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REV. E
AS7928™/6

FEDERAL SUPPLY CLASS
5970

RATIONALE

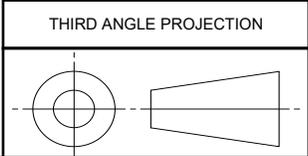
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CUSTODIAN: AE-8C2		PROCUREMENT SPECIFICATION: AS7928	
	AEROSPACE STANDARD		AS7928™/6
	SPLICES, CONDUCTOR, CRIMP STYLE, ELECTRIC (PERMANENT, TYPE II, CLASS 1) FOR 150 °C TOTAL CONDUCTOR TEMPERATURE		

ISSUED 1999-04 REVISED 2022-07 STABILIZED 2022-11

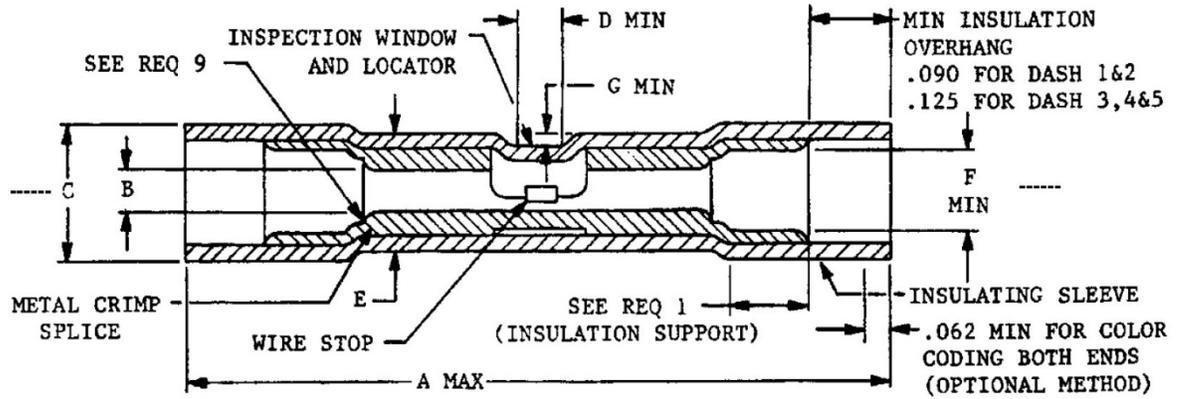


FIGURE 1 - AS7928/6 SPLICE

TABLE 1 - AS7928/6 DIMENSIONS

DASH NO.	WIRE RANGE	A MAX	BØ 1/	CØ 1/	D MIN	E	FØ 1/ MIN	G MIN	COLOR IDENTIFICATION
-1	26-24	.890 (22.6)	.033/.027 (0.84/0.69)	.160/.125 (4.07/3.18)	.060 (1.52)	.150/.125 (3.81/3.18)	.070 (1.78)	.025 (0.64)	YELLOW
-2	24-20	1.035 (26.29)	.055/.043 (1.40/1.09)	.170/.135 (4.32/3.43)	.060 (1.52)	.165/.135 (4.19/3.43)	.100 (2.54)	.030 (0.76)	WHITE
-3	22-18	1.300 (33.02)	.073/.052 (1.85/1.32)	.220/.160 (5.59/4.07)	.080 (2.03)	.210/.160 (5.33/4.07)	.110 (2.79)	.050 (1.27)	RED
-4	16-14	1.300 (33.02)	.095/.081 (2.41/2.06)	.260/.180 (6.60/4.57)	.080 (2.03)	.250/.180 (6.35/4.57)	.140 (3.56)	.050 (1.27)	BLUE
-5	12-10	1.700 (43.18)	.139/.129 (3.53/3.28)	.320/.250 (8.13/6.35)	.110 (2.79)	.300/.250 (7.62/6.35)	.200 (5.08)	.050 (1.27)	YELLOW

1/ DIAMETERS ARE THE SAME ON BOTH ENDS OF THE SPLICE.

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REQUIREMENTS: ALL REQUIREMENTS SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF AS7928.

