

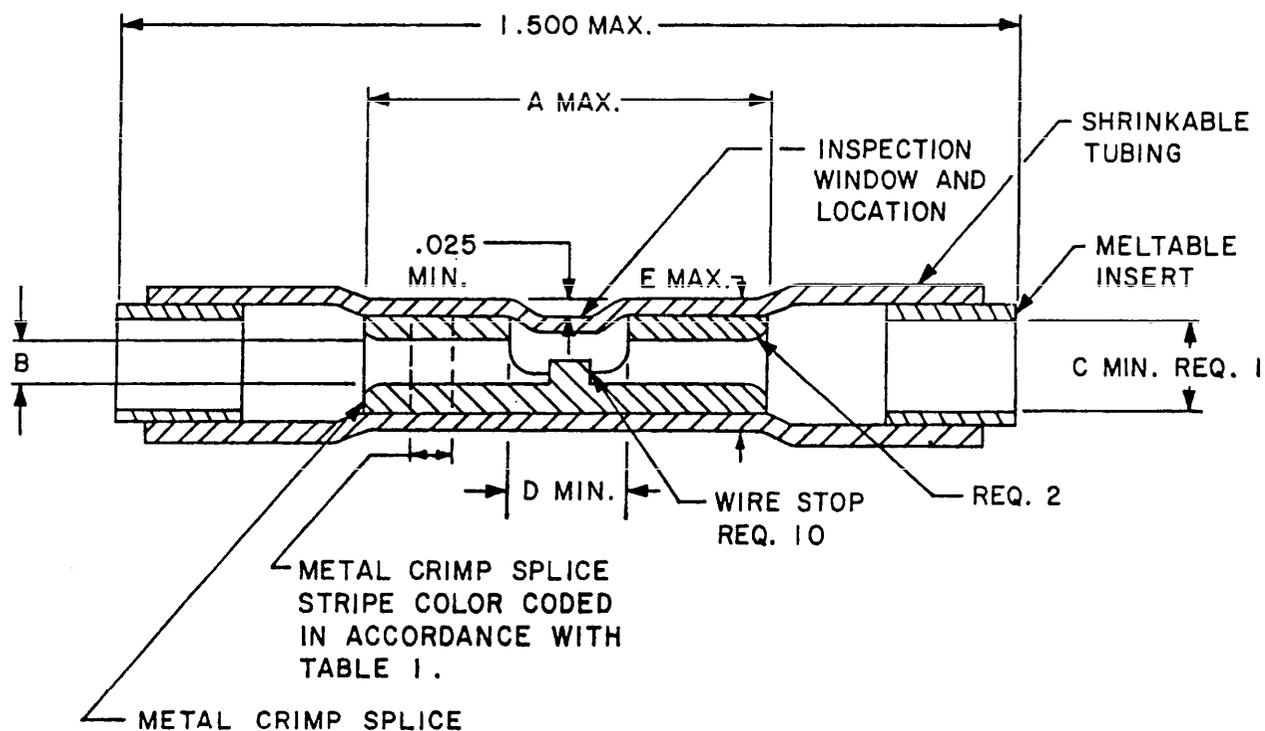
MIL-S-81824/2A
 24 October 1980
 Superseding
 MIL-S-81824/2
 22 June 1979

MILITARY SPECIFICATION SHEET

SPLICE, ELECTRIC, PERMANENT, CRIMP STYLE COPPER,
 INSULATED, ONE-PIECE, ENVIRONMENT RESISTANT, CLASS 1

This specification is approved for use by all Departments
 and agencies of the Department of Defense.

The complete requirements for procuring the splice,
 described herein shall consist of this document
 and the latest issue of MIL-S-81824.



FSC 5940

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TABLE I.

DASH NO.	WIRE RANGE	A MAX.	B	C MIN.	D MIN.	E MAX.	WEIGHT PER 1,000 (POUNDS)	COLOR CODE
-1	26-24-22-20	.515	.055 .043	.085	.120	.160	15.0	Red
-2	20-18-16	.590	.075 .060	.110	.130	.190	24.0	Blue
-3	16-14-12	.590	.110 .090	.170	.135	.230	35.0	Yellow

METRIC TABLE

INCH	mm	INCH	mm	INCH	mm	INCH	mm
.025	0.64	.075	1.91	.120	3.05	.515	13.08
.040	1.02	.085	2.16	.130	3.30	.590	14.99
.055	1.40	.090	2.29	.140	3.56	1.125	28.58
.060	1.52	.110	2.79	.170	4.32		

REQUIREMENTS:

- .025 max. after unrestricted recovery through meltable material.
- Wire insertion shall be facilitated by Bell mouth.
- Material: Copper (See procurement specification, or copper alloy.)
- Insulation Sleeve: See procurement specification.
- Sealing material: Modified thermoplastic: See procurement specification.
- Finish: Metal, tin plated or silver plated: See procurement specification.
- Dimension B to be determined as the average of two diameters measured at right angles.
- The inspection window and locator shall provide a positive means of positioning splice in the applicable crimping tool and provide visible inspection of stripped wire ends.
- Part number: Consists of the letter "M", the basic number of this specification sheet, and a dash number taken from Table I. Example: M81824/2-1 Splice for 26-24 22-20 wire range.
- The wire stop must prevent wire entering opposing wire barrel.

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11. Qualification: For qualification testing, splices shall be tested with wire conforming to MIL-W-22759/11. For crimping tools use Table II. The applicable heat tool is to be used for shrinking the insulating sleeve after crimping to meet the performance requirements. See procurement specification.
12. No etching or solvent treating of the associated wire insulation shall be permitted.
13. Use only M83507/14-01 heat gun on fueled aircraft.

NOTES:

1. Dimensions are in inches.
2. Metric equivalents (to the nearest .01mm) are given for general information only and are based upon 1 inch = 25.4mm.

TABLE II. CRIMP TOOLS

Splice Part No.	Basic Crimp Tool No.	Die No.	Die Nest Color
M81824/2-1	M22520/5-01	M22520/5-101	White
	M22520/10-01	M22520/10-102	White
M81824/2-2	M22520/5-01	M22520/5-100	*White
	M22520/10-01	M22520/10-101	White
M81824/2-3	M22520/5-01	M22520/5-100	*White
	M22520/10-01	M22520/10-101	White

*For M22520/5-100 Dies use 26-14 Die Closure.

Custodians:

ARMY - ER
 NAVY - AS
 USAF - 85

Preparing Activity:

NAVY - AS
 (Project No. 5940-0896)

Review Activity:

ARMY - AV
 USAF - 11, 99
 DSA - GS

User Activity:

ARMY - MI
 NAVY - EC, MC, SH, OS

