	.0270
4	.0250	.0300
5	.0290	.0340
6	.0330	.0380
7	.0370	.0420
8	.0410	.0460

"NO-GO" GAGING

Operate the tool to the fully closed position. Maintain firm hand pressure on the tool handles. Try to insert the "NO-GO" gage end as shown. The "NO-GO" gage may partially enter the indenter opening, but must not pass completely through.



CAUTION!
DO NOT CRIMP GAGE !!

CARE OF TOOL

There is virtually no maintenance required. However, it's good practice to keep indenter tips free of residual deposits and other debris. A small wire brush may be used for this purpose.

We strongly recommend that you:

1. DO NOT immerse tools in cleaning solution.
2. DO NOT spray oil into tool to lubricate.
3. DO NOT attempt to disassemble tool or make repairs.

This is a precision hand crimp tool and should handled as such.

DMC offers complete refurbishing and recalibrating services.

DMC specially engineers and manufactures complete tool kits to satisfy individual customer requirements, such as total aircraft support, general shop maintenance or production, on board ship and vehicle service, etc.

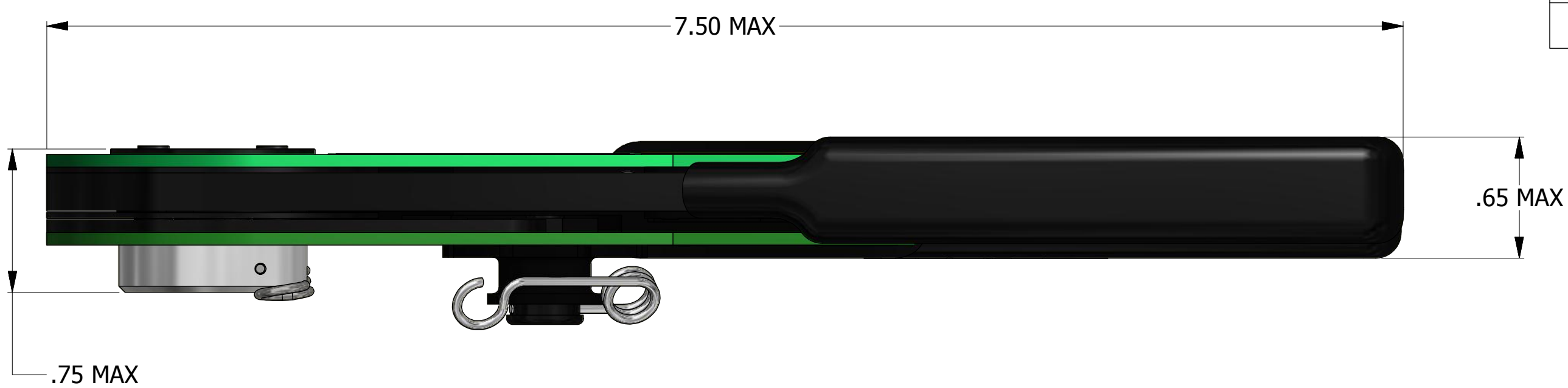
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LIMITED WARRANTY

