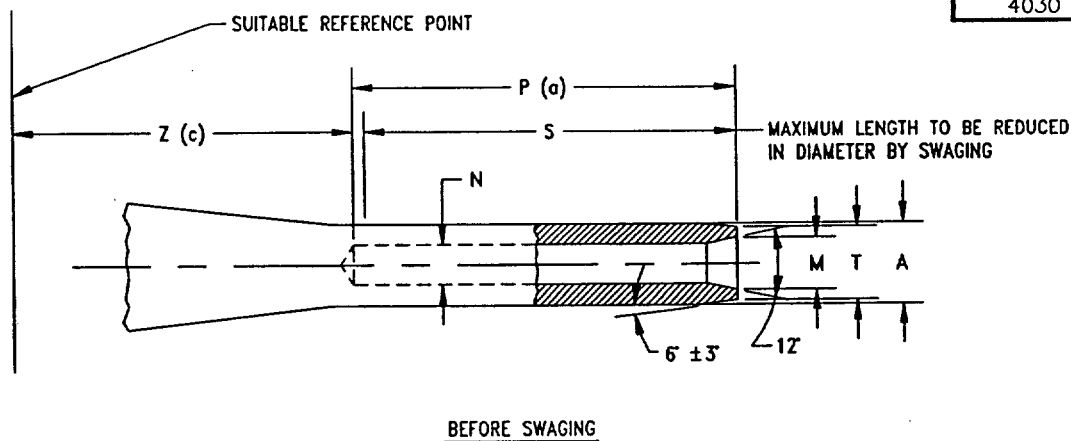


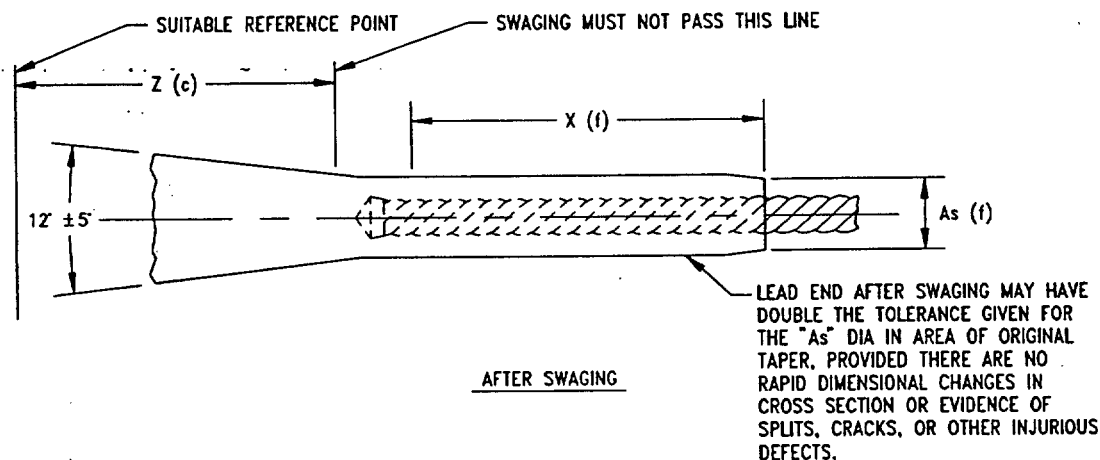
REVIEWER SYMBOLS:  
AIR FORCE-82

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NOTE: This drawing was approved by joint action of the Air Force and Navy Departments as the Air Force - Navy standard for this product. This drawing supersedes all antecedent standard drawings for the same product and shall become effective for the procurement of aeronautical supplies, or for use in new design not later than 6 months after the latest date of approval shown.  
AMSC N/A



BEFORE SWAGING



AFTER SWAGING

## REQUIREMENTS

- (a) BORE "P" MAY EXTEND THROUGH THE ENTIRE TERMINAL IF SO INDICATED ON THE TERMINAL DETAIL DRAWING
- (b) IN TERMINALS IN WHICH THE SWAGING OPERATION PRODUCES A LONGITUDINAL FIN OR PARTING LINE ON TWO DIAMETRICALLY OPPOSITE SIDES OF THE SWAGING PORTION, THE DIMENSIONS AS MEASURED ACROSS THE FIN OR PARTING LINES SHALL NOT EXCEED "As" BY MORE THAN .010 INCH
- (c) DIMENSION "Z" SHALL BE SPECIFIED ON ALL DETAIL DRAWINGS WHICH DO NOT PROVIDE A SHOULDER SWAGING STOP
- (d) SHANK "S" CABLE HOLE SHALL BE CONCENTRIC AND PARALLEL TO AXIS WITHIN "K" (2K FULL INDICATOR READING)
- (e) THESE LOADS ARE APPLICABLE WHEN TERMINALS ARE SWAGED ONTO CABLE CONFORMING TO MIL-W-83420
- (f) SWAGED TERMINALS WILL CONFORM TO "As" DIAMETER FOR LENGTH "X"; DIMENSION "X" SHALL BE SPECIFIED ON ALL DETAIL DRAWINGS
- (g) REMOVE ALL BURRS AND SHARP EDGES

