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REV.
C

AS81824™/1

FEDERAL SUPPLY CLASS
5970

RATIONALE

UPDATE TEST REQUIREMENT FOR WIRE SPEC.

NOTICE

THE COMPLETE REQUIREMENTS FOR PROCURING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF AS81824.

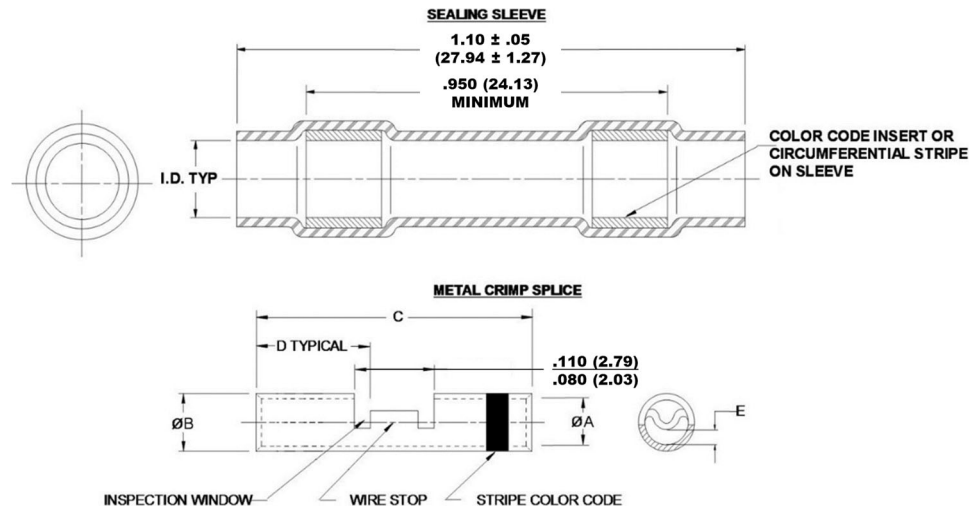
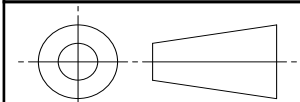


FIGURE 1 - SPLICE SEALING SLEEVE AND METAL CRIMP SPLICE

For more information on this standard, visit

<https://www.sae.org/standards/content/AS81824/1C/>

THIRD ANGLE PROJECTION



CUSTODIAN: AE-8C2

PROCUREMENT SPECIFICATION: AS81824



AEROSPACE STANDARD

SPLICE, IN-LINE, ELECTRIC, CRIMP, SN/CU,
ENVIRONMENTAL, HEAT-SHRINKABLE SLEEVE
(150 °C), 1 X 1 SEALANT OPENING

AS81824™/1
SHEET 1 OF 3

REV.
C

Documents

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TABLE 1 - CONSTRUCTION DETAILS

PART NUMBER	WIRE RANGE	ID 1/ A (MIN) B (MAX)	ØA	ØB	C	D	E MAX	COLOR CODE	WEIGHT POUNDS (KG) PER 1000 PCS - MAX REF
M81824/1-1	SEE TABLE 3	.085 (2.18) .025 (0.64)	.053 (1.35) .045 (1.14)	.080 (2.03) .075 (1.91)	.510 (12.95) .490 (12.45)	.245 (6.22) .225 (5.72)	.015 (0.38)	RED	1.10 (0.5)
M81824/1-2	SEE TABLE 3	.110 (2.79) .025 (0.64)	.070 (1.78) .063 (1.60)	.107 (2.72) .100 (2.54)	.585 (14.86) .565 (14.35)	.280 (7.11) .260 (6.60)	.020 (0.51)	BLUE	1.75 (0.8)
M81824/1-3	SEE TABLE 3	.170 (4.32) .025 (0.64)	.103 (2.62) .095 (2.41)	.155 (3.94) .146 (3.71)	.585 (14.86) .565 (14.35)	.280 (7.11) .260 (6.60)	.050 (1.27)	YELLOW	3.15 (1.4)

1/ ID A IS AS RECEIVED AND B IS AFTER UNRESTRICTED RECOVERY THROUGH MELTABLE MATERIAL.

REQUIREMENTS: ALL REQUIREMENTS SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF AS81824.

CONFIGURATION:

- DIMENSIONS ARE IN INCHES. METRIC EQUIVALENTS IN PARENTHESES (TO THE NEAREST 0.01 MM) ARE FOR GENERAL INFORMATION ONLY AND ARE BASED ON 1 INCH = 25.4 MM.
- UNLESS OTHERWISE SPECIFIED, TOLERANCES ARE ± 0.005 (0.13 MM) FOR THREE PLACE DECIMALS AND ± 0.01 (0.25 MM) FOR TWO PLACE DECIMALS.
- WIRE STOP IS REQUIRED TO LOCATE THE CRIMP ZONE ON THE CONDUCTOR. CONTOUR MAY VARY FROM THAT SHOWN IN FIGURE 1.
- THE "B" DIAMETER SHALL NOT INCLUDE COLOR STRIPE.

MATERIALS:

- METAL CRIMP SPLICE SHALL BE COPPER PER ASTM B280, ASTM B75/B75M, ASTM B187/B187M, ASTM B1, ASTM B301/B301M, OR ASTM B152.
- INSULATION SLEEVE SHALL BE HEAT-SHRINKABLE POLYVINYLIDENE FLUORIDE PER THE PERFORMANCE REQUIREMENTS OF AS23053/8. THE SLEEVE SHALL BE TRANSLUCENT TO TRANSPARENT THROUGH WHICH THE CRIMP BARREL SHALL BE VISIBLE.
- SEALING MATERIAL SHALL BE MODIFIED THERMOPLASTIC IN ACCORDANCE WITH AS81824.
- FINISH SHALL BE TIN PLATED IN ACCORDANCE WITH AS81824.

CRIMP TOOLS:

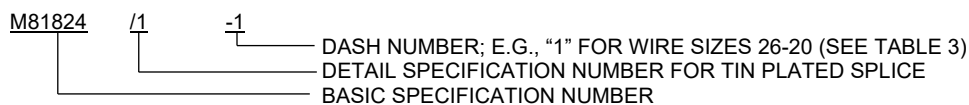
- CRIMP TOOLS SHALL BE AS SPECIFIED IN TABLE 2 (SEE QUALIFICATION REQUIREMENTS AND APPLICATION NOTES).

TABLE 2 - CRIMP TOOLS

SPLICE PART NO.	BASIC CRIMP TOOL NO.	DIE NO. OR CAVITY ID
M81824/1-1	M22520/5-01	M22520/5-103
	M22520/10-01	M22520/10-104
	M22520/37-01	20-26
M81824/1-2	M22520/5-01	M22520/5-103
	M22520/10-01	M22520/10-104
	M22520/37-01	16-20
M81824/1-3	M22520/5-01	M22520/5-102
	M22520/10-01	M22520/10-103
	M22520/37-01	12-16

PART IDENTIFICATION NUMBER (PIN):

- THE SPLICE IS IDENTIFIED AS SHOWN BELOW. THE SPLICE SUPPLIER SHALL BE IDENTIFIED BY A MANUFACTURER SYMBOL ON THE CRIMP BARREL IN ACCORDANCE WITH AIR1351 (LOCATION OPTIONAL).



	AEROSPACE STANDARD	AS81824™/1 SHEET 2 OF 3	REV. 6
	SPLICE, IN-LINE, ELECTRIC, CRIMP, SN/CU, ENVIRONMENTAL, HEAT-SHRINKABLE SLEEVE (150 °C), 1 X 1 SEALANT OPENING		



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