

DMC99 & ST825 SWAGING TOOL KIT & TOOL

The DMC **ST825** swaging tool is used to swage terminals to flexible aircraft cable. Made using heat-treated, hardened steel this tool offers extreme durability and portability. The tool and accessories meet military qualification and provide coverage of cables between 1/16" to 1/4" diameter. The tool consists of a cylinder and yoke assembly, an air hose assembly, and a foot control assembly. The air hose assembly features a shut off valve.



DMC99 Tool Kit
NSN: 5130-00-712-4855
GSA-FSS: GGG-S-00825A



All swaging and cutting dies are made in the USA from heat treated S-5 and A-2 steel and meet the requirements of the Trade Agreements Act. Each die is marked to indicate the type and size of the item to be swaged or cut.

This rugged tool weighs less than 20 pounds. It operates on standard shop air pressure and is designed for hand operation or can be mounted on a cushioned baseplate (Part # **ST825001**) for bench use. The tool features interchangeable die sets for cutting and swaging. All die sets are sold separately.

TOOL SPECIFICATIONS

- L x W x H: 20 x 5 x 3.38 (in) (with baseplate)
508 x 127 x 86 (mm)
- Weight: 19 lbs (8.61 kg)
- Range: 1/16" to 1/4" diameter MIL-W-83420, MIL-W-87161, and other specified wires
- Air: 90 psi (6.2 BAR)
- Connections: 3/8" I.D. hose
- Includes: Cylinder and yoke assembly, air hose assembly, foot control assembly with lubricator and air filter

The swaging tool can be purchased in a tool kit (Part # **DMC99**) which includes additional items such as a baseplate, gages, and cutting and swaging dies in a metal case. All dies and gages in this kit are listed on page 2.

TOOL KIT SPECIFICATIONS

- L x W x H: 25.25 x 12.75 x 7.25 (in)
641 x 324 x 184 (mm)
- Weight: 155 lbs (70.30 kg)



Cutting Die



Cutting Punch



Swaging Dies



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TYPICAL SWAGING APPLICATIONS



DMC99 TOOL KIT GAGES AND DIES

DMC PART NO.	TERMINAL REF. (MIL.#)	DESCRIPTION	CABLE DIA.	CROSS REF. ATI P/N
ST825	N/A	SWAGING TOOL	N/A	N/A
G689	N/A	GAGE SET	N/A	AT5205G
ST825003-1	N/A	SPACER	N/A	AT520SP-1
ST825SDB-2	MS20663-2	DOUBLE SHANK BALL END TERMINAL SWAGING DIE SET	1/16"	AT520CDB-2
ST825SDB-3	MS20663-3	DOUBLE SHANK BALL END TERMINAL SWAGING DIE SET	3/32"	AT520CDB-3
ST825SDB-4	MS20663-4	DOUBLE SHANK BALL END TERMINAL SWAGING DIE SET	1/8"	AT520CDB-4
ST825SDB-5	MS20663-5	DOUBLE SHANK BALL END TERMINAL SWAGING DIE SET	5/32"	AT520CDB-5
ST825SDB-6	MS20663-6	DOUBLE SHANK BALL END TERMINAL SWAGING DIE SET	3/16"	AT520CDB-6
ST825SSB-2	MS20664-2	SINGLE SHANK BALL END TERMINAL SWAGING DIE SET (L & R)	1/16"	AT520CSB-2
ST825SSB-3	MS20664-3	SINGLE SHANK BALL END TERMINAL SWAGING DIE SET (L & R)	3/32"	AT520CSB-3
ST825SSB-4	MS20664-4	SINGLE SHANK BALL END TERMINAL SWAGING DIE SET (L & R)	1/8"	AT520CSB-4
ST825SSB-5	MS20664-5	SINGLE SHANK BALL END TERMINAL SWAGING DIE SET (L & R)	5/32"	AT520CSB-5
ST825SSB-6	MS20664-6	SINGLE SHANK BALL END TERMINAL SWAGING DIE SET (L & R)	3/16"	AT520CSB-6
ST825SB-2	BA3-2	PLAIN BALL END SWAGING DIE	1/16"	AT520CB-2
ST825SB-3	BA3-3	PLAIN BALL END SWAGING DIE	3/32"	AT520CB-3
ST825SB-4	BA3-4	PLAIN BALL END SWAGING DIE	3/32"	AT520CB-4
ST825SL-2	*-2	SLEEVE TYPE TERMINALS SWAGING DIE	1/16"	AT520CS-2
ST825SL-3	*-3	SLEEVE TYPE TERMINALS SWAGING DIE	3/32"	AT520CS-3
ST825SL-4	*-4	SLEEVE TYPE TERMINALS SWAGING DIE	1/8"	AT520CS-4
ST825SL-5	*-5	SLEEVE TYPE TERMINALS SWAGING DIE	5/32"	AT520CS-5
ST825SL-6	*-6	SLEEVE TYPE TERMINALS SWAGING DIE	3/16"	AT520CS-6
ST825SL-7	*-7 (NOTE)	SLEEVE TYPE TERMINALS SWAGING DIE	7/32"	AT520CS-7
ST825SL-8	*-8	SLEEVE TYPE TERMINALS SWAGING DIE	1/4"	AT520CS-8
ST825CD-2-1	N/A	CUTTING DIE	1/16"	AT520CD-2
ST825CD-2-2	N/A	CUTTING PUNCH	1/16"	AT520CP-2
ST825CD-3-1	N/A	CUTTING DIE	3/32"	AT520CD-3
ST825CD-3-2	N/A	CUTTING PUNCH	3/32"	AT520CP-3
ST825CD-4-1	N/A	CUTTING DIE	1/8"	AT520CD-4
ST825CD-4-2	N/A	CUTTING PUNCH	1/8"	AT520CP-4
ST825CD-5-1	N/A	CUTTING DIE	5/32"	AT520CD-5
ST825CD-5-2	N/A	CUTTING PUNCH	5/32"	AT520CP-5
ST825CD-6-1	N/A	CUTTING DIE	3/16"	AT520CD-6
ST825CD-6-2	N/A	CUTTING PUNCH	3/16"	AT520CP-6
ST825CD-7-1	N/A	CUTTING DIE	7/32"	AT520CD-7
ST825CD-7-2	N/A	CUTTING PUNCH	7/32"	AT520CP-7
ST825CD-8-1	N/A	CUTTING DIE	1/4"	AT520CD-8
ST825CD-8-2	N/A	CUTTING PUNCH	1/4"	AT520CP-8

*MS20658, MS20667, MS21260, MS21259

(NOTE) Uses the ST825SL-6 die set for MS20658-7 terminal