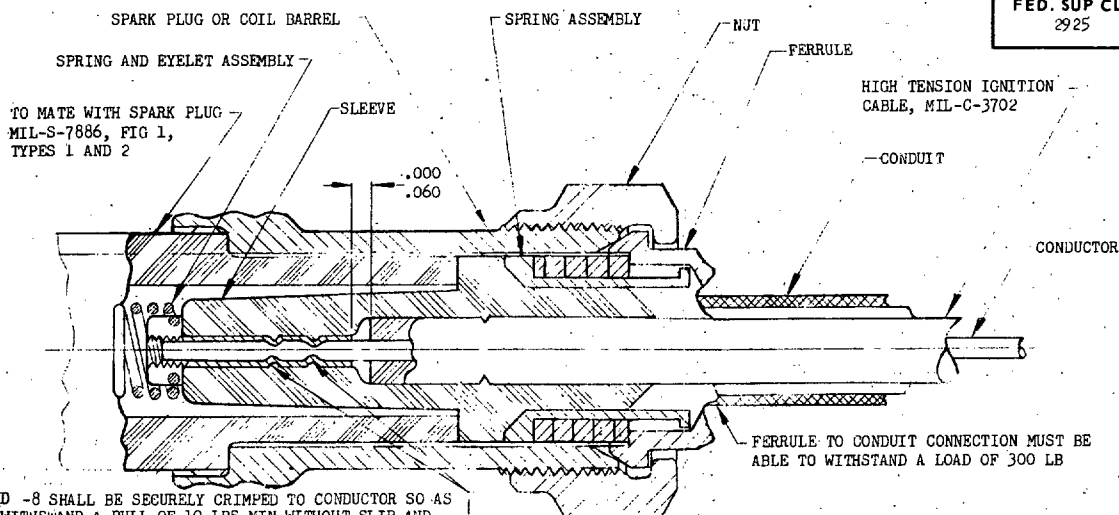
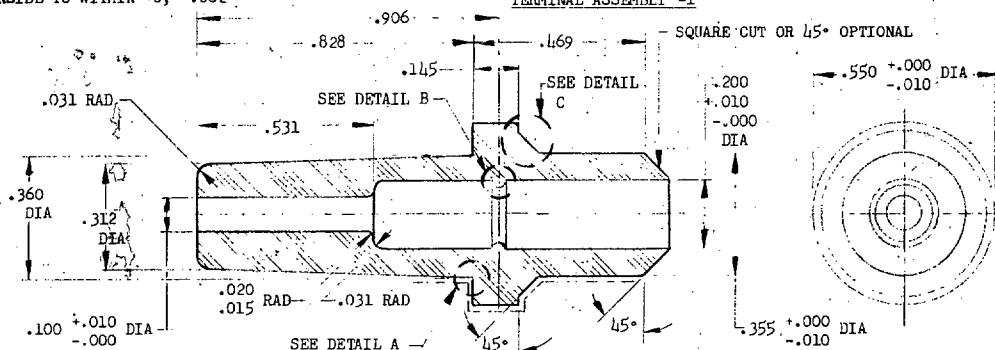


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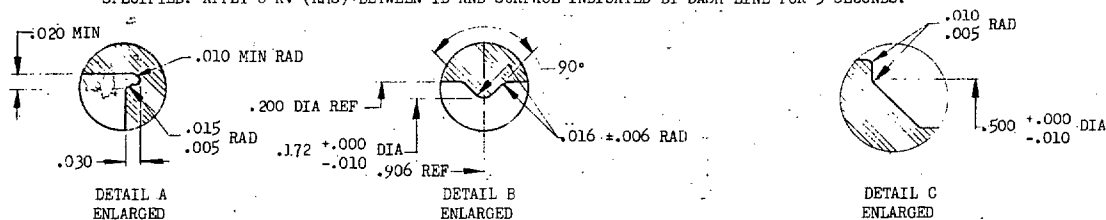
STUD -8 SHALL BE SECURELY CRIMPED TO CONDUCTOR SO AS TO WITHSTAND A PULL OF 10 LBS MIN WITHOUT SLIP AND WITHOUT DAMAGING WIRES. CONDUCTOR WIRES SHALL EXTEND THRU STUD AND BE VISIBLE AT OUTER END, BUT TERMINATE INSIDE TO WITHIN +0, -.062

## TERMINAL ASSEMBLY -1



## SLEEVE -4

MATERIAL: SILICONE RUBBER, MIL-R-5947, GR 80, CLASS II OR EQUIVALENT. ALL CORNERS TO BE .020 - .005 RADIUS UNLESS OTHERWISE SPECIFIED. APPLY 8 KV (RMS) BETWEEN ID AND SURFACE INDICATED BY DASH LINE FOR 5 SECONDS.



