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REV.
B

AS81714™/63

FEDERAL SUPPLY CLASS
5940

RATIONALE

REVISION IS REQUIRED TO REMOVE THE INACTIVE FOR NEW DESIGN STATUS OF THIS PRODUCT (REMOVING THE APPLICATION NOTE PARAGRAPH), A USER HAS REQUESTED THE STATUS BE CHANGED TO ACTIVE.

NOTICE

THE COMPLETE REQUIREMENTS FOR PROCURING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF AS81714.

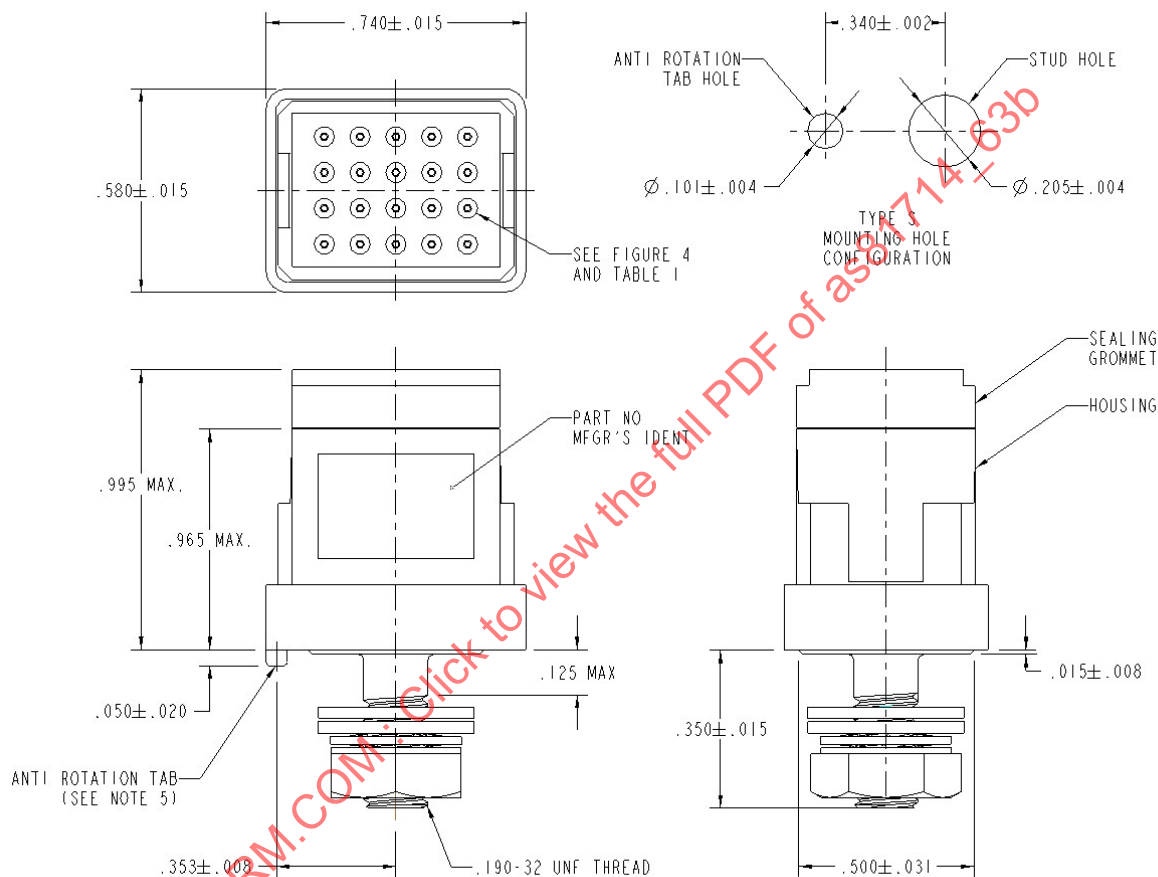
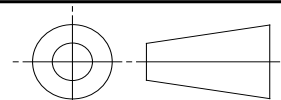