## NOTES

- 1. DIMENSIONS IN INCHES
- 2. TERMINALS COVERED BY DRAWINGS MS21259, MS20667, MS20668, AND MS21260 SHALL BE USED WHENEVER POSSIBLE
- 3. THIS DRAWING IS FOR USE IN DESIGN OF SPECIAL TERMINALS OF CORROSION RESISTANT STEEL FOR USE ON AIRCRAFT AND APPLICATIONS WHERE MAXIMUM SAFETY AND MINIMUM WEIGHT ARE REQUIRED
- 4. SPECIAL TERMINALS INCORPORATING THE SWAGING TERMINAL SHANK SHALL BE MANUFACTURED IN ACCORDANCE WITH MIL-T-781

(4) DENOTES CHANGE

P.A.  
NAVY-AS  
CUSTODIANS:  
ARMY-AV  
AIR FORCE-99

PROCUREMENT SPECIFICATION  
MIL-T-781

AIR FORCE-NAVY AERONAUTICAL DESIGN STANDARD

TERMINAL SHANK-SWAGING, DIMENSIONS FOR

SUPERSEDES AND10081, REV 3

AND10081

SHEET 1 OF 2

APPROVED 11 MAY 45 REVISED 121 JUN 51 203 JUNE 59 302 AUG 65 415 NOV 93

FED. SUP. CLASS  
4030

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AMSC N/A

TABLE I. DIMENSIONS

TERMINAL DIMENSIONS										
(e) NOMINAL CABLE DIAMETER REF		BEFORE SWAGING					AFTER SWAGING			
		A DIAMETER	(d) K	M DIAMETER	N DIAMETER	(c) P DRILL DEPTH	S +.062 - .000	T DIAMETER	(b) AS DIAMETER	(f) X MIN
(4)	.063	.160	.008	.090	.078	1.042	.969	.138	.138	.700
	.094	.218		.119	.109	1.261	1.188	.190	.190	.800
	.125	.250		.154	.141	1.511	1.438	.219	.219	1.050
	.156	.297		.188	.172	1.761	1.688	.250	.250	1.290
	.188	.359		.223	.203	2.011	1.938	.313	.313	1.310
	.219	.427		.257	.234	2.261	2.188	.375	.375	1.550
	.250	.494		.291	.265	2.511	2.438	.438	.438	1.700
	.281	.563		.326	.297	2.761	2.688	.500	.500	1.890
	.313	.635		.360	.328	3.011	2.938	.563	.563	2.060
	.375	.703		.430	.390	3.511	3.438	.625	.625	3.120
	.438	.781		.514	.468	4.011	3.938	.688	.688	3.570
	.500	.844		.584	.531	4.698	4.625	.750	.750	4.310
	.563	.984		.653	.594	5.011	4.938	.875	.875	4.510
	.625	1.109		.722	.656	5.511	5.438	1.000	1.000	5.040
	.750	1.359		.860	.781	6.511	6.438	1.250	1.250	5.800
	.875	1.593		1.013	.921	7.166	7.094	1.437	1.437	6.310
1.000	1.812	1.151	1.046	8.229	8.156	1.625	1.625	7.260		
1.125	2.000	1.289	1.171	9.135	9.062	1.812	1.812	7.610		
1.250	2.218	1.443	1.312	10.198	10.125	2.000	2.000	8.450		
1.375	2.500	1.581	1.437	11.229	11.156	2.250	2.250	9.200		
1.500	2.750	1.720	1.562	12.135	12.062	2.500	2.500	10.090		

TABLE II. CABLE/ROPE PARTICULARS

(4) NOMINAL DIAMETER	7 X 19							6 X 19						
	.063	.094	.125	.156	.188	.219	.250	.281	.313	.375	.438	.500	.562	.625
PREFORMED STEEL CABLE OR WIRE ROPE	7 X 7							INDEPENDENT WIRE ROPE CENTER						
STANDARDS BY WIRES/STRANDS CENTERS OR CORES	STEEL STRAND							CORROSION RESISTANT, ZINC COATED OR TINNED STEEL						
MATERIAL														

P.A.  
NAVY-AS  
CUSTODIANS:  
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AIR FORCE-NAVY AERONAUTICAL DESIGN STANDARD

TERMINAL SHANK SWAGING, DIMENSIONS FOR

SUPERSEDES AND10081, REV 3

AND10081

SHEET 2 OF 2

APPROVED 11 MAY 45REVISED ④ SEE SHEET 1