TERMINAL ASSEMBLY DASH NO.	SPRING ASSEMBLY (A) (a)	SLEEVE	SPRING AND EYELET ASSEMBLY	NUT	STUD
-1	-3	-4	-6	-7	-8
-2	NONE	-5	-6	-7	-8

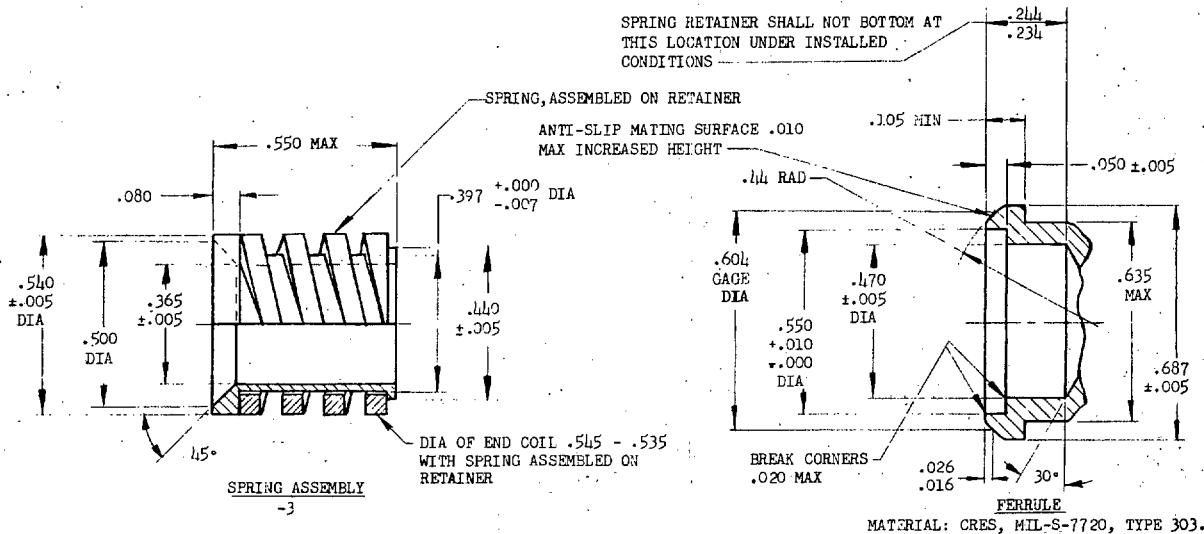
(A) (a) THE GOVERNMENT DOES NOT HAVE A ROYALTY FREE LICENSE UNDER U.S. PATENT 2,759,989 WHICH EXPIRES 21 AUGUST 1973.

DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS  $\pm .010$ , ANGLES  $\pm 2^\circ$ .

FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.  
REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID.

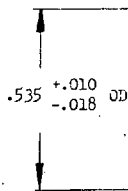
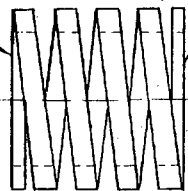
(A) FOR CHANGES SEE SHEET 1.

P.A. Navy - WP	TITLE	MILITARY STANDARD
Other Cust Army - MO USAF - 82	TERMINAL ASSEMBLY, SPARK PLUG, DETACHABLE IGNITION LEAD	MS21267
PROCUREMENT SPECIFICATION MIL-L-19844	SUPERSEDES: AN4164	SHEET 1 OF 3

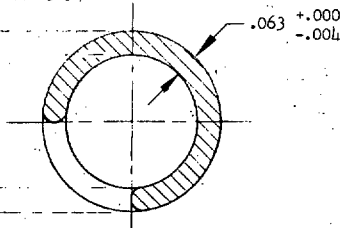
FED. SUP CLASS  
2925

SPRING WIRE CROSS SECTION MAY BE EITHER RECTANGULAR OR CIRCULAR

CLOSE ENDS AND GRIND SQUARE WITH AXIS OF SPRINGS WITHIN 2° WHEN COMPRESSED TO .315 LENGTH



SPRING



(b) MATERIAL: SPRING, QQ-W-470 OR QQ-W-423, COMPOSITION 302 OR 304, CONDITION B.