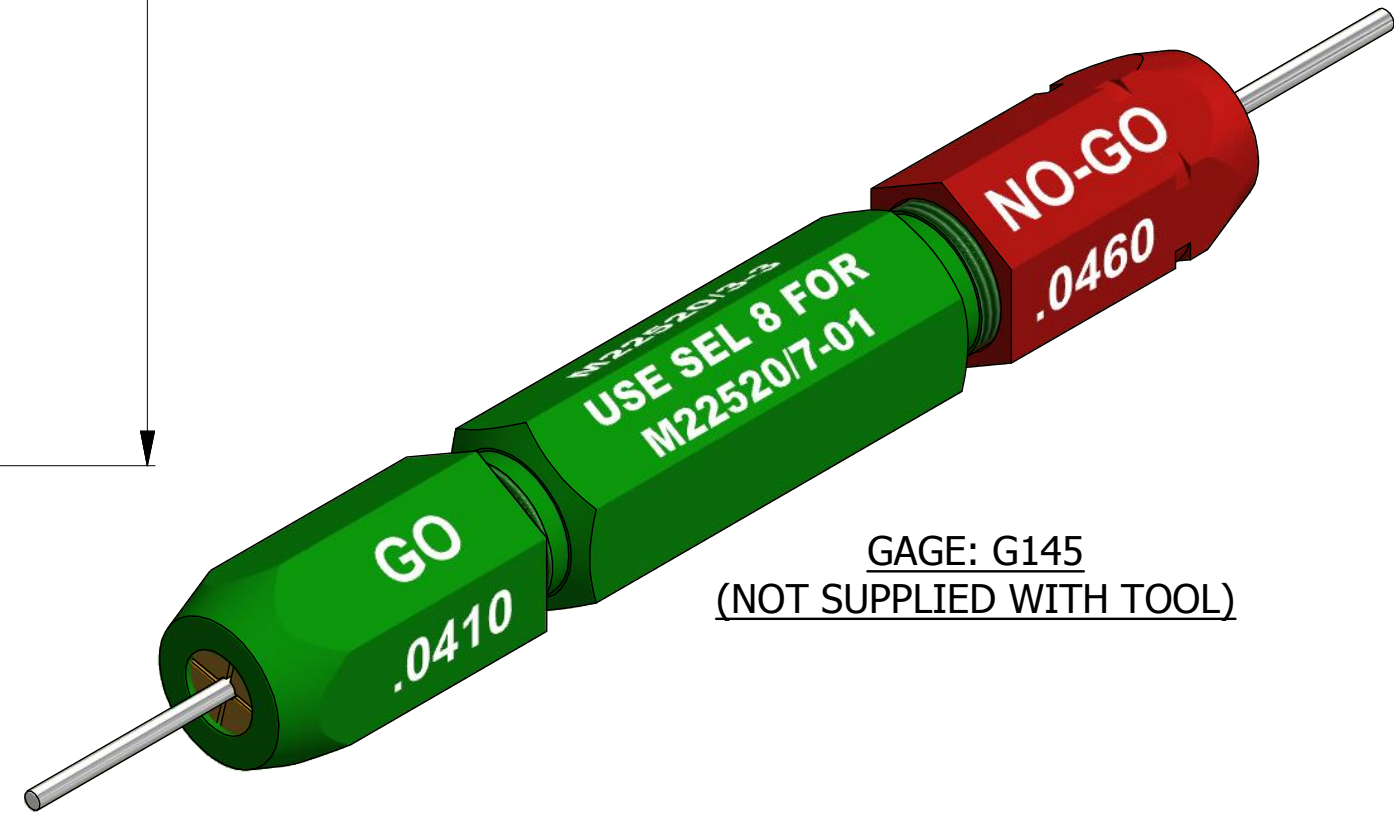
DMC (Daniels Manufacturing Corporation) warrants each new product sold by it to be free from defects in material and workmanship under normal use and service. DMC's obligation under this warranty is limited to the free correction or, at DMC's option, the refund of the purchase price of any such product which proves defective in normal service within ninety (90) days after delivery to the first user, provided that the product is returned to DMC with all transportation charges prepaid and which shall appear to DMC's satisfaction, after DMC's inspection, to have been defective in material or workmanship, it being understood that DMC products are not consumer products. This warranty shall not cover any damage to any products which, in the opinion of DMC, was caused by normal wear, misuse, improper operation, tampering, neglect or accident. This warranty is in lieu of all other warranties express or implied. No warranty, express or implied, is made or authorized to be made or assumed with respect to products of Daniels Manufacturing Corporation other than those herein set forth.

REVISIONS						
REV	ECO NO.	DESCRIPTION	BY	DATE	APP'D BY	DATE
4		ADDED NOTE 1	JWJ	7/24/2007	RRR	7/24/2007
5	23612	UPDATED AND ADDED GAGE	TonyD	11/28/2014		
6	24190	"(NOT SUPPLIED WITH TOOL)" ADDED TO GAGE	TonyD	3/8/2016		



GAGING LIMITS OF INDENTERS		
SEL NO	INSPECTION GAGE	
	Ø GO ±.0001	Ø NO-GO ±.0001
1	.0160	.0210
2	.0190	.0240
3	.0220	.0270
4	.0250	.0300
5	.0290	.0340
6	.0330	.0380
7	.0370	.0420
8	.0410	.0460

CHECK WITH GAGE: G145 SEL #8



GAGE: G145
(NOT SUPPLIED WITH TOOL)

**UNCONTROLLED DOCUMENT
WILL NOT BE UPDATED**
DIMENSIONS IN INCHES - UNLESS OTHERWISE SPECIFIED

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CREATED FROM AN INVENTOR MODEL. CHANGES MUST BE REFLECTED IN THE 3D PART
DO NOT SCALE DRAWING

MATERIAL	ITEM	PART NO.	QTY.	DESCRIPTION / REMARKS
N/A	DRN. DH CHK'D. MGS	DATE 3/28/1988 DATE 9/23/1986		DMC DANIELS MANUFACTURING CORP. ORLANDO, FLORIDA CAGE 11851
HEAT TREAT	NOTE: THIS DRAWING IS AN OUTLINE DRAWING OF THE RESPECTIVE DMC PART NUMBER INDICATED. ACTUAL DMC PART NUMBER IS CAD PART NUMBER WITHOUT THE "-ENV" SUFFIX		TITLE CRIMP TOOL M22520/7-01 ENVELOPE DRAWING	
FINISH	WHERE USED:	SIZE C	SCALE 1.75X	CAD P/N MH860-ENV DWG. NO. MH860
				SHEET 1 OF 1 REV. 6