1. MIN CABLE INSULATION SUPPORT: .060 FOR DASH 1 AND 2
.094 FOR DASH 3, 4, AND 5
2. MATERIAL: COPPER (SEE ACQUISITION SPECIFICATION) OR COPPER ALLOY. MATERIAL SHALL HAVE ADEQUATE ELECTRICAL CONDUCTIVITY AND SHALL BE SUFFICIENTLY STRONG TO RESIST CRACKING AFTER FORMING AND CRIMPING.
3. INSULATING SLEEVE: REFER TO AS7928.
4. FINISH: METAL, TIN PLATED: REFER TO AS7928.
5. COLOR IDENTIFICATION: INSULATION SHALL BE THE NATURAL MATERIAL COLOR AND TRANSPARENT:
 - a. COLOR STRIPES: LONGITUDINAL COLOR STRIPES (2 OR MORE) .062 WIDE PER TABLE 1 SHALL BE ADDED UNDER THE INSULATION. STRIPES SHALL RUN THE LENGTH OF THE TUBE. THE STRIPES MUST EXTEND TO WITHIN 1/16 INCH OF THE ENDS OF THE INSULATION.
 - b. COLOR RINGS (OPTIONAL METHOD): A COLOR RING, .062 WIDE ON EACH END OF TUBE, PER TABLE 1 SHALL BE ADDED. THE RINGS MUST COVER A MINIMUM OF 315° OF THE CIRCUMFERENCE.
6. DIMENSIONS ARE IN INCHES AND SHALL BE AS SPECIFIED IN TABLE 1 AND FIGURE 1. DIMENSION B SHALL BE DETERMINED AS THE AVERAGE OF TWO DIAMETERS MEASURED IN TWO PLACES VERTICALLY AND HORIZONTALLY OR MEASURED IN TWO LOCATIONS 90° APART. METRIC UNITS SHOWN IN PARENTHESES IS BASED ON 25.4 MM PER INCH. IN THE EVENT OF A CONFLICT, ENGLISH UNITS TAKE PRECEDENCE.
7. THE INSPECTION WINDOW AND LOCATOR SHALL PROVIDE A POSITIVE MEANS OF POSITIONING SPLICE IN THE APPLICABLE CRIMPING TOOL AND PROVIDE VISIBLE INSPECTION OF STRIPPED WIRE ENDS.
8. CRIMPING TOOLS: CRIMPING TOOLS FOR THE AS7928/6 SPLICES SHALL BE AS SPECIFIED IN TABLE 2.

TABLE 2 - AS7928/6 CRIMP TOOLS

PART NUMBER	WIRE RANGE	CRIMP TOOL	TOOL DIE	DIE COLOR DESIGNATION
M7928/6-1	26-24	M22520/5-01	M22520/5-101	WHITE
		M22520/10-01	M22520/10-102	
M7928/6-2	24-20	M22520/5-01	M22520/5-101	
		M22520/10-01	M22520/10-102	
M7928/6-3	22-18	M22520/5-01	M22520/5-101 (WIRE SIZE 22-20 ONLY)	
			M22520/5-106	
		M22520/10-01	M22520/10-101	WHITE
M7928/6-4	16-14	M22520/5-01	M22520/5-107	BLUE
		M22520/10-01	M22520/10-101	WHITE
M7928/6-5	12-10	M22520/5-01	M22520/5-108	YELLOW
		M22520/10	M22520/10-100	
		M22520/41-01 FIX DIE TOOL	N/A	N/A

9. INSULATION SUPPORT AND WIRE METAL CRIMP SPLICE MAY BE MULTIPLE PIECE CONSTRUCTION. CONTOUR MAY VARY FROM THAT SHOWN, WITHIN SPECIFIED DIMENSIONS, BUT WIRE LEAD-IN TO WIRE BARREL SHALL BE PROVIDED.
10. FOR QUALIFICATION, SPLICES SHALL BE TESTED WITH AS22759/87 WIRE (SIZES 26 THROUGH 10) OR AN EQUIVALENT WIRE WITH AS29606 TYPE NCC SMALL DIAMETER NICKEL COATED COPPER CONDUCTOR.
11. FLATTENING OF INSULATION SLEEVE TO FORM LOCATOR MAY CAUSE THE SLEEVE TO EXCEED THE E DIMENSION BY .050 MAX IN THE LOCATOR AREA.
12. PART NUMBER: CONSISTS OF THE LETTER "M," THE BASIC NUMBER OF THIS SPECIFICATION SHEET, AND A DASH NUMBER SPECIFIED IN TABLE 1.

EXAMPLE: M7928/6-1 SPLICE FOR 26-24 WIRE RANGE.

	AEROSPACE STANDARD	AS7928™/6 SHEET 2 OF 3	REV. E
	SPLICES, CONDUCTOR, CRIMP STYLE, ELECTRIC (PERMANENT, TYPE II, CLASS 1) FOR 150 °C TOTAL CONDUCTOR TEMPERATURE		