

REV.  
A

AS81306/2

FEDERAL SUPPLY CLASS  
5120

RATIONALE

CORRECT TENSION DESIGNATOR INFORMATION AND DIMENSION TOLERANCE TO BAND ENTRY SLOT.

NOTICE

THE COMPLETE REQUIREMENTS FOR PROCURING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF AS81306.

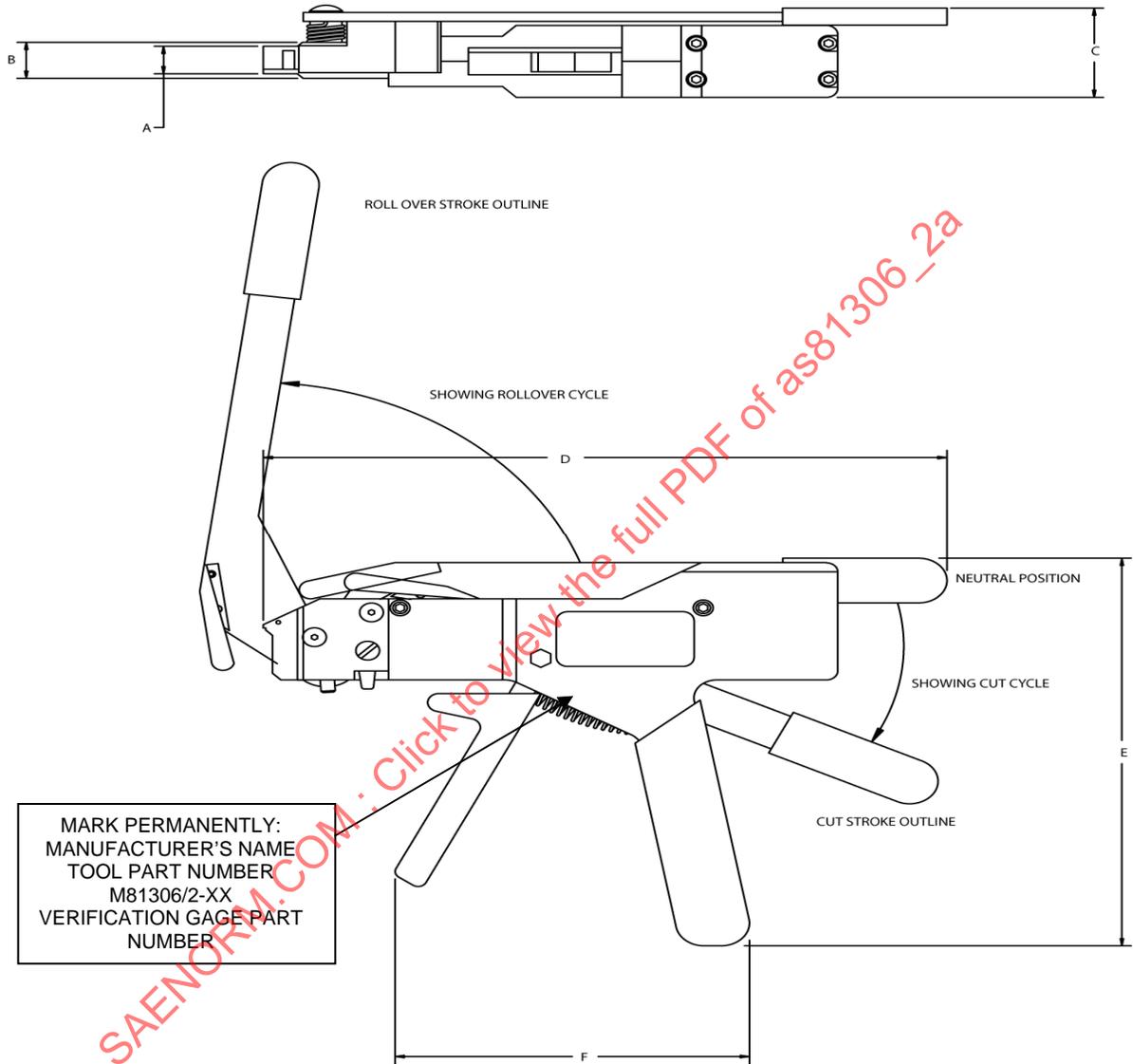
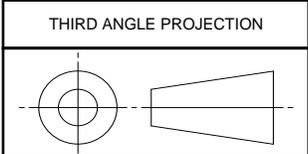


FIGURE 1 - DIMENSIONS AND CONFIGURATION

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS81306/2A>



CUSTODIAN: AE-8/AE-8C2

PROCUREMENT SPECIFICATION: AS81306



**AEROSPACE STANDARD**

BAND INSTALLATION TOOL, HAND, TWO STEP  
TERMINAL, FOR AS85049/128 CONNECTOR  
ACCESSORY CABLE SHIELD TERMINATION BANDS

AS81306/2  
SHEET 1 OF 5

REV.  
A

SAE Technical Standards Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user." SAE reviews each technical report at least every five years at which time it may be revised, reaffirmed, stabilized, or cancelled. SAE invites your written comments and suggestions.

