

**REV.  
B**

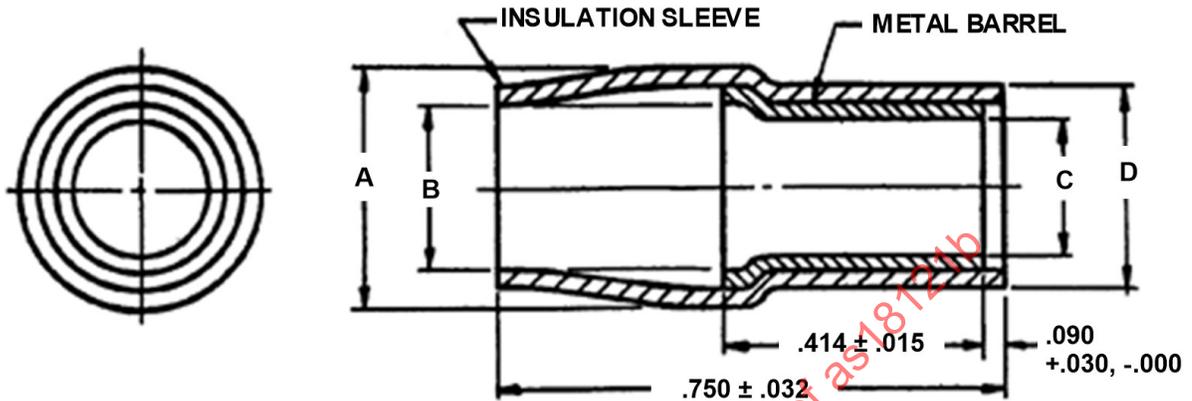
**RATIONALE**

REVISION REQUIRED TO ADD APPLICATION INFORMATION AND MINOR TECHNICAL CHANGES.

**NOTICE**

THE COMPLETE REQUIREMENTS FOR PROCURING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF AS21608.

**AS18121™**



**FIGURE 1 - FERRULE**

REQUIREMENTS: ALL REQUIREMENTS SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF AS21608.

**1. MATERIAL:**

- METAL BARREL MATERIAL SHALL BE COPPER OR BRASS ALLOY. ROCKWELL F65 MAXIMUM.
- FINISH SHALL BE TIN PLATE IN ACCORDANCE WITH ASTM B545 OR ASTM B339.
- INSULATING SLEEVE MATERIAL SHALL BE NYLON IN ACCORDANCE WITH ASTM D4066.

**2. CONFIGURATION:**

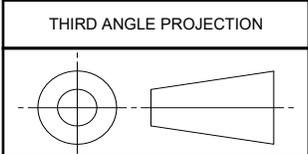
- DIMENSIONS IN INCHES SHALL BE IN ACCORDANCE WITH TABLE 1 AND FIGURE 1.
- SLEEVE COLOR SHALL BE IN ACCORDANCE WITH TABLE 1.
- REMOVE ALL BURRS AND SHARP EDGES. CHAMFER OR ROUND EDGES IS ACCEPTABLE.

**3. MARKING:**

- SLEEVES SHALL BE COLOR CODED IN ACCORDANCE WITH TABLE 1.
- SUPPLIER NAME OR SYMBOL IN ACCORDANCE WITH AIR1351 AND PART NUMBER SHALL BE ON UNIT PACKAGING.

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<https://www.sae.org/standards/content/AS18121B/>



CUSTODIAN: AE-8C2

PROCUREMENT SPECIFICATION: AS21608



**AEROSPACE STANDARD**  
 (R) FERRULES, OUTER, INSULATED, SHIELD  
 TERMINATING, TYPE II TWO-PIECE, CLASS I,  
 FOR SHIELDED CABLE

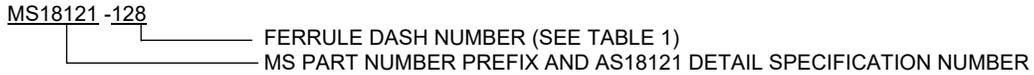
**AS18121™**  
 SHEET 1 OF 3

**REV.  
B**

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ISSUED 1999-07 REAFFIRMED 2012-01 REVISED 2021-01

4. PART NUMBER:



5. CRIMP TOOLS:

- SUPPLIER SHALL MAKE AVAILABLE TO THE USER COMPLETE DETAILS OF THE TOOLS REQUIRED FOR TERMINATION OF FERRULE.
- CRIMP TOOL SHALL BE AS22520/5 DIES AS SPECIFIED IN TABLE 1.
- IF CLASS II TOOLS ARE USED (QUALIFICATION CERTIFICATION IS REQUIRED).

**TABLE 1 - CONFIGURATION**

DASH NUMBER MS18121-	SLEEVE COLOR	A ±.025	B ±.015	C ±.005	D ±.025	CRIMP DIE DASH NUMBER M22520/5-	DIE CLOSURE POSITION
101	NONE 1/	.177	.128	.101	.152	35	B
128	BLUE	.205	.149	.128	.182	37	B
149	PURPLE	.244	.175	.149	.219	41	B
156	YELLOW	.260	.184	.156	.233	43	B
175	BLUE	.283	.206	.175	.255	19	B
187	ORANGE	.299	.218	.187	.270	45	A
194	RED	.298	.223	.194	.270	45	A
199	NONE 1/	.305	.229	.199	.275	45	A
205	YELLOW	.315	.236	.205	.285	19	A
219	GREEN	.320	.247	.219	.293	19	A
225	PURPLE	.336	.253	.225	.302	19	A
232	ORANGE	.343	.260	.23	.314	43	A
261	YELLOW	.377	.292	.261	.347	41	A
275	NONE 1/	.396	.316	.275	.356	39	A
281	PURPLE	.414	.322	.281	.374	35	A
287	BLUE	.410	.325	.287	.372	35	A
297	GREEN	.418	.340	.297	.376	35	A
312	YELLOW	.454	.353	.312	.409	47	A
327	NONE 1/	.476	.368	.327	.436	23	A
348	ORANGE	.483	.389	.348	.453	23	A
359	PURPLE	.492	.397	.359	.454	23	A
375	YELLOW	.499	.416	.375	.459	49	A
405	RED	.553	.446	.405	.513	51	A
415	BLUE	.558	.456	.415	.518	51	A
460	NONE 1/	.604	.501	.460	.568	51	A
500	GREEN	.640	.541	.500	.620	27	A

1/ NO COLOR ADDED TO THE SLEEVE

6. QUALIFICATION:

- QUALIFICATION NOT REQUIRED. QUALITY CONFORMANCE DATA IS REQUIRED TO BE SUBMITTED WITH EACH PROCUREMENT UNLESS WAIVED BY THE PURCHASER.

	<b>AEROSPACE STANDARD</b>	<b>AS18121™</b> SHEET 2 OF 3	<b>REV.</b> <b>B</b>
	(R) FERRULES, OUTER, INSULATED, SHIELD TERMINATING, TYPE II TWO-PIECE, CLASS I, FOR SHIELDED CABLE		