

MIL-STD-1130B
NOTICE 2
20 July 1983

MILITARY STANDARD
CONNECTIONS, ELECTRICAL
SOLDERLESS WRAPPED

TO ALL HOLDERS OF MIL-STD-1130B:

1. THE FOLLOWING PAGES OF MIL-STD-1130B HAVE BEEN REVISED AND SUPERSEDE THE PAGES LISTED:

NEW PAGE	DATE	SUPERSEDED PAGE	DATE
7	20 July 1983	7	12 December 1978
8	20 July 1983	8	12 December 1978

2. RETAIN THIS NOTICE AND INSERT BEFORE TABLE OF CONTENTS.

3. Holders of MIL-STD-1130B will verify that page changes and additions indicated above have been entered. This notice page will be retained as a check sheet. This issuance, together with appended pages, is a separate publication. Each notice is to be retained by stocking points until the Military Standard is completely revised or canceled.

Custodians:
Army - CR
Navy - EC
Air Force - 17

Preparing activity:
Navy - EC
(Project 5935-3319)

Review activities:
Army - AR
Navy - AS, SH
Air Force - 11, 85, 99
DLA - ES

User activities:
Army - MI
Navy - MC, CG
Air Force - 19

Agent:
DLA - ES

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5.2 Wrappost.

5.2.1 Wrappost geometry. Unless otherwise specified in the applicable procurement document, the wrappost shall be in accordance with figures 2 and 3, table I and table IA.

5.2.2 Material. Wrapposts material shall be as specified in the applicable connector specification.

5.2.3 Parallelism. See figure 2 and table IA.

5.2.4 Tip configuration. The tip of the wrappost shall terminate in a radius or bevel to facilitate insertion into the wrapping tool. If the tip of the wrappost terminates in a bevel, the apex of the bevel shall be flat, with no side of the flat exceeding .015 inch on a .025 inch square and .020 inch on a .045 inch square and .06 inch X .03 inch rectangle.

5.2.5 Plating. Wrappost shall be plated in accordance with one of the following:

5.2.5.1 Plating, gold. Gold plating shall be in accordance with MIL-G-45204, class 1, over nickel in accordance with QQ-N-290. Thickness of nickel plating shall be a minimum of 30 microinches.

5.2.5.2 Plating, tin-lead. Tin-lead plating shall be in accordance with MIL-P-81728 and shall have a tin composition of 50 to 95%. Tin-lead plating thickness shall be .0001 to .0003 inch thick.

5.2.5.3 Caution note. Silver underplating shall not be used in any case.

5.3 Solderless wrapped connection.

5.3.1 Process. Solderless wrapped connections shall be made with either hand or automatic wrapping tools capable of wrapping connections which conform to all requirements of this standard. The sequence of operations for making wrapped connections shall be as follows (see figure 4):

- a. Verify that the tool meets the requirements specified in 5.4.
- b. Insert the stripped wire into the feed slot (hands tools only).
- c. Bend insulated or bare wire into notch in tool to anchor (hand tools only).
- d. Place tool (large hole) over the wrappost.
- e. Rotate the tool spindle around the wrappost.
- f. Remove tool from wrappost.

5.3.1.1 Positioning of wire. Prior to wrapping, the wire shall be positioned radially so that subsequent routing of the unwrapped portion of the wire does not tend to unwrap the connection.

5.3.1.2 Torque. The wrappost shall withstand the following torque without permanent rotation or twisting relative to the mounting surface.

<u>Wrappost size</u>	<u>Minimum torque</u>
0.025 square	2.0 ounce - inches
0.045 square	8.0 ounce - inches
0.06 x 0.03	8.0 ounce - inches

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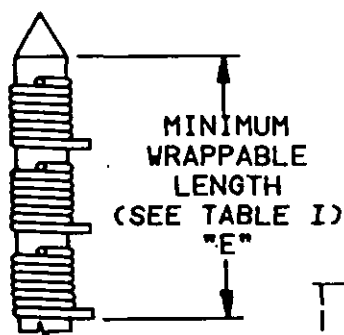


TABLE I. Minimum wrappable length, -E, inches 1/

Number of wrapped connections	Wire Gage						
	30	28	26	24	22	20	18
1	.185	.219	.226	.258	.303	.327	.391
2	.320	.388	.402	.466	.556	.604	.732
3	.455	.557	.578	.674	.809	.881	1.073

1/ Minimum wrappable length shall have the wrappost geometry in accordance with table IA.

FIGURE 2. Typical connection.

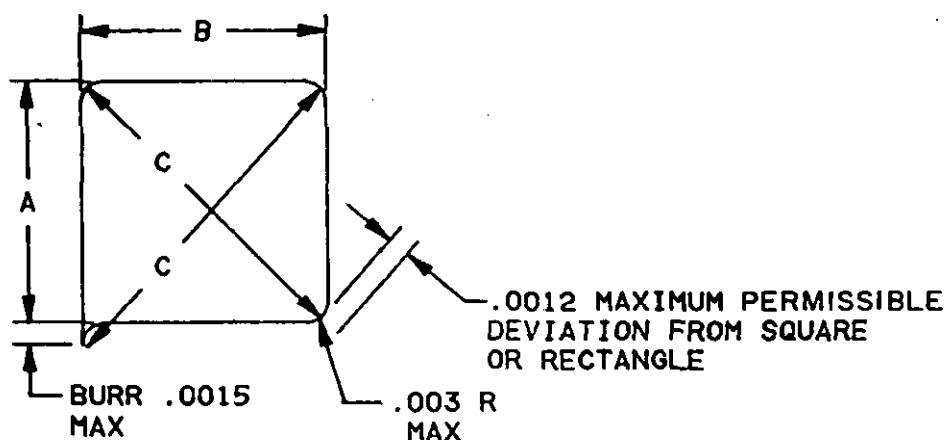


TABLE IA Wrappost geometry.

A	B	C	Parallelism	Straightness in./in.
.025 (nominal)	.025 (nominal)	.0355 Max.		
.022 Min.	.022 Min	.0325 Min.	.002	.005
.045 (nominal)	.045 (nominal)	.066 Max.		
.042 Min.	.042 Min	.059 Min.	.005	.005
.030 (nominal)	.060 (nominal)	.070 Max.		
.027 Min.	.057 Min	.063 Min.	.005	.005

FIGURE 3. Diagonal dimension.