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AS81969™/11

FEDERAL SUPPLY CLASS
5120

RATIONALE

THIS DETAIL SPECIFICATION SHEET IS REQUIRED TO ALLOW THE CANCELLATION AND SUPERSESSION OF MIL-I-81969/11 WITH THIS DOCUMENT, TO IMPROVE DRAWING LEGIBILITY, TO INCORPORATE AMENDMENT 1, TO REMOVE THE PATENT NOTICE SINCE THE PATENT HAS EXPIRED, TO UPDATE QUALIFICATION INFORMATION, AND TO UPDATE REFERENCES.

NOTICE

THE COMPLETE REQUIREMENTS FOR PROCURING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF AS81969.

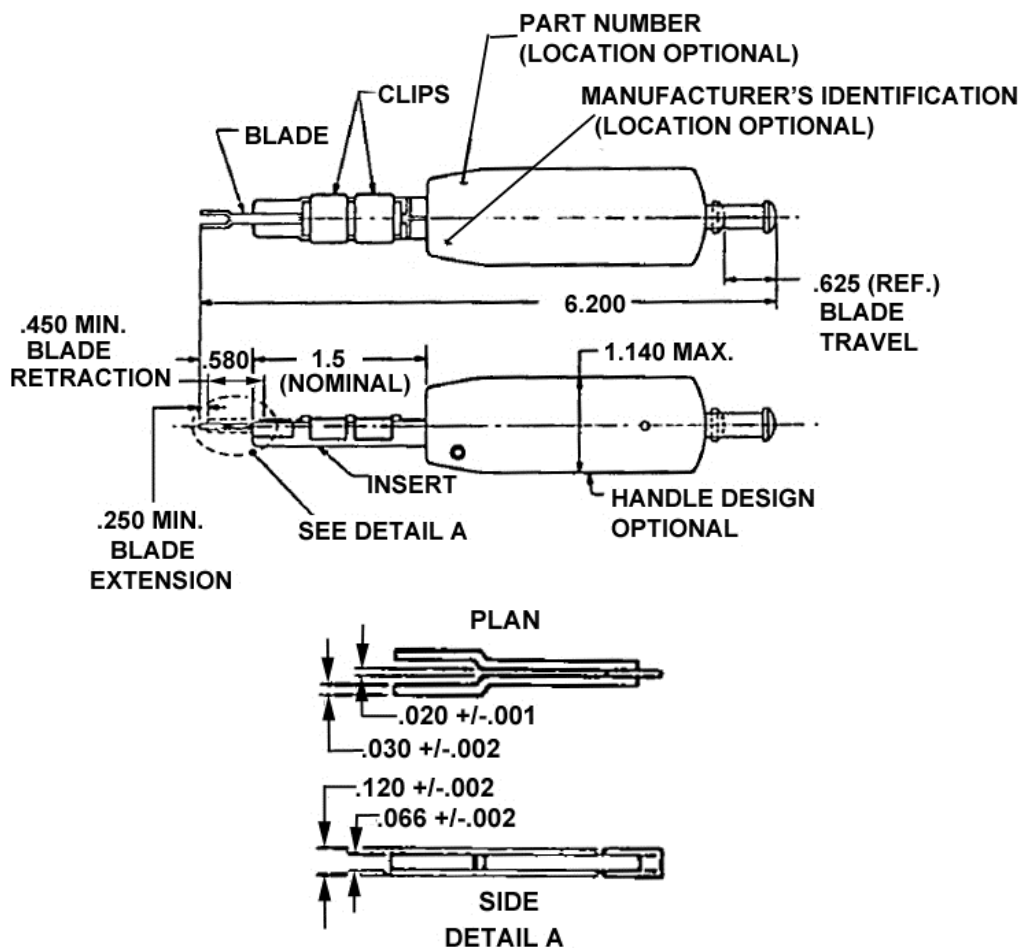
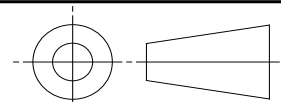


FIGURE 1 - REMOVAL TOOL CONFIGURATIONS/DIMENSIONS

For more information on this standard, visit
<https://www.sae.org/standards/content/AS81969/11>

THIRD ANGLE PROJECTION



CUSTODIAN: AE-8/AE-8C2

PROCUREMENT SPECIFICATION: AS81969



AEROSPACE STANDARD

REMOVAL TOOLS, CONNECTOR, ELECTRICAL
CONTACT, (FORK TYPE, WRAPPOST/CRIMP
REMOVABLE) TYPE II, CLASS 1, COMPOSITION C

AS81969™/11
SHEET 1 OF 3

Documents

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TABLE 1 - METRIC EQUIVALENTS

INCHES	MILLIMETERS	INCHES	MILLIMETERS	INCHES	MILLIMETERS
.001	0.03	.120	3.05	1.125	28.58
.002	0.05	.250	6.35	1.140	28.96
.020	0.51	.450	11.43	1.5	38.10
.030	0.76	.580	14.73	6.200	157.48
.066	1.68	.625	15.88		

REQUIREMENTS: ALL REQUIREMENTS SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF AS81969.

