

REV.
C

AS25274™

FEDERAL SUPPLY CLASS
5940

RATIONALE

REVISION REQUIRED TO ADD CRIMP TOOLS AND PART IDENTIFICATION NUMBER (PIN).

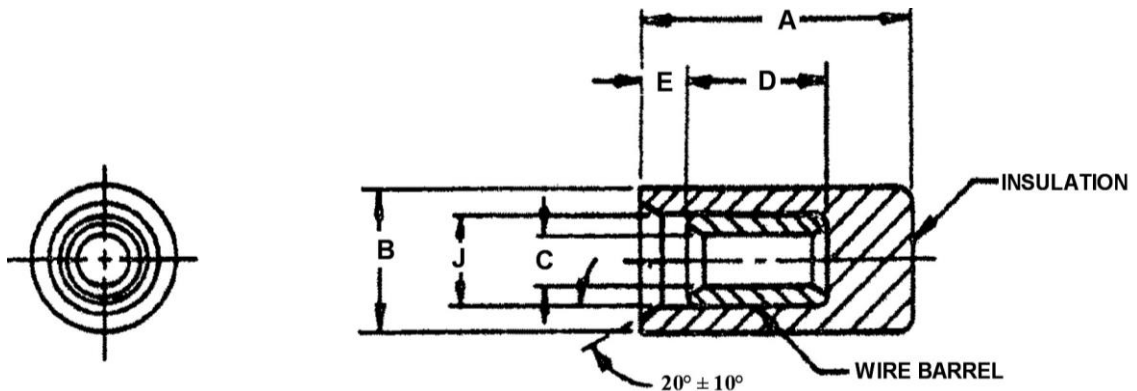


FIGURE 1 - AS25274 CONFIGURATION

TABLE 1 - DIMENSIONS AND PERFORMANCE REQUIREMENTS

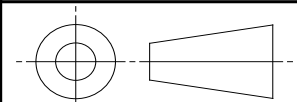
DASH NO.	WIRE SIZE	A MAX	B MAX	C		D MAX	E MIN	J MAX	COLOR CODE	MIN TENSILE VALUES AND AXIAL LOAD (LB)
				MAX	MIN					
-1	26-24	.480	.215	.035	.027	.305	.082	.145	YELLOW	5.0
-2	22-18		.215	.073	.050			.145	RED	15.0
-3	16-14		.245	.095	.080			.170	BLUE	25.0
-4	12-10		.315	.140	.129	.345		.229	YELLOW	35.0

TABLE 2 - CRIMP TOOL REQUIREMENTS

DASH NO.	WIRE SIZE	CRIMP TOOL PIN M22520/	CRIMP DIE PIN M22520/
-1	26-24	/5-01	/5-100
		/10-01	/10-101
-2	22-18	/5-01	/5-100
		/10-01	/10-101
		/40	N/A
-3	16-14	/5-01	/5-100
		/10-01	/10-101
		/40	N/A
-4	12-10	/5-01	/5-100
		/10-01	/10-100
		/41	N/A

For more information on this standard, visit
<https://www.sae.org/standards/content/AS25274C>

THIRD ANGLE PROJECTION



CUSTODIAN: AE-8/AE-8C2

PROCUREMENT SPECIFICATION: AS7928



AEROSPACE STANDARD

(R) CAP, ELECTRICAL (WIRE END, CRIMP STYLE, TYPE II, CLASS 1) FOR 105 °C TOTAL CONDUCTOR TEMPERATURE

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REQUIREMENTS: (SEE AS7928)

1. MATERIAL:

METAL SLEEVE BASE MATERIAL: SOFT COPPER, ASTM B272, CLASS A, BRONZE, COMMERCIAL, ASTM B140 ALLOY B, ASTM B282 CLASS A, OR ASTM B152

METAL SLEEVE FINISH: TIN PLATED

INSULATING SLEEVE: THERMOPLASTIC NYLON OR POLYETHYLENE

2. CONFIGURATION:

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES IN ACCORDANCE WITH FIGURE 1 AND TABLE 1. CONTOUR MAY VARY FROM THAT SHOWN.

3. CRIMP TOOLS

CRIMP TOOLS SHALL BE IN ACCORDANCE WITH TABLE 2.

4. PART IDENTIFICATION NUMBER (PIN)

THE PIN SHALL BE AS FOLLOWS:

MS25274 -1
I I DASH NUMBER (SEE TABLE 1)
I AS7928 PART DESIGNATION (MS) AND DETAIL SPECIFICATION NUMBER (25274)

5. TENSILE STRENGTH AND AXIAL LOAD TESTS:

MECHANICAL CONNECTION OF WIRE BARREL AND INSULATOR TO CONDUCTOR SHALL MEET MINIMUM TENSILE REQUIREMENTS OF TABLE 1. THE INSULATING SLEEVE SHALL NOT SLIP MORE THAN .031 INCHES AT THESE VALUES (AXIAL LOAD).

6. QUALIFICATION:

END CAPS SHALL BE SUBJECTED TO TEST GROUPS I, IV, V, VII, AND VIII OF TABLE 5 SPECIFIED IN AS7928. END CAPS SHALL BE TESTED WITH AS50861/1, AS22759/1, AS22759/9, OR AS22759/11 WIRES.

7. APPLICATIONS:

MS90413 AND MS3316 TOOLS WERE ORIGINALLY USED FOR CRIMPING AS25274 CAPS. THESE SHOULD BE DISCARDED AND REPLACED WITH THE APPROPRIATE M22520 TOOL PARTS SPECIFIED IN TABLE 2.

SPECIFICATION NOTE:

1. REVISION INDICATOR:

A CHANGE BAR (I) LOCATED IN THE LEFT MARGIN IS FOR THE CONVENIENCE OF THE USER IN LOCATING AREAS WHERE TECHNICAL REVISIONS, NOT EDITORIAL CHANGES, HAVE BEEN MADE TO THE PREVIOUS ISSUE OF THIS DOCUMENT. AN (R) SYMBOL TO THE LEFT OF THE DOCUMENT TITLE INDICATES A COMPLETE REVISION OF THE DOCUMENT, INCLUDING TECHNICAL REVISIONS. CHANGE BARS AND (R) ARE NOT USED IN ORIGINAL PUBLICATIONS, NOR IN DOCUMENTS THAT CONTAIN EDITORIAL CHANGES ONLY.

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