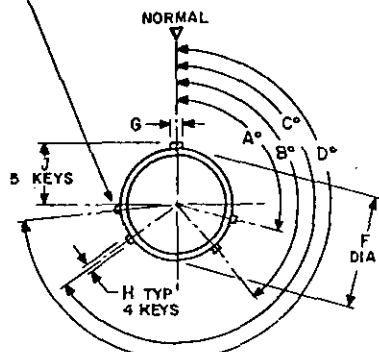
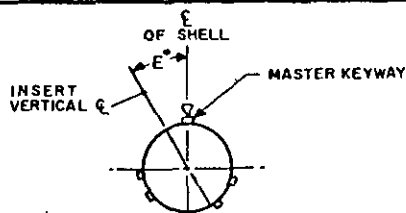
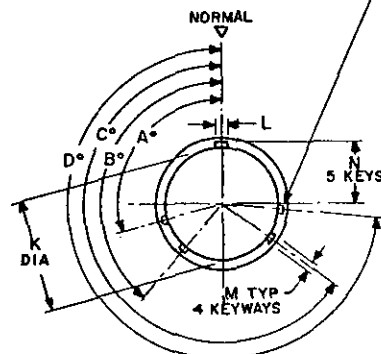


FED. SUP CLASS  
59354 KEYS (MMC) LOCATED WITHIN  
.004 EITHER SIDE OF (TYP) RELATIVE  
TO NORMAL KEY (MMC) ANDPLUG SHELL  
MATING FACEROTATED INSERT POSITION  
THRU 5 ONLY  
MATING FACE VIEW  
PIN INSERT (SHOWN)  
SOCKET INSERT (OPPOSITE)4 KEYS (MMC) LOCATED WITHIN  
.004 EITHER SIDE OF (TYP) RELATIVE  
TO NORMAL KEYWAY (MMC) ANDRECEPTACLE SHELL  
MATING FACE

ALTERNATE SHELL KEY POSITIONS FOR CONNECTORS

POSITION	SIZE 8				SIZE 10				SIZES 12 THRU 24				INSERT POSITION E°
	A°	B°	C°	D°	A°	B°	C°	D°	A°	B°	C°	D°	
N-NORMAL	105	140	215	265	105	140	215	265	105	140	215	265	0
1	-	-	-	-	↑	↑	↑	↑	↑	↑	↑	↑	10
2	-	-	-	-	↑	↑	↑	↑	↑	↑	↑	↑	20
3	-	-	-	-	↑	↑	↑	↑	↑	↑	↑	↑	30
4	-	-	-	-	↓	↓	↓	↓	↓	↓	↓	↓	40
5	-	-	-	-	↓	↓	↓	↓	↓	↓	↓	↓	50
6	102	132	248	320	102	132	248	320	18	149	192	259	0
7	80	118	230	312	80	118	230	312	92	152	222	342	0
8	35	140	205	275	35	140	205	275	84	152	204	334	0
9	64	155	234	304	64	155	234	304	24	135	199	240	0
10	-	-	-	-	25	115	220	270	98	152	268	338	0

SHELL SIZE	F + .000 - .005	G ± .003	H ± .003	J + .000 - .003	K + .005 - .000	L ± .003	M + .005 - .000	N + .005 - .000
8	.424	.084	.042	.234	.428	.094	.063	.227
10	.526	.084	.052	.285	.530	.094	.072	.280
12	.696	.084	.052	.370	.700	.094	.072	.373
14	.765	.084	.052	.405	.769	.094	.072	.408
16	.892	.115	.052	.468	.896	.125	.072	.471
18	.998	.115	.052	.521	1.002	.125	.072	.524
20	1.123	.115	.052	.583	1.127	.125	.072	.586
22	1.248	.115	.052	.646	1.252	.125	.072	.649
24	1.373	.115	.052	.703	1.377	.125	.072	.711

## NOTES:

- DIMENSIONS IN INCHES. DIMENSIONING IN ACCORDANCE WITH ANSI Y14.5-1966.
- DIMENSIONS LOCATING CONTACTS AND INSERTS ARE TRUE POSITION. FOLLOWING TOLERANCES APPLY TO INSERT INSTALLED IN SHELL.
  - FOR CRIMP CONTACT CONNECTORS, CENTER OF EACH HOLE IN INSERT SHALL BE LOCATED AT TRUE POSITION WITHIN .014 DIA.  $\oplus .014 \text{ DIA.}$
  - CENTER OF ENGAGING END OF EACH CONTACT SHALL BE LOCATED AT TRUE POSITION WITHIN .024 DIA.  $\oplus .024 \text{ DIA.}$
- UNLESS OTHERWISE INDICATED, DIMENSIONS ARE SYMMETRICAL ABOUT CENTERLINES.
- EACH INSERT ARRANGEMENT IS SHOWN IN ITS NORMAL POSITION IN THE SHELL.
- IN NORMAL POSITION THE INDEXING RADIUS COINCIDES WITH  $\epsilon$  OF THE MASTER KEY OR KEYWAY OF SHELL.
- POSITIONS 1 THRU 5 FOR REPLACEMENT PURPOSES ONLY.
- FOR NEW DESIGN USE POSITIONS "N", 6 THRU 10.
- CONTACT IDENTIFICATION: MARK IN CONTRASTING COLOR WITH PERMANENT HIGH TEMPERATURE MARKING.

CANCELED AFTER 20 Feb 78

USE MIL-STD-1554

THIS IS A DESIGN STANDARD, NOT TO BE USED AS A PART NUMBER.

A Denotes Changes

P.A. AIR FORCE 85 Other Cust	TITLE INSERT ARRANGEMENTS MIL - C - 83723 ELECTRICAL CONNECTOR	MILITARY STANDARD MS27748 (USAF)
PROCUREMENT SPECIFICATION NONE	SUPERSEDES:	SHEET 1 OF 1

DD FORM 672-1 (Limited coordination)

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Reviewers: AF 99

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This document is approved by the AF LCC/DOE and is mandatory for use by military activities that employ this standard where suitable.