

# M22520/37-01 (GMT232) CRIMP TOOL



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

SEE PAGE 4 FOR IMPORTANT INFORMATION CONCERNING  
LIMITED WARRANTY, AND LIMITATION OF LIABILITY.

## SPECIFICATIONS

1. The GMT232 Crimp Tool is designed to terminate wire splices conforming to MIL-S-81824 of the following sizes:

TOOL CAVITY	12-16		16-20		20-26	
CRIMP SPLICE SIZE	I.D.	O.D.	I.D.	O.D.	I.D.	O.D.
	.105	.155	.070	.107	.053	.080
	.095	.146	.063	.100	.045	.075

2. A properly calibrated GMT232 Crimp Tool has the following characteristics:

A. Ratchet adjustment (set at the factory):

A compression force of 40 lb minimum applied 1.25±.125 inches from the end of the handles shall be required to completely close jaws before the ratchet mechanism releases the handles.

- B. Jaw Closing: With the jaws fully closed, a "Go" gage shall fit in the space between the indenter and its corresponding cavity. A "No-Go" gage shall not fit in this space. Gage sizes are as follows:

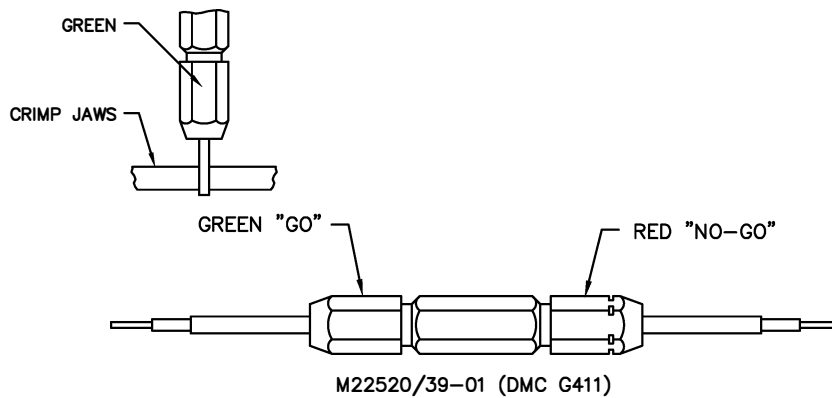
TOOL CAVITY	"GO" DIA.	"NO-GO" DIA.
12-16	.0620	.0720
16-20	.0420	.0520
20-26	.0250	.0350

The M22520/39-01 (Daniels G411) Go/No-Go gage is recommended for this purpose.

## GAGING INSTRUCTIONS

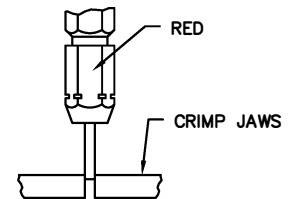
### "GO" GAGING

Operate tool to fully closed position. Insert "GO" gage end as shown. Gage must pass freely between jaw halves.



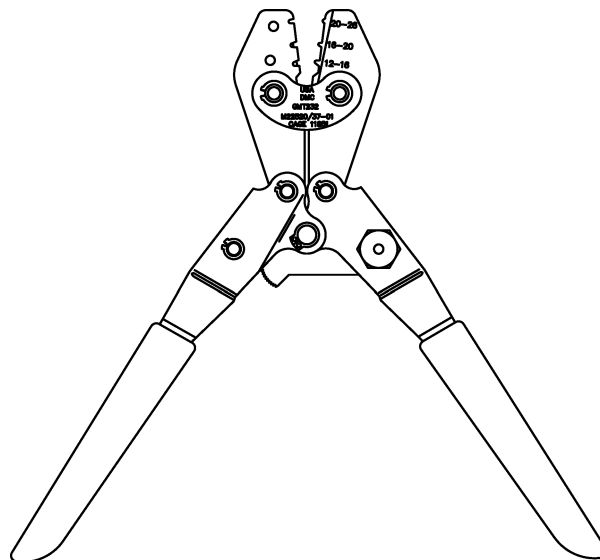
### "NO-GO" GAGING

Operate tool to fully closed position. Insert "NO GO" gage end as shown. The "NO GO" may partially enter the opening, but must not pass completely through the opening.



CAUTION!  
DO NOT CRIMP GAGE!

3. Ratchet is secured to prevent unauthorized adjustment.
4. This tool is not equipped with an early release mechanism.



### DAILY MAINTENANCE

A properly crimped terminal is controlled by the following maintenance and inspection procedures.

- A. Clean all dust, dirt, moisture and other foreign matter from the crimp jaws that could damage the crimp area of the dies.
- B. The pivot pin and ratchet pawl bearing surface should be lubricated to ensure a smooth operation.
- C. When storing the tool, close the handles until the ratchet pawl is about to be released from the last tooth of the ratchet. This will help prevent the dies from being damaged.

### PERIODIC INSPECTION PROCEDURE

Visual inspections should be performed on the tool based on the amount of use, working conditions and operator skill and care.

- A. Clean tool die area with solvent or brush.
- B. Check crimp area of dies for damage.
- C. If tool jams or locks, check the ratchet for dirt and lubrication.

### CARE OF TOOL

It is a good practice to keep crimp jaw tips free of residual color band deposits and other debris. A small wire brush may be used for this purpose.

We strongly recommend that you:

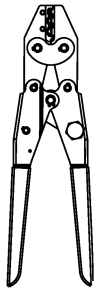
- 1. DO NOT immerse tools in cleaning solution.
- 2. DO NOT spray oil into tool to lubricate except as noted in Section B under Daily Maintenance.
- 3. DO NOT attempt to disassemble tool or make repairs.

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

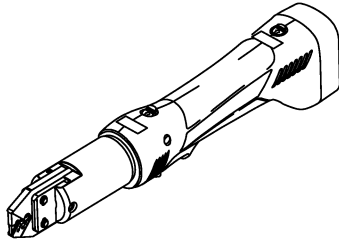
DMC offers complete refurbishing and recalibration services.

DMC 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.

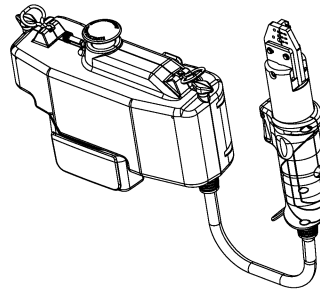
**GMT232 Tool Configuration Options**



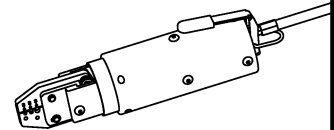
**GMT232  
Hand Tool**



**GMTEB232  
Battery Tool**



**GMTE232-R  
Remote-Head  
Battery Tool**



**PMT232  
Pneumatic  
Tool**

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