

MIL-T-7928G
 AMENDMENT 1
 19 December 1980

MILITARY SPECIFICATION

TERMINALS, LUG: SPLICES, CONDUCTOR: CRIMP STYLE
 COPPER, GENERAL SPECIFICATION FOR

This amendment forms a part of Military Specification MIL-T-7928G, dated 25 August 1976, and is approved for use by all Departments and Agencies of the Department of Defense.

PAGE 1

Add the following: PPP-B-665 - Boxes, Paperboard, Metal Edged and Components.

PAGE 2

Delete the following: MIL-B-43014 - Boxes, Water-Resistant Paperboard, Folding, Set-Up and Metal Stayed.

Delete FED-STD-356 - Commercial Packaging of Supplies and Equipment.

Add the following: MIL-STD-454 - Standard General Requirements for Electronic Equipment.

Add the following: MIL-STD-1188 - Commercial Packaging of Supplies and Equipment.

PAGE 4

Add to Table I Clearance hole (reference)

INCH	mm	INCH	mm	INCH	mm
.086	2.18	.190	4.83	.437	11.10
.090	2.29	.193	4.90	.448	11.38
.098	2.49	.203	5.16	.463	11.76
.112	2.84	.216	5.49	.500	12.70
.114	2.90	.220	5.59	.510	12.95
.122	3.10	.236	5.99	.525	13.34
.125	3.18	.250	6.35	.625	15.88
.129	3.28	.260	6.60	.651	16.54
.137	3.48	.275	6.99	.666	16.92
.138	3.51	.312	7.92	.750	19.05
.142	3.61	.323	8.20	.770	19.56
.152	3.86	.338	8.59	.785	19.94
.164	4.17	.375	9.53	.875	22.23
.168	4.27	.385	9.78	.895	22.73
.178	4.52	.400	10.16	.910	23.11

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Metric equivalents (to the nearest .01 mm) are given for general information only and are based upon 1 inch - 25.4 mm.

Paragraph 3.5

Add an additional sentence, "The specified performance of the terminals and splices is premised on there being no nicked or broken strands of the conductor."

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Add the following sub-paragraph:

3.5.9.1 Heat aging (Type 1) after testing as specified in 4.7.10.3, lug terminals shall meet the requirements of 3.8.

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Add to Table VI Qualification inspection

Under Group VII

Add heat aging (175°C) Reg. paragraph 3.5.9.1 Method paragraph 4.7.10.3 add under sample units type I, 4 5/.

Add to Table VI notes - 5/ applicable to 175°C items only (see 3.1).

In table VI under sample units for group I type I change 22 to 26 and 12 3/ to 16 3/.

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Delete the following:

4.5.6 Retention of qualification. To retain qualification, the contractor shall forward a report at 12 month intervals to the qualifying activity. The qualifying activity shall establish the initial reporting date. The report shall consist of:

- a. A summary of the results of the tests performed for inspection of product for delivery, group A, indicating as a minimum the number of lots that have passed and the number that have failed. The results of tests of all reworked lots shall be identified and accounted for.
- b. A summary of the results of tests performed for periodic inspection, groups B and C, including the number and mode of failures. The summary shall include results of all group A quality conformance inspection performed and completed during the 12 month period. If the summary of

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the test results indicates nonconformance with specification requirements, and corrective action acceptable to the qualifying activity has not been taken, action may be taken to remove the failing product from the qualified products list.

Add the following:

4.5.6 Qualification by similarity. (Group I testing required) Qualification by similarity to qualified lug terminals and splices is permissible for those lug terminals and splices, Class 1 or Class 2, of the same type and wire size when the materials, design and manufacturing processes are identical except for tongue shapes or non-essential dimensions that differ due to the multiple stud sizes, various stud configurations or minor design considerations. When materials, design and manufacturing processes differ, sufficient testing to prove the adequacy of the affected characteristic may be required to obtain qualification by similarity. Full details of the similarities and differences, with proposed tests, if the submitter deems necessary, shall be submitted to the qualifying activity for approval prior to commencing testing.