1. DESIGN: THE TOOL SHALL BE DESIGNED IN ACCORDANCE WITH FIGURE 1. DIMENSIONS ARE IN INCHES. METRIC EQUIVALENTS IN TABLE 1 ARE GIVEN FOR GENERAL INFORMATION ONLY AND ARE BASED ON 1 INCH = 25.4 MILLIMETERS. UNLESS OTHERWISE SPECIFIED, TOLERANCE IS ± 0.015 INCH (0.38 MILLIMETERS).
2. COMPONENTS: THE PROBE AND PLUNGER SHALL BE PERMANENTLY ATTACHED TO THE BODY OF THE TOOL, THEREFORE THE TOOL IS NON-REPAIRABLE.

THE CLIP RELEASE PRONGS SHALL MAINTAIN ALIGNMENT IN ORDER TO PREVENT DAMAGE TO THE CONNECTOR CONTACT CAVITY.

THE PLUNGER SHALL SELF-RETURN TO THE UNUSED POSITION.

3. MATERIAL AND FINISHES:

HANDLE AND INSERT - ALUMINUM ALLOY, PLASTIC IN ACCORDANCE WITH ASTM D5948, ASTM D4673, OR AN ALTERNATE MATERIAL APPROVED BY THE QUALIFYING ACTIVITY.

BLADE - 1090 STEEL, SPRING TEMPERED, STEEL SAE 4130, AMS5643, AMS6370, 400 SERIES STAINLESS STEEL OR 300 MARGING STEEL OR SUITABLE MATERIAL, HEAT TREATED TO ROCKWELL C35-45.

PLATING - FOR NON-CORROSION RESISTANT STEELS, COAT WITH ELECTROLESS NICKEL TO THE REQUIREMENTS OF AMS2404, CLASS I (THICKNESS .0002 TO .0005). HYDROGEN RELIEF FOR 4 HOURS $\pm$ 1 HOUR AT 375 °F $\pm$ 25 °F, WITHIN 24 HOURS AFTER COATING, TREAT BY IMMERSION IN A SOLUTION IN ACCORDANCE WITH MIL-DTL-5541 TO ENHANCE RESISTANCE TO CORROSION AND TARNISH OR NICKEL PLATING (ELECTRODEPOSITED) IN ACCORDANCE WITH AMS-QQ-N-290, CLASS 2, THICKNESS .0002 TO .0005).

4. PART NUMBER/MARKING: M81969/11-01

EACH TOOL SHALL BE LEGIBLY AND PERMANENTLY MARKED ON THE HANDLE WITH THE MANUFACTURER'S IDENTIFICATION AND PART NUMBER IN ACCORDANCE WITH MIL-STD-130. MANUFACTURER SYMBOL, IF USED, SHALL BE IN ACCORDANCE WITH AIR1351.

5. QUALIFICATION: QUALIFICATION SHALL BE IN ACCORDANCE WITH AS81969 WITH THE FOLLOWING EXCEPTIONS:

PLUNGER FORCE - 5 POUNDS MAXIMUM

ROTATION - NOT APPLICABLE

THRUST - NOT APPLICABLE

IMPACT STRENGTH - NOT APPLICABLE

PLUNGER FORCE - NOT APPLICABLE

ALTERNATIVE QUALIFICATION REQUIREMENTS SUCH AS CERTIFICATION, FIRST ARTICLE OR QC TESTING MAY BE IMPOSED BY THE QUALIFYING ACTIVITY (QA). THE QA SHALL SUBMIT A WRITTEN REQUEST TO THE AE-8C2 COMMITTEE FOR REVIEW AND APPROVAL OF THE ALTERNATIVE QUALIFICATION TESTING PROGRAM PRIOR TO IMPLEMENTATION OF THE REQUIREMENT.

APPLICATION NOTES:

1. THIS TOOL SHALL BE USED TO REMOVE CONTACTS SPECIFIED IN MIL-DTL-28731/1 THROUGH /6 AND /9 THROUGH /18.
2. THIS DOCUMENT SUPERSEDES MIL-I-81969/11B DATED 25 JANUARY 1985, MIL-I-81969/11B AMENDMENT 1 DATED 27 FEBRUARY 1997, AND MIL-C-28731/22B DATED 12 MAY 1977.

	AEROSPACE STANDARD	AS81969™/11 SHEET 2 OF 3  Documents	
	REMOVAL TOOLS, CONNECTOR, ELECTRICAL CONTACT, (FORK TYPE, WRAPPOST/CRIMP REMOVABLE) TYPE II, CLASS 1, COMPOSITION C		