RETAINER, CRES, BAR, MIL-S-7720, TYPE 303, CONDITION A.

FINISH: SPRING, CADMIUM PLATE, QQ-P-416, TYPE I, CLASS 2.

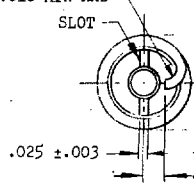
SURFACE FINISH: RETAINER, 63 RHR ALL OVER, MIL-STD-10.

GROUND END SURFACES OF ALL SPRINGS SHALL EXTEND NOT LESS THAN 270° OVER CIRCUMFERENCE OF END COILS.

SPRINGS SHALL NOT TAKE A PERMANENT SET WHEN COMPRESSED SOLID. LENGTH UNDER 25 LB LOAD SHALL BE .335 - .295.

3-1/2 TURNS MIN FIRST LOOP OF EACH END MUST BE FLAT AND SQUARE WITH SPRING AXIS

.016 MIN RAD



SPRING AND EYELET ASSEMBLY - 6

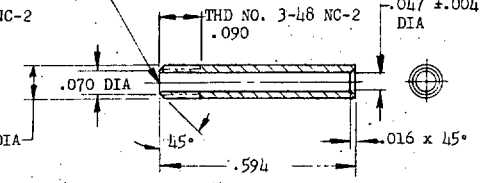
MATERIAL: SPRING, QQ-W-423, 302, 304 OR EQUAL.

EYELET, CORROSION RESISTANT STEEL.

SPRING LOAD SHALL BE 28 ± 3 OUNCES WHEN THE OVERALL COMPRESSED LENGTH OF THIS ASSEMBLY IS .130 ±.010.

METHOD OF ATTACHMENT CONTACT SPRING TO EYELET OPTIONAL EXCEPT THAT ATTACHMENT MUST BE TIGHT

DISTORTION OF HOLE AT THIS END PERMISSIBLE AS THE RESULT OF THREADING



STUD - 8

MATERIAL: AMS 5560, AMS 5565 OR EQUAL.

AMS 4610, AMS 4558

FINISH: BRASS, SILVER PLATE, QQ-S-365, THICKNESS .0002 TO .0004 AFTER THREADING.

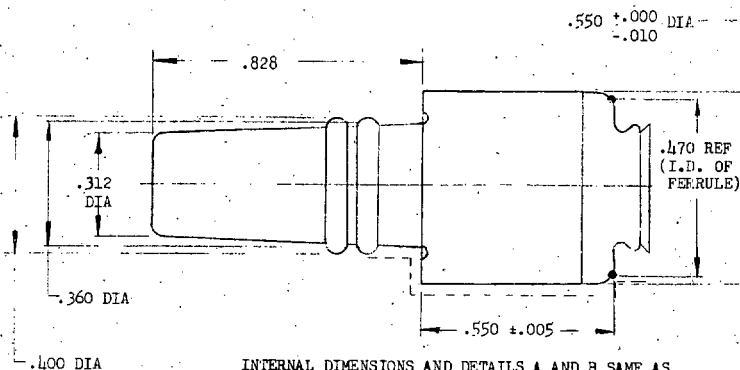
METAL PARTS MAY BE ROLLED, STAMPED OR MACHINED PROVIDED THE SPECIFIED DIMENSIONS ARE MET.

(b) IF QQ-W-470 IS USED, STRESS RELIEVE AT 500-550°F FOR 30 MINUTES AFTER FORMING.