Add the following:

4.5.7 Retention of Qualification. To retain qualification, the contractor shall forward reports to the qualifying activity every 12 months on the groups A and B tests, and every 36 months on the group C tests. The qualifying activity shall establish the initial reporting date. The reports shall consist of:

Add new sub-paragraphs a., b. and c. as follows:

a. (Group A tests every 12 months) A summary of the results of the test performed for inspection of product for delivery, group A, indicating as a minimum the number of lots that have passed and the number that failed. The results of tests of all reworked lots shall be identified and accounted for.

b. (Group B tests every 12 months) A summary of the results of the tests performed for periodic inspection, Group B, including the number and mode of failures. The summary shall include results of all group A quality conformance inspection performed and completed during the 12 month period. If the summary of the test results indicates non-conformance with specification requirements and corrective action acceptable to the qualifying activity has not been taken, action may be taken to remove the failing product from the qualified list.

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c. (Group C tests every 36 months) A summary of the results of the tests performed for periodic inspection, group C, including the number and mode of failures. If the summary of test results indicates non-conformance with specification requirements and corrective action acceptable to the qualifying activity has not been taken, action may be taken to remove the failing product from the qualified products list.

Add the following:

Failure to submit the report within 30 days after the end of each 12 month period may result in loss of qualification for the product. In addition to the periodic submission of inspection data, the contractor shall immediately notify the qualifying activity at any time during the 12 month period that the inspection data indicated failure of the qualified product to meet the requirements of this specification.

In the event that no production occurred during the reporting period, a report shall be submitted certifying that the company still has the capabilities and facilities necessary to produce the item. If during two consecutive reporting periods there has been no production, the manufacturer may be required, at the discretion of the qualifying activity, to submit a representative item of those covered by a single specification sheet or military standard to testing in accordance with the qualification inspection requirements.

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Add to Table IX Group C inspection

Under Group VI

Add heat aging (175°C) 4/ Reg. paragraph 3.5.9.1 Method paragraph 4.7.10.3 add under sample units type I, 4.

Add to Table IX notes - 4/ applicable to 175°C items only (see 3.1).

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4.7.8 Delete second sentence and substitute the following:

The speed of head travel of the tensile device shall be 1.0 ± 0.25 inch per minute.

Add a fourth sentence as follows:

The wired assemblies shall meet the requirements of 3.5.7.

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Add the following sub-paragraph

4.7.10.3 Heat aging (type I) 175°C temperature (see 3.5.9.1).
Uninsulated lug terminals attached to suitable wires shall be conditioned in a heat chamber at a temperature of $193^{\circ} \pm 5^{\circ}\text{C}$ for a period of 120 hours. After removal from the chamber, the specimens shall be cooled to a temperature of $23^{\circ} \pm 3^{\circ}\text{C}$ within a period of one hour. When cool, the specimens shall be subjected to the salt spray (corrosion) test (see 4.7.5).

Paragraph 5.1 Delete the word, "packaging", 2 places.

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Paragraph 5.1.1.3 Delete the word, "application".

Paragraph 5.1.2 Delete "Level C", and substitute "Commercial Packing".

Paragraph 5.2.3 Delete "Level C", and add "Commercial Packing". Delete the last sentence. Add to the first sentence "...in accordance with MIL-STD-1188 and applicable carrier rules and regulations."

Paragraph 5.4.3.1 - Delete the last sentence and substitute "Containers conforming to PPP-B-566, PPP-B-665, or PPP-B-676 shall be overwrapped with waterproof barrier materials (see 5.1.1.4 and 5.1.1.5)."

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Paragraph 5.4.3.3 Delete "FED-STD-356", and substitute "MIL-STD-1188".

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Paragraph 6.2 - Delete and renumber the paragraphs that follow.

Paragraph 6.3(c): Delete "(See 4.6.4)", and substitute "(See 5.4.3.3)".

Paragraph 6.4 Qualification - Delete the next to the last sentence and substitute "However, the Commanding Officer, Naval Avionics Center (Code 714), Indianapolis, Indiana 46218, has been designated agent for the Naval Air Systems Command to establish the QPL."

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6.7: Change "NUK" to "MIL".

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Custodians:

Army - ER
Navy - AS
Air Force - 85

Preparing activity:

Navy - AS
(Project No. 5940-0841)

Review Activities:

Army - AV, MI, AR, AT
Navy - SH, EC
Air Force - 99,11
DSA - GS

User Activities:

Army -
Navy - OS, MC
Air Force - 17