

Miniature Adjustable Crimp Tool 612596 (MS3198-1)

- 8 indent crimp
- Dial selectable
- Uses bayonet-style positioners
- Cycle controlled

The **Astro 612596** meets performance requirements for MS3198-1 and M22520/34-01. This lightweight compact tool uses MS3198, M22520/34, M22520/2 and proprietary bayonet-style positioners to crimp most pin and socket contacts smaller than size 20 to wires size 20 AWG and smaller.

The **612596** is step-adjustable to eight preselected crimp depths. The correct crimp depth is determined by using the data plate located on each positioner. This tool utilizes the same positive ratchet found on other Astro crimpers, which requires the completion of a crimp cycle before the handles will return to their open position. This feature ensures the integrity of every crimp.

Astro recommends the periodic gaging of all its crimping tools. For this purpose Astro offers the M22520/3-1 (615716) gage with the tool in the number 8 selector position. For use on M22520/34-01 applications Astro recommends using the M22520/35 (621064) gage with the crimp depth selector set on the number 6 setting.



For contacts not listed, please consult factory for proper tooling.

Contacts for Connector Families: MIL-C-26482 Series II, MIL-C-81703 Series III, MIL-C-83723 Series III, MIL-C-83733

Military Part #	BIN Code	Supersedes Military Part #	Style: Pin or Socket	Mating End Size	Wire Barrel Size	Positioner/Turret Part #	Astro Positioner #
M39029/4-110	110	M83723-33B20 M39029/4-20-20	PIN	20	20		
M39029/5-115	115	M83723-34B20 M39029/5-20-20	SKT	20	20	M22520/2-02	615718
M39029/9-132 THRU M39029/9-136	132 THRU 136	M39029/9-20-20C1 THRU M39029/9-20-20C5	PIN	20	20	MS3198-1P MS3198-1PA	612759 613382
M39029/10-138 THRU M39029/10-142	138 THRU 142	M39029/9-20-20C1 THRU M39029/10-20-20C5	SKT	20	20		

Contacts for Connector Family: MIL-C-28840

Military Part #	BIN Code	Supersedes Military Part #	Style: Pin or Socket	Mating End Size	Wire Barrel Size	Positioner/Turret Part #	Astro Positioner #
M39029/83-450	450	M39029/83-20-22	PIN	20	22	M22520/34-02	620636
M39029/83-451	451	M39029/83-20-28	PIN	20	28	M22520/34-02	620636
M39029/84-452	452	M39029/84-20-22	SKT	20	22	M22520/34-02	620636
M39029/64-453	453	M39029/84-20-28	SKT	20	28	M22520/34-02	620636

Contacts for Connector Family: MIL-C-21097

Military Part #	BIN Code	Supersedes Military Part #	Style: Pin or Socket	Mating End Size	Wire Barrel Size	Positioner/Turret Part #	Astro Positioner #
M39029/9-01	--	----	SKT	20	20	MS3196-4P	613023



612596 (MS3198-1) Positioner Selection Charts

Contacts for Connector Families: MIL-C-38999 Series I, II, III, IV, MIL-C-83733, MIL-C-24308 & MIL-C-55302/68/69/71/72/75							
Military Part #	BIN Code	Supersedes Military Part #	Style: Pin or Socket	Mating End Size	Wire Barrel Size	Positioner/Turret Part #	Astro Positioner #
M39029/58-360	360	MS27494-22D MS27493-22D M24308/13-1	PIN	22	22D	M22520/2-09	615725
M39029/58-361	361	MS27494-22M MS27493-22M	PIN	22	22M	MS3196-8P	613642
M39029/58-362	362	MS27494-22 MS27493-22	PIN	22	22		
M39029/57-354	354	MS27492-22D MS27491-22D M24308/12-1	SKT	22	22D	M22520/2-06	615722
M39029/57-355	355	MS27492-22M MS27491-22M	SKT	22	22M	MS3196-6P	613640
M39029/58-363	363	MS27494-20 MS27493-20	PIN	20	20	M22520/2-10 MS3196-9P	615726 613643
M39029/57-357	357	MS27492-20 MS27491-20	SKT	20	20	M22520/2-10 MS3196-9P	615726 613643

Contacts for Connector Family: MIL-C-38999 Series I, III, IV							
Military Part #	BIN Code	Supersedes Military Part #	Style: Pin or Socket	Mating End Size	Wire Barrel Size	Positioner/Turret Part #	Astro Positioner #
M39029/56-349	349	MS27490-22M	SKT	22	22M	M22520/2-07	615723
M39029/56-350	350	MS27490-22	SKT	22	22	MS3198-7P	613641
M39029/56-351	351	MS27655-30 MS27490-20	SKT	20	20	M22520/2-10 MS3196-9P	615726 613643

Contacts for Connector Family: MIL-C-81511 Series I & II							
Military Part #	BIN Code	Supersedes Military Part #	Style: Pin or Socket	Mating End Size	Wire Barrel Size	Positioner/Turret Part #	Astro Positioner #
M39029/46-303	303	MS90460 A23-22	PIN	23	22	MS3196-2PA	613381
M39029/46-304	304	MS90460 B23-22	SKT	23	22		
M39029/47-313	313	MS90461 A23-22	PIN	23	22	MS3196-2P	612760
M39029/47-314	314	MS90461 B23-22	SKT	23	22		

Contacts for Connector Family: MIL-C-26500							
Military Part #	BIN Code	Supersedes Military Part #	Style: Pin or Socket	Mating End Size	Wire Barrel Size	Positioner/Turret Part #	Astro Positioner #
M39029/31-241	241	MS24254-20P	PIN	20	20	M22520/2-02 MS3196-1P, MS3196-1PA	615718 612759, 613382
M39029/32-260	260	MS24255-20S	SKT	20	20	M22520/2-02 MS3198-1P, MS3198-1PA	615718 612759, 613382

BIN (Basic identification number) code color bands, reading in sequence from wire barrel end of the contact. Each digit of the BIN code shall be designated on the contact by a color band in accordance with the following:

- 0-Black 2-Red 4-Yellow 6-Blue 8-Gray
1-Brown 3-Orange 5-Green 7-Violet 9-White

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