FIGURE 1 - STUD MOUNTING TYPE S

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THIRD ANGLE PROJECTION



CUSTODIAN: AE-8/AE-8C2

PROCUREMENT SPECIFICATION: AS81714



AEROSPACE STANDARD

(R) TERMINAL JUNCTION SYSTEM, TERMINAL JUNCTION BLOCKS, SECTIONAL, GROUNDING MODULES, STUD AND FLANGE TYPE MOUNTING, SERIES II

AS81714™/63
SHEET 1 OF 6

REV.
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ISSUED 2004-04 REVISED 2015-12

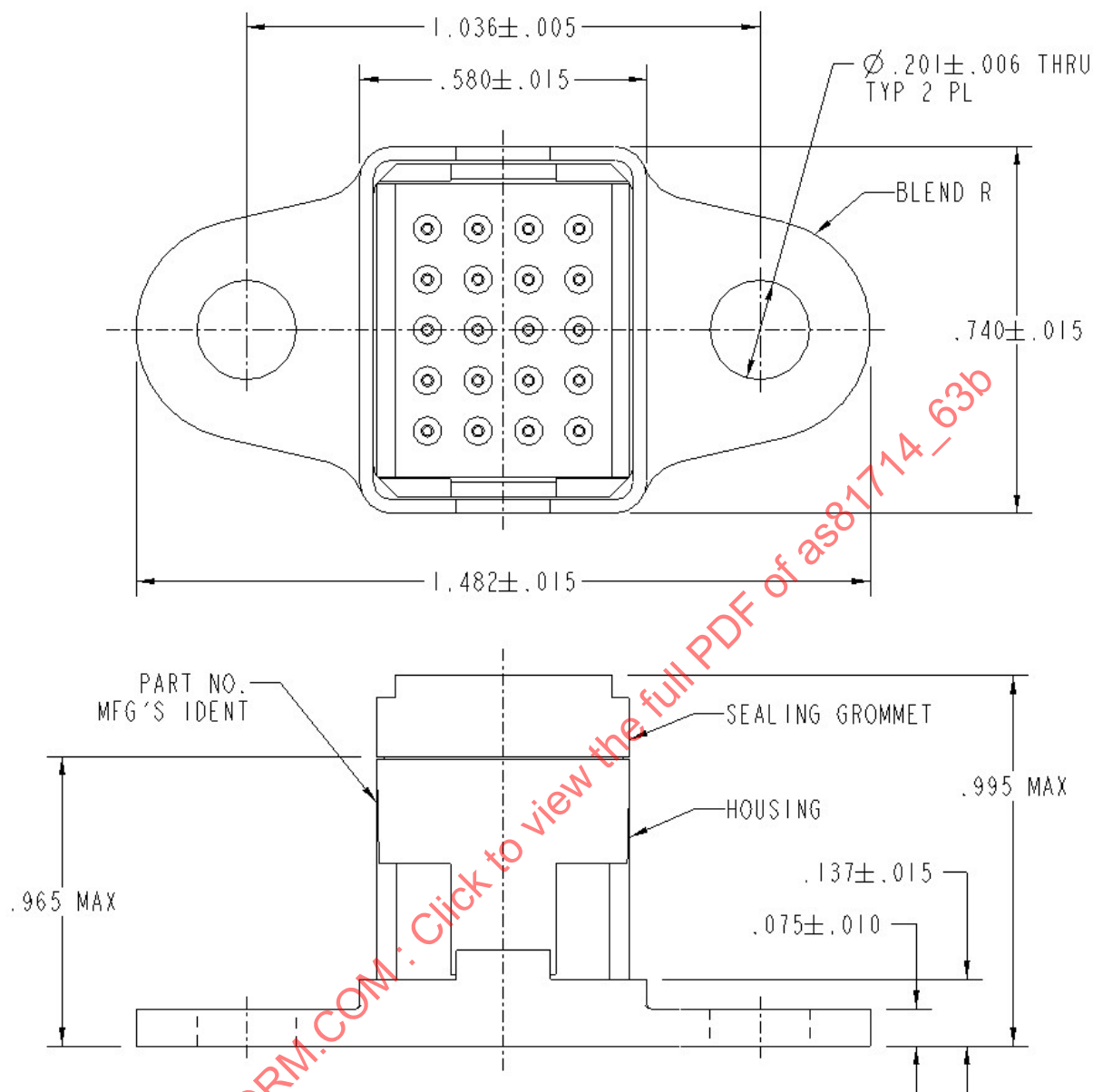


FIGURE 2 - FLANGE MOUNTING TYPE F (ALL EXCEPT BLOCK SIZE 12)

