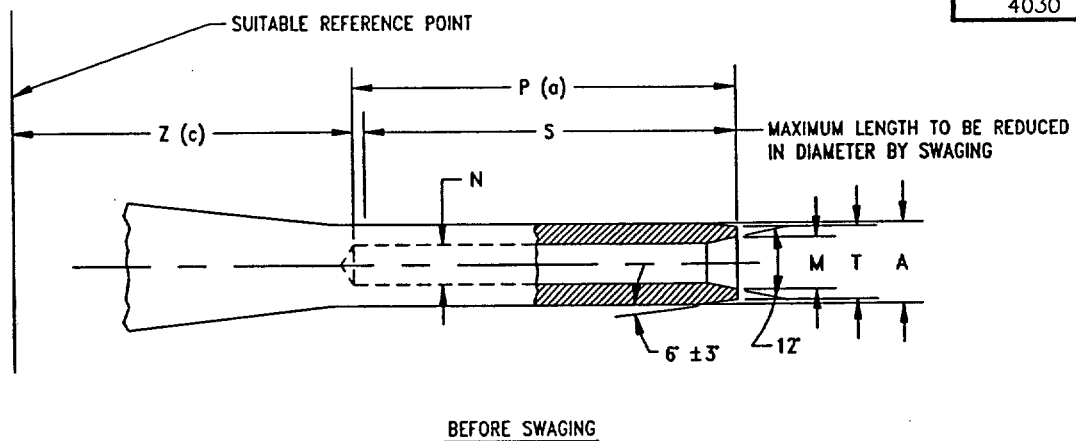


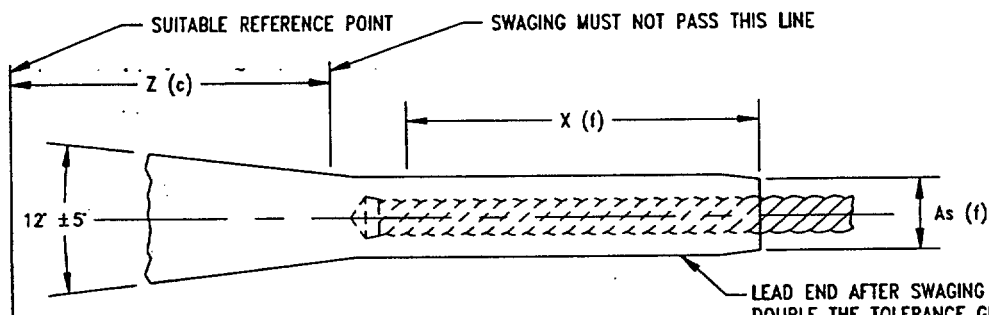
REVIEWER SYMBOLS:
AIR FORCE-82

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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 be 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 FINNS 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)
- (4) (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 CUSTOMIANS: ARMY-AV AIR FORCE-99 PROCUREMENT SPECIFICATION MIL-T-781	AIR FORCE-NAVY AERONAUTICAL DESIGN STANDARD	AND10081
	TERMINAL SHANK-SWAGING, DIMENSIONS FOR	
	SUPERSEDES AND10081, REV 3	SHEET 1 OF 2

APPROVED 11 MAY 45 REVISED 1 JUN 51 2 JUN 59 3 JUNE 59 4 AUG 65 5 NOV 93

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AMSC N/A

TABLE I. DIMENSIONS

NOMINAL CABLE DIAMETER REF	(e) MINIMUM ALLOWABLE BREAKING STRENGTH LB REF	TERMINAL DIMENSIONS						AFTER SWAGING		
		A DIAMETER	(d) K	M DIAMETER	N DIAMETER	(o) P DRILL DEPTH	S +.062 -0.00	T DIAMETER	(b) AS DIAMETER	(f) X MIN
.063	480	.160		.090	.078	1.042	.969	.138	.138	.700
.094	920	.218		.119	.109	1.261	1.188	.190	.190	.800
.125	2,000	.250		.154	.141	1.511	1.438	.219	.219	1.050
.156	2,800	.297		.188	.172	1.761	1.688	.250	.250	1.290
.188	4,200	.359	.008	.223	.203	2.011	1.938	.313	.313	1.310
.219	5,600	.427		.257	.234	2.261	2.188	.375	.375	1.550
.250	7,000	.494		.291	.265	2.511	2.438	.438	.438	1.700
.281	8,000	.563	+0.00	.326	.297	2.761	2.688	.500	.500	1.890
.313	9,800	.635	-0.05	.360	.328	3.011	2.938	.563	.563	2.060
.375	14,400	.703		.430	.390	3.511	3.438	.625	.625	3.120
.438	17,600	.781	.010	.514	.468	4.011	3.938	.688	.688	3.570
.500	22,800	.844		.584	.531	4.698	4.625	.750	.750	4.310
.563	28,500	.984		.653	.594	5.011	4.938	.875	.875	4.510
.625	35,000	1.109	.015	.722	.656	5.511	5.438	1.000	1.000	5.040
.750	49,600	1.359		.860	.781	6.511	6.438	1.250	1.250	5.800
.875	66,500	1.593		1.013	.921	7.166	7.094	1.437	1.437	6.310
1.000	85,400	1.812		1.151	1.046	8.229	8.156	1.625	1.625	7.260
1.125	106,400	2.000		1.289	1.171	9.135	9.062	1.812	1.812	7.610
1.250	129,400	2.218	+0.00	1.443	1.312	10.198	10.125	2.000	2.000	8.450
1.375	153,600	2.500	-0.10	1.581	1.437	11.229	11.156	2.250	2.250	9.200
1.500	180,500	2.750		1.720	1.562	12.135	12.062	2.500	2.500	10.090

TABLE II. CABLE/ROPE PARTICULARS

PREFORMED STEEL CABLE OR WIRE ROPE	NOMINAL DIAMETER	7 X 19										6 X 19									
		.063	.094	.125	.156	.188	.219	.250	.281	.313	.375	.438	.500	.562	.625	.750	.875	1.000	1.125	1.250	1.375
STANDARDS BY WIRES/STRANDS	7 X 7																				
CENTERS OR CORES		STEEL STRAND																			
MATERIAL		CORROSION RESISTANT, ZINC COATED OR TINNED STEEL																			
		INDEPENDENT WIRE ROPE CENTER																			

P.A. NAVY-AS
CUSTOMERS:
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 2 OF 2

APPROVED 11 MAY 45 REVISED 4 SEE SHEET 1