ISSUED 2012-08 REVISED 2014-01

TABLE 1 - FIGURE 1 DIMENSIONS

DASH NO.	A ±.003	B MAX	C MAX	D MAX	E MAX	F MAX	USED TO TERMINATE M85049/128-* BANDS
01	.400	.525	1.375	7.625	6.500	4.500	-1 & -2
02							-5 & -6

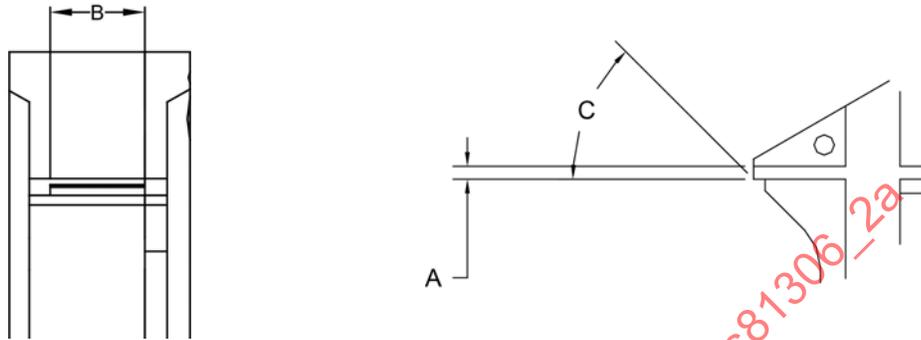


FIGURE 2 - NOSE DETAIL

TABLE 2 - DIMENSIONS FOR FIGURE 2

DASH NO.	A +.002 -.001	B MIN	C ANGLE
01	.030	.256	45°
02	.023	.129	45°

MATERIAL: TOOL STEEL OR EQUIVALENT  
HARDNESS: HRC 35-40 MIN  
FINISH: BLACK OXIDE, OR TREAT TO RESIST CORROSION

SAENORM.COM : Click to view the full PDF of as81306-2a

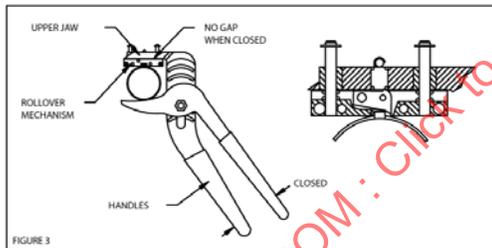
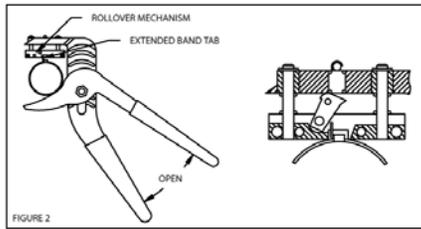
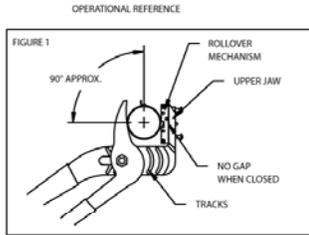
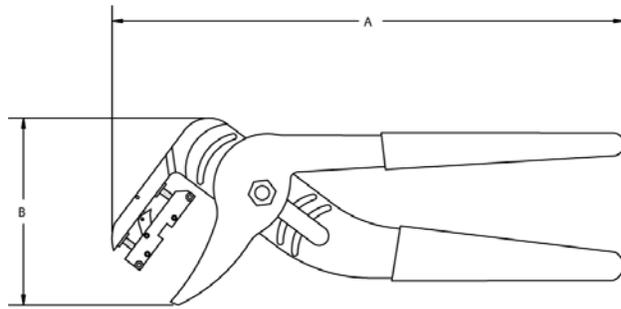


TABLE 3 - DIMENSIONS AND MARKING REQUIREMENTS FOR BAND ROLLOVER TOOL

DASH NO.	A MAX	B MAX
01	9.00	4.00
02		
MARK PERMANENTLY: MANUFACTURER'S NAME AND PART NUMBER (LOCATION OPTIONAL)		

