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REV.
A

AS81824™/3

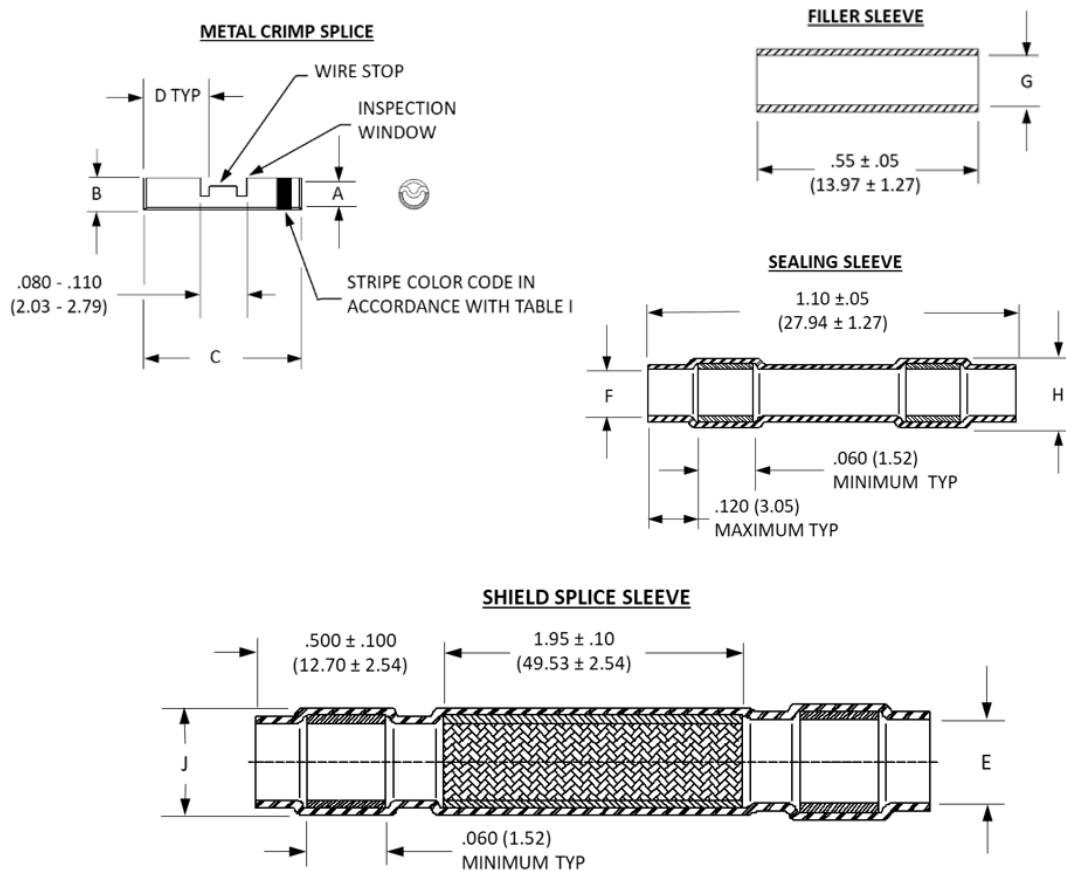
FEDERAL SUPPLY CLASS
5940

RATIONALE

THIS DOCUMENT IS REWRITTEN WHICH WAS ORIGINALLY TAKEN DIRECTLY FROM U.S. MILITARY STANDARD MIL-S-81824/3. THIS SAE STANDARD RETAINS THE SAME PART NUMBERS ESTABLISHED BY THE ORIGINAL MILITARY DOCUMENTS.

NOTICE

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



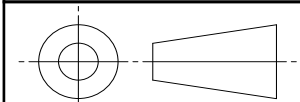
NOTES:

1. DIMENSIONS ARE IN INCHES.
2. "B" DIAMETER SHALL NOT INCLUDE COLOR STRIPE.
3. METRIC EQUIVALENTS (TO THE NEAREST .01 MM) ARE GIVEN FOR GENERAL INFORMATION ONLY AND ARE BASED UPON 1 INCH = 25.4 MM.