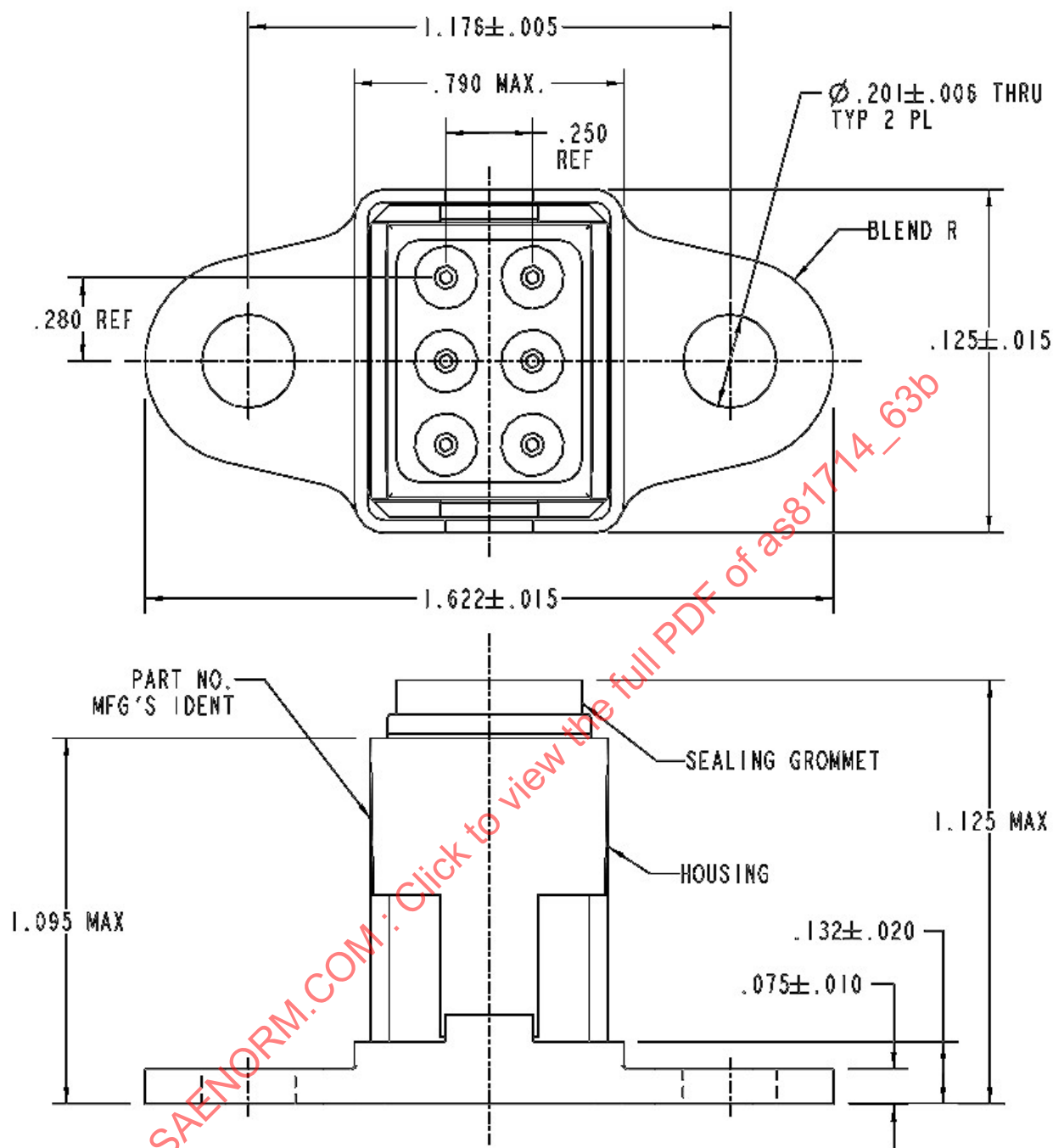
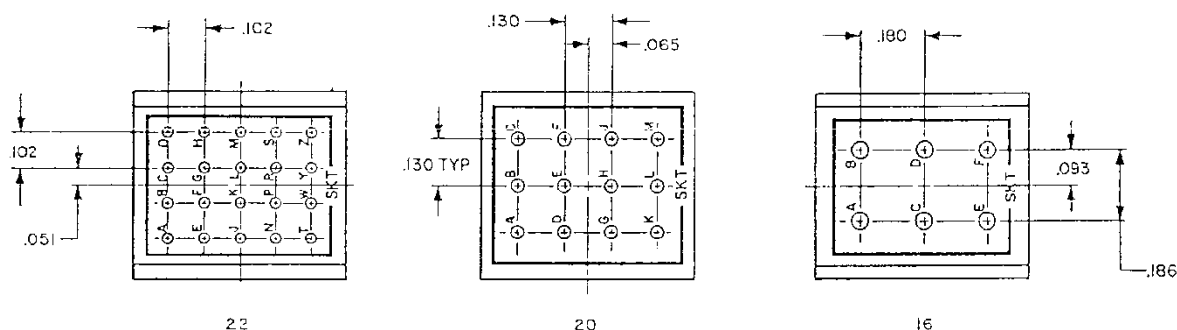