FIGURE 3 - BAND ROLLOVER TOOL

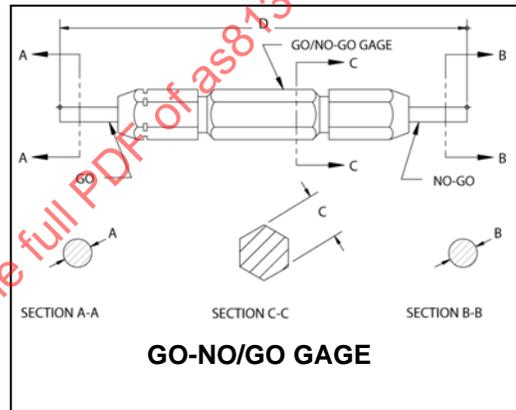
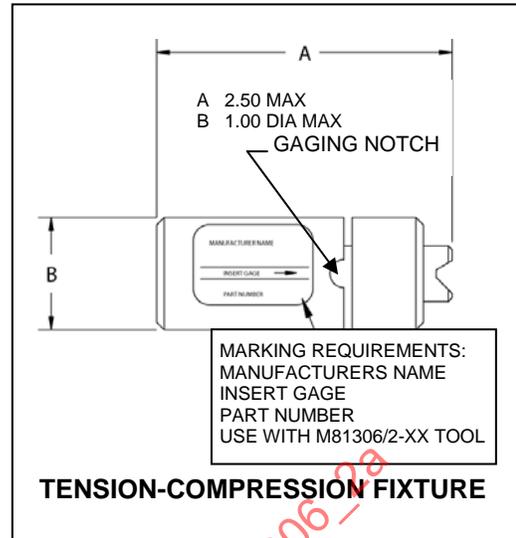


TABLE 4 - DIMENSIONS FOR GO-NO/GO GAGE

FOR AS81306/2 DASH NUMBER (SEE TABLE 6)	A DIA. +.0002 -.0000	B DIA. +.0000 -.0002	C MAX DIM	D (REF) DIM
-01E	.1230	.1270	.500	3.5
-02F	.1110	.1270		

FIGURE 4 - TENSION-COMPRESSION FIXTURE & GO-NO/GO GAGE

TABLE 5 - TOOL SET DESCRIPTION

DASH NO.	DESCRIPTION
01	TOOL SET CONSISTING OF THE BAND INSTALLATION TOOL, BAND ROLLOVER TOOL, FOR TERMINATING M85049/128-1 & -2 .250 WIDTH BANDS.
02	TOOL SET CONSISTING OF THE BAND INSTALLATION TOOL, BAND ROLLOVER TOOL, FOR TERMINATING M85049/128-5 & -6 .125 WIDTH BANDS.

TABLE 6 - COMPONENT REPLACEMENT PROCUREMENT INFORMATION

LETTER DESIGNATOR	DESCRIPTION
A	M81306/2-01 BAND INSTALLATION TOOL ONLY FOR USE WITH M85049/128-1 AND -2 BANDS
B	M81306/2-02 BAND INSTALLATION TOOL ONLY FOR USE WITH M85049/128-5 AND -6 BANDS
C	ROLLOVER TOOL ONLY FOR USE WITH THE M81306/2-01 BAND INSTALLATION TOOL.
D	ROLLOVER TOOL ONLY FOR USE WITH THE M81306/2-02 BAND INSTALLATION TOOL.
E	TENSION-COMPRESSION FIXTURE AND GO-NO/GO GAGE ONLY FOR USE WITH THE M81306/2-01 BAND INSTALLATION TOOL.
F	TENSION-COMPRESSION FIXTURE AND GO-NO/GO GAGE ONLY FOR USE WITH THE M81306/2-02 BAND INSTALLATION TOOL.

NOTES:

1. DIMENSIONS ARE IN INCHES.
2. UNLESS OTHERWISE SPECIFIED, TOLERANCES SHALL BE: .XX = ±.03; .XXX = ±.015; X DEGREE = ±2 DEGREES
3. METRIC EQUIVALENTS ARE GIVEN FOR GENERAL INFORMATION ONLY AND ARE BASED ON 25.4 MM = 1 INCH.
4. MILLIMETERS ARE IN PARENTHESES.

REQUIREMENTS IN ACCORDANCE WITH AS81306 AND THIS SPECIFICATION:

DESIGN AND CONSTRUCTION:

1. DIMENSIONS AND CONFIGURATION: SEE FIGURES 1 THRU 4 AND TABLES 1 THRU 4.
2. TOOL SHALL HAVE NO SHARP EDGES, OR SHARP CORNERS.
3. THE WEIGHT OF THE TOOL SHALL NOT EXCEED 2 POUNDS.
4. THE RANGE OF TOOLS DEFINED IN THIS STANDARD SHALL BE DESIGNED TO TERMINATE AS85049/128-\*\* BANDS (SEE APPLICATION NOTE 1) WITHOUT THE USE OF OTHER TOOLS TO COMPLETE THE CONNECTOR ACCESSORY BAND TERMINATION PROCESS.
5. THE OPERATION HANDLE SHALL BE CONFIGURED TO RETURN THE HANDLE TO THE OPEN POSITION EACH TIME PRESSURE IS RELEASED WHILE BAND TENSION IS BEING GAINED. THE SAME HