

REV.
B

SAE AS5768/1

RATIONALE

FEDERAL SUPPLY CLASS
5120

REVISION IS REQUIRED TO INCORPORATE THE OUTSTANDING AMENDMENT PER SAE GUIDELINES AND CORRECT THE AMENDMENT ERRORS WHICH OMITTED THE SIZE 20 WIRE CAVITY AND INCORRECTLY LISTED THE "A" DIAMETER FOR THE SIZE 16 AT .058 INSTEAD OF .056.

NOTICE

THE REQUIREMENTS FOR PROCURING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE LATEST ISSUE OF: SAE AS5768.

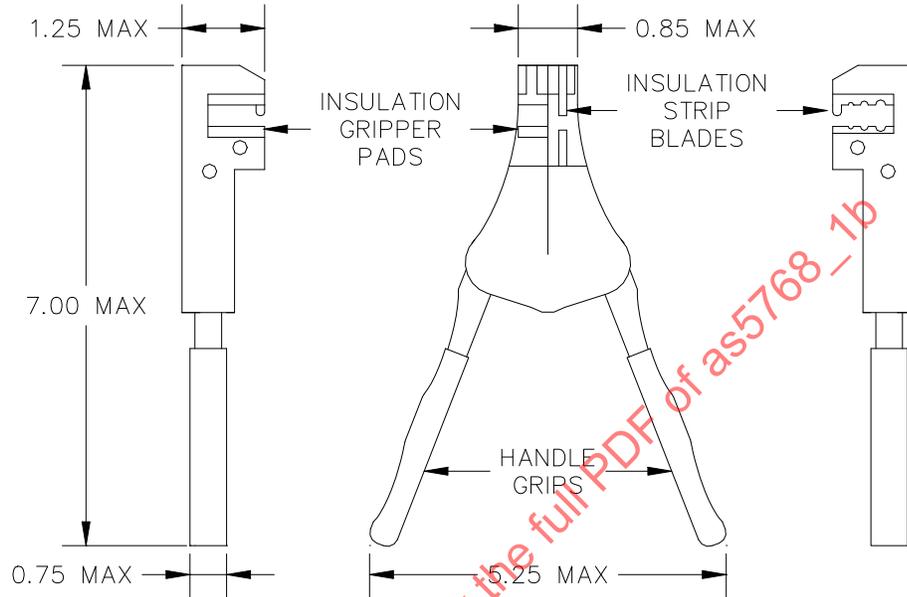


FIGURE 1 – STRIPPER TOOL ASSEMBLY WITH BLADES AND PADS ATTACHED

NOTE: LOCATION OF TOOL PART NUMBER AND APPLICABLE WIRE SPECIFICATIONS LISTING IS OPTIONAL (SEE TABLE 1)

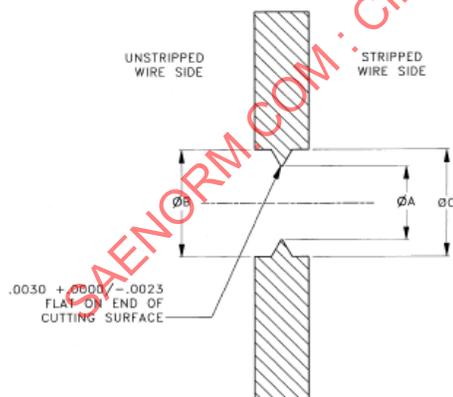


FIGURE 2- BLADE DIES (SEE TABLE 2 AND AS5768)

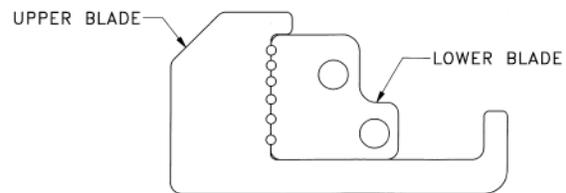
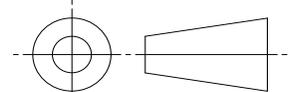