FIGURE 1 - SPLICE ASSEMBLY

For more information on this standard, visit
<https://www.sae.org/standards/content/AS81824/3A/>

THIRD ANGLE PROJECTION



CUSTODIAN: AE-8/AE-8C2



AEROSPACE STANDARD

SPLICE, COAXIAL CABLE, ELECTRIC, PERMANENT, CRIMP AND SOLDER STYLE COPPER, INSULATED, ENVIRONMENT RESISTANT, 150 °C

AS81824™/3
SHEET 1 OF 4

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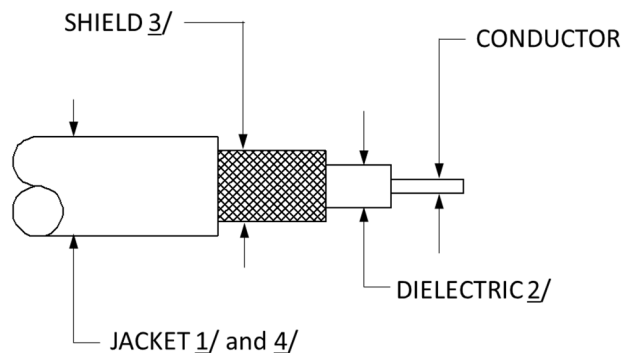
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TABLE 1 - CONSTRUCTION DETAILS

MILITARY PART NUMBER	CENTER CONDUCTOR DIAMETER RANGE	COLOR CODE	METAL CRIMP SPLICE				SHIELD SPLICE, E		
			A	B	C	D	1/ MIN	4/ MIN	3/ MAX
M81824/3-1	.020 (0.51) .010 (0.25)	YELLOW	.032 (0.81) .022 (0.56)	.080 (2.03) .075 (1.91)	.510 (12.95) .490 (12.45)	.245 (6.22) .225 (5.72)	.118 (3.00)	.060 (1.52)	.070 (1.78)
M81824/3-2	.020 (0.51) .010 (0.25)	YELLOW	.032 (0.81) .022 (0.56)	.080 (2.03) .075 (1.91)	.510 (12.95) .490 (12.45)	.245 (6.22) .225 (5.72)	.157 (3.99)	.075 (1.91)	.080 (2.03)
M81824/3-3	.040 (1.02) .020 (0.51)	RED	.053 (1.35) .045 (1.14)	.080 (2.03) .075 (1.91)	.510 (12.95) .490 (12.45)	.245 (6.22) .225 (5.72)	.236 (5.99)	.118 (3.00)	.137 (3.48)

MILITARY PART NUMBER	SEALING SLEEVE, F		FILLER SLEEVE, G			SEALING SLEEVE	SHIELD SPLICE	MIL-DTL-17 APPLICABLE CABLES
	1/ MIN	2/ MAX	1/ MIN	5/ MIN	6/ REF	H MAX	J MAX	
M81824/3-1	.118 (3.00)	.025 (0.64)	NONE			.200 (5.08)	.270 (6.86)	/94 RG-179 /113 RG-316 /172
M81824/3-2	.157 (3.99)	.054 (1.37)	.157 (3.99)	.070 (1.78)	.105 (2.67)	.250 (6.35)	.315 (8.00)	/95 RG-180
M81824/3-3	.236 (5.99)	.075 (1.91)	.236 (5.99)	.070 (1.78)	.118 (3.00)	.300 (7.62)	.350 (8.89)	/110 RG-302 /111 RG-303 /170

SELECTION GUIDE



- 1/ AS SUPPLIED. CABLE JACKET DIAMETER MUST BE LESS THAN THIS VALUE.
- 2/ RECOVERED ID, THROUGH MELTABLE INSERTS OF SEALING SLEEVE. CABLE DIELECTRIC DIAMETER MUST BE GREATER THAN THIS VALUE.
- 3/ RECOVERED ID, THROUGH SHRINKABLE SHIELD OF SHIELD SPLICE SLEEVE. CABLE SHIELD DIAMETER MUST BE GREATER THAN THIS VALUE. SHIELD MAY BE FOLDED BACK OVER CABLE JACKET TO INCREASE ITS DIAMETER.
- 4/ RECOVERED ID, THROUGH MELTABLE INSERTS OF SHIELD SPLICE SLEEVE. CABLE JACKET DIAMETER MUST BE GREATER THAN THIS VALUE.
- 5/ RECOVERED ID.
- 6/ RECOVERED OD MEASURED WHEN INSTALLED ON METAL CRIMP SPLICE.

TABLE 2 - CRIMP TOOLS

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

	AEROSPACE STANDARD	AS81824™/3 SHEET 2 OF 4	REV. A
	SPLICE, COAXIAL CABLE, ELECTRIC, PERMANENT, CRIMP AND SOLDER STYLE COPPER, INSULATED, ENVIRONMENT RESISTANT, 150 °C		



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