FIGURE 3 - FLANGE MOUNTING TYPE F, BLOCK SIZE 12



ALL DIMENSIONS OF THIS FIGURE ARE REFERENCE DIMENSIONS.

FIGURE 4 - TYPE S AND F

TABLE 1 - TOOLING

COMPONENT DESIGNATOR	BUSSING ARRANGEMENT	TYPE	CONTACT INSERTING/ REMOVAL TOOL	END SEALING PLUG	FIGURE
22	22	S & F	M81969/16-04	MS27488-22-2	4
20	20	S & F	M81969/14-02	MS27488-20-2	4
16	16	S & F	M81969/14-03	MS27488-16-2	4
12 (SEE REQUIREMENT 6)	12	F ONLY	M89169/16-03	MS27488-12-2	3

INCH	MM	INCH	MM	INCH	MM	INCH	MM
.002	0.05	.065	1.65	.186	4.72	.740	18.79
.004	1.01	.075	1.90	.201	5.10	.790	20.06
.005	0.12	.093	2.36	.205	5.20	.965	24.51
.006	0.15	.101	2.56	.250	6.35	.995	25.27
.008	0.20	.102	2.59	.280	7.11	1.036	26.31
.010	0.25	.125	3.17	.340	8.63	1.095	27.81
.015	0.38	.130	3.30	.350	8.89	1.125	28.57
.020	0.50	.132	3.35	.353	8.96	1.176	29.87
.031	0.78	.137	3.47	.500	12.7	1.482	37.64
.050	1.27	.180	4.57	.580	14.73	1.622	41.19
.051	1.29						

REQUIREMENTS:

1. FINISH

THE STUD/STUD BASE FOR TYPE "S", AND THE FLANGE FOR TYPE "F" SHALL BE GOLD PLATED IN ACCORDANCE WITH MIL-DTL-45204, TYPE I, GRADE C, CLASS 00 OVER A SUITABLE NICKEL UNDERPLATE.

- 2. THE ASSEMBLY SHALL BE MOUNTED IN A TEST FIXTURE, AS SHOWN IN FIGURE 5, WITH AN ADAPTER ATTACHED TO THE STUD OR FLANGE AS NECESSARY. APPLY THE REQUIRED LOAD AT DISTANCE "L" FROM THE TEST FIXTURE AS SHOWN. THE LOAD SHALL CREATE A BENDING MOMENT OF 20 IN-LB FOR SIZES 22, 20, AND 16, AND 30 INCH-POUNDS FOR SIZE 12. APPLY THE LOAD AT A RATE OF APPROXIMATELY 1 POUND PER SECOND UNTIL THE REQUIRED FORCE IS ACHIEVED AND KEEP IT APPLIED FOR 15 SECONDS BEFORE RELEASING. THERE SHALL BE NO EVIDENCE OF SEPARATION BETWEEN THE HOUSING AND THE STUD OR SHELL BASE, OR ANY OTHER DAMAGE DETRIMENTAL TO THEIR NORMAL OPERATION.**