REVISED (A) FOR CHANGES SEE SHEET 1.  
APPROVED 27 Dec 63

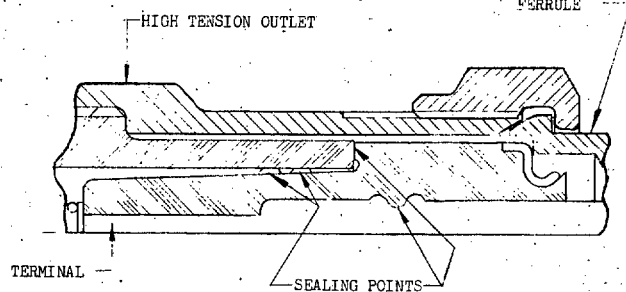
P.A. Navy - WP Other Cust Army - MO USAF - 82	TITLE TERMINAL ASSEMBLY, SPARK PLUG, DETACHABLE IGNITION LEAD SUPERSEDES: AN4164	MILITARY STANDARD <b>MS21267</b> SHEET 2 OF
PROCUREMENT SPECIFICATION MIL-L-19844	DD FORM 672-1 (Coordinated) 1 SEP 57	PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

This military standard is approved by the Department of Defense and is mandatory on all activities. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

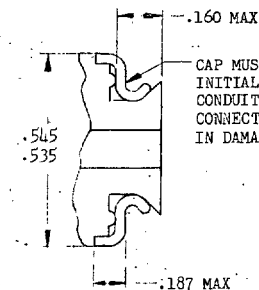
FED. SUP CLASS  
2925

SLEEVE (AND CAP) -5.

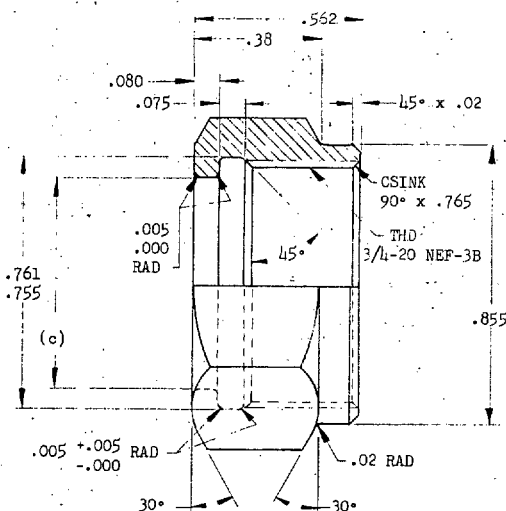
MATERIAL: SILICONE RUBBER, MIL-R-5847, GR-80, CLASS II OR EQUIVALENT. ALL CORNERS TO BE .020 ±.005 RADIUS UNLESS OTHERWISE SPECIFIED. APPLY 8 KV (RMS) BETWEEN ID AND SURFACE INDICATED BY DASH LINE FOR 5 SECONDS.



TERMINAL ASSEMBLY - 2



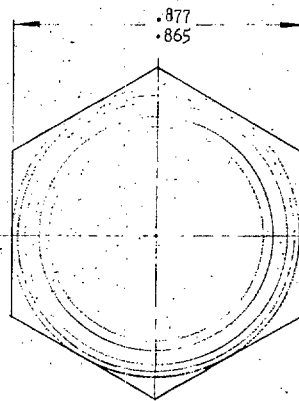
MATERIAL: CRES OR BRASS.  
FINISH: SILVER PLATED.



NUT -7

MATERIAL: CRES, QQ-S-753, TYPE 416.

(c) THIS DIMENSION OPTIONAL WITH MANUFACTURER. HOWEVER IT MUST BE SUCH AS TO PROVIDE A MINIMUM .020 SEAT (.040 DIAMETRICAL ENGAGEMENT) WHEN ASSEMBLED TO HIS FERRULE.



This military standard is approved by the Department of Defense and is mandatory on all activities. Selection for all new engineering and design applications and for repetitive use shall be made from this document.

USER:

REVIEWER:

Army - MO  
Navy - WP  
USAF - 82

APPROVED 27 Dec 63 REVISED 4 FOR CHANGES SEE SHEET 1.

P.A. Navy - WP	TITLE	MILITARY STANDARD
Other Cust Army - MO USAF - 82	TERMINAL ASSEMBLY, SPARK PLUG, DETACHABLE IGNITION LEAD	MS21267
PROCUREMENT SPECIFICATION MIL-L-19844	SUPERSEDES: AN4164	SHEET 3 OF