FIGURE 3- BLADE ASSEMBLY

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS5768/1B>

THIRD ANGLE PROJECTION



CUSTODIAN: AE-8/AE-8C2

PROCUREMENT SPECIFICATION: AS5768

SAE Aerospace
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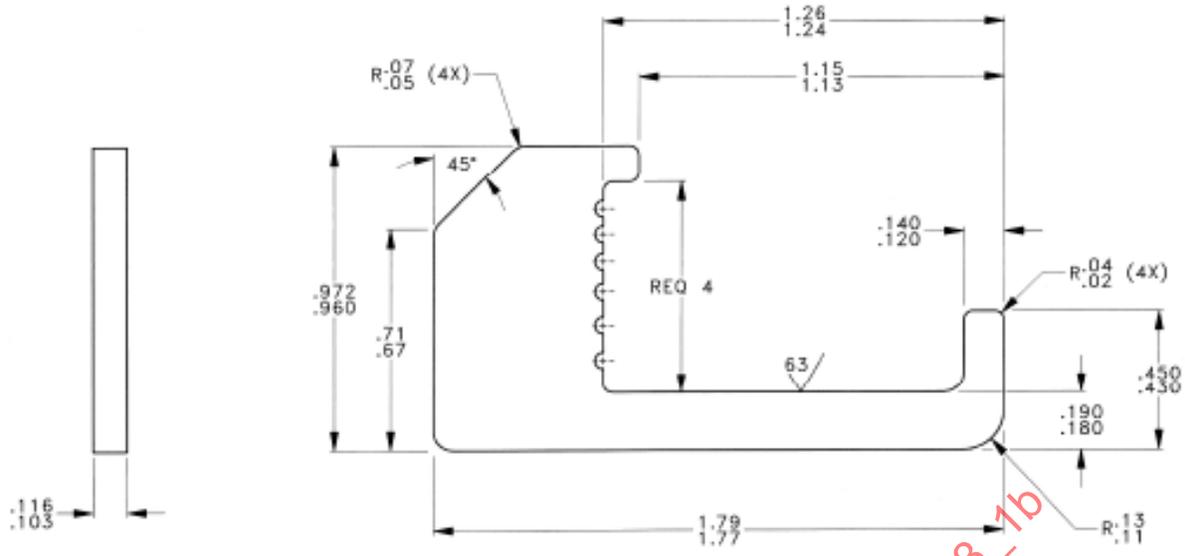
AEROSPACE STANDARD

TOOL, STRIPPER, MANUALLY ACTUATED,
ELECTRICAL INSULATION, ROUND WIRE,
SIZE 10 TO 30

SAE AS5768/1
SHEET 1 OF 7

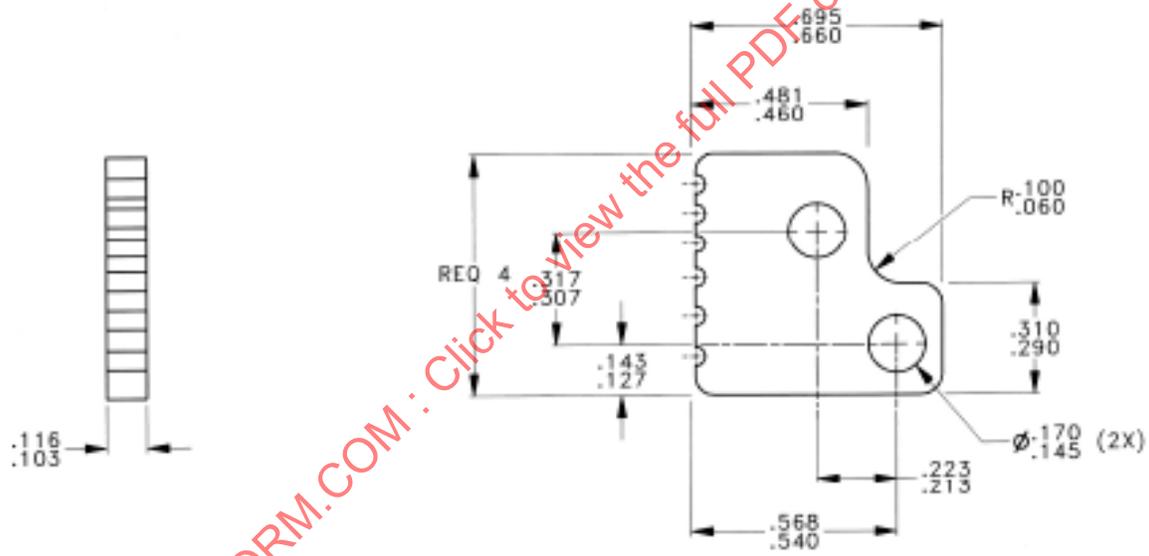
REV. B

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NOTE: BLADE PART NUMBER TO BE MARKED ABOVE THE WIRE CAVITIES (SEE TABLE 2)

UPPER BLADE DIMENSIONS



NOTE: CAVITY WIRE SIZE SHALL BE MARKED UNDER EACH CAVITY (SEE TABLE 2)

LOWER BLADE DIMENSIONS

(UPPER BLADE MUST BE .004 +.005 -.000 IN THINNER THAN LOWER BLADE FINAL THICKNESS)

FIGURE 4 – UPPER AND LOWER BLADE ASSEMBLY DIMENSIONS (SEE TABLE 2)

 An SAE International Group	AEROSPACE STANDARD	SAE AS5768/1 SHEET 2 OF 7	REV. B
	TOOL, STRIPPER, MANUALLY ACTUATED, ELECTRICAL INSULATION, ROUND WIRE, SIZE 10 TO 30		

TABLE 1 - TOOL ASSEMBLY WITH BLADES AND PADS ATTACHED (SEE FIGURES 2 THRU 4)

TOOL PART NUMBER AS5768/1-T	BLADE PART NUMBER AS5768/1-B	WIRE TYPE	WIRE SIZE CAVITIES
1	1	AS50861/1, /2, /4-/7	10-14
2	2	AS50861/1, /2, /4-/7	16-22
3	3	AS22759/5, /6	16-22
4	4	AS22759/7, /8	16-22
5	5	AS22759/9-/12, /16, /17, /20-/23, /28-/35, /41-/46, AS81044/11-/13, AS85485/9-/12, MIL-DTL-81381/3, /4,	10-14
6	6	AS22759/9-/12, /20-/23, /28-/31	16-26
7	7	AS22759/9-/12, 20-/23, /28-/35, /41-/43, AS81044/7-/14, /21, /22, MIL-DTL-81381/3, /4, /7-/14, /21, /22	26-30
8	8	AS22759/11, /12, /16, /17, MIL-DTL-81381/11-/14, /22	16-26
9	9	AS22759/16, /17, /32-/35, /41-/46	16-26
10	10	AS22759/18, /19, MIL-DTL-81381/1, /2, /5-/10, /21	16-26
11	11	AS22759/18, /19, MIL-DTL-81381/11-/14, /22	10-14
12	12	AS22759/80-/82, /91, /92	10-14
13	13	AS22759/80-/82, /91, /92	16-24
14	14	AS22759/83-/90	10-14
15	15	AS22759/83-/90	16-26
16	16	AS81044/5-/7	10-14
17	17	AS81044/5-/7	16-26
18	18	AS81044/8-/10	10-14
19	19	AS81044/8-10	16-26
20	20	AS81044/11-/13 AS85485/9-/12 MIL-DTL-81381/3, /4	16-26
21	21	MIL-DTL-81381/1, /2, /5-/10, /17-/21	10-14
22	22	MIL-DTL-81381/17-/20	16-26
23	23	AS85485/5-/8	10-14
24	24	AS85485/5-/8	16-26

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TABLE 2 - BLADE DIE DIMENSIONS FOR APPLICABLE TOOL ASSEMBLY (SEE FIGURE 2)

BLADE PART NUMBER AS5768/1-B	TOOL PART NUMBER AS5768/1-T	DIA ØA ± .001	DIA ØB ±.002	DIA ØC ± .002	WIRE TYPE	WIRE SIZE CAVITY 1/ 10
1	1	0.128	0.182	0.182	AS50861/1, /2, /4-7	10
		0.100	0.136	0.136		12
		0.076	0.118	0.118		14
2	2	0.064	0.098	0.098	AS50861/1, /2, /4-7	16
		0.055	0.088	0.088		18
		0.044	0.077	0.077		20
		0.036	0.068	0.068		22
3	3	0.063	0.110	.110	AS22759/5, /6	16
		0.058	0.100	.100		18
		0.047	0.090	.090		20
		0.039	0.080	.080		22
4	4	0.063	0.102	.102	AS22759/7, /8	16
		0.058	0.092	.092		18
		0.047	0.082	.082		20
		0.039	0.073	.073		22
5	5	0.112	0.143	0.143	AS22759/9-/12, /16, /17-/20-/23, /28-/35, /41-/46, AS81044/11-/13, AS85485/9-/12, MIL-DTL- 81381/3, /4,	10
		0.089	0.117	0.117		12
		0.073	0.100	0.100		14
6	6	0.061	0.081	0.081	AS22759/9-/12, /20-/23, /28-/31	16
		0.052	0.070	0.070		18
		0.042	0.0595	0.0595		20
		0.034	0.052	0.052		22
		0.028	0.043	0.043		24
7	7	0.023	0.039	0.039	AS22759/9-/12, 20-/23, /28-/31, /34, /35, /41-/43, AS81044/7-/14, /21, /22, MIL-DTL-81381/3, /4, /7-/14, /21, /22	26
		0.019	0.035	0.035		28
		0.016	0.032	0.032		30
		0.057	0.073	0.073		16
		0.051	0.067	0.067		18
8	8	0.041	0.057	0.057	AS22759/11, /12, /16, /17, MIL-DTL-81381/11-/14, /22	20
		0.033	0.049	0.049		22
		0.027	0.043	0.043		24
		0.022	0.038	0.038		26
		0.057	0.083	0.083		16
9	9	0.050	0.074	0.074	AS22759/16, /17, /32-/35, /41-/46	18
		0.040	0.063	0.063		20
		0.032	0.055	0.055		22
		0.026	0.048	0.048		24
		0.021	0.043	0.043		26
10	10	0.057	0.069	0.069	AS22759/18, /19, MIL-DTL-81381/1, /2, /5-/10, /21	16
		0.051	0.063	0.063		18
		0.041	0.053	0.053		20
		0.033	0.045	0.045		22
		0.027	0.039	0.039		24
11	11	0.112	0.128	0.128	AS22759/18, /19, MIL-DTL-81381/11-/14, /22	10
		0.089	0.105	0.105		12
		0.069	0.085	0.085		14
12	12	0.110	0.126	0.126	AS22759/80-/82, /91, /92	10
		0.0866	0.104	0.104		12
		0.0689	0.083	0.083		14

TABLE 2 - BLADE DIE DIMENSIONS FOR APPLICABLE TOOL ASSEMBLY (SEE FIGURE 2) (CONTINUED)

BLADE PART NUMBER AS5768/1-B	TOOL PART NUMBER AS5768/1-T	DIA ØA ± .001	DIA ØB ± .002	DIA ØC ± .002	WIRE TYPE	WIRE SIZE CAVITY 1/
13	13	0.055	0.070	0.070	AS22759/80-/82, /91, /92	16
		0.0492	0.061	0.061		18
		0.0394	0.051	0.051		20
		0.031	0.043	0.043		22
		0.025	0.038	0.038		24
14	14	0.110	0.130	0.130	AS22759/83-/90	10
		0.0866	0.108	0.108		12
		0.0689	0.086	0.086		14
15	15	0.055	0.074	0.074	AS22759/83-/90	16
		0.0492	0.0669	0.0669		18
		0.0394	0.057	0.057		20
		0.0312	0.048	0.048		22
		0.0256	0.042	0.042		24
		0.0204	0.038	0.038		26
16	16	0.116	0.154	0.154	AS81044/5-/7	10
		0.0937	0.136	0.136		12
		0.0760	0.113	0.113		14
17	17	0.062	0.096	0.096	AS81044/5-/7	16
		0.0520	0.086	0.086		18
		0.0420	0.073	0.073		20
		0.035	0.0635	0.0635		22
		0.0292	0.0595	0.0595		24
		0.022	0.052	0.052		26
18	18	0.119	0.144	0.144	AS81044/8-/10	10
		0.0960	0.125	0.125		12
		0.0760	0.104	0.104		14
19	19	0.061	0.089	0.089	AS81044/8-/10	16
		0.052	0.0785	0.0785		18
		0.042	0.067	0.067		20
		0.034	0.0595	0.0595		22
		0.028	0.055	0.055		24
		0.023	0.0465	0.0465		26
20	20	0.058	0.083	0.083	AS81044/11-/13 AS85485/9-/12	16
		0.052	0.074	0.074		18
		0.042	0.063	0.063		20
		0.034	0.055	0.055		22
		0.028	0.048	0.048		24
		0.023	0.043	0.043		26
21	21	0.112	0.124	0.124	MIL-DTL-81381/1, /2, /5-/10, /17-/21	10
		0.0890	0.101	0.101		12
		0.0690	0.081	0.081		14
22	22	0.0560	0.067	0.067	MIL-DTL-81381/17-/20	16
		0.0497	0.0607	0.0607		18
		0.0399	0.0509	0.0509		20
		0.0316	0.0426	0.0426		22
		0.0252	0.0362	0.0362		24
		0.0204	0.0314	0.0314		26
23	23	0.114	0.156	0.156	AS85485/5-/8	10
		0.0900	0.132	0.132		12
		0.0720	0.105	0.105		14
24	24	0.056	0.090	0.090	AS85485/5-/8	16
		0.051	0.082	0.082		18
		0.040	0.072	0.072		20
		0.048	0.064	0.064		22 (1) 2/
		0.032	0.064	0.064		22 (2) 2/
		0.026	0.055	0.055		24

1/ DEPICTS THE NUMBER OF WIRE CAVITIES FOR EACH BLADE PART NUMBER (I.E., AS5768/1-B1 STRIPS 3 WIRE SIZES 10, 12, 14) AND DEPICTS DIE DIMENSIONS PER CAVITY FOR 10, 12, 14.

2/ TWO STEP STRIP PROCESS REQUIRED. STEP (1) SIZE 22 OUTER INSULATION LAYER SHALL BE STRIPPED FIRST FOLLOWED BY STEP (2) STRIPPING THE INTER INSULATION. BLADE CAVITIES SHALL BE MARKED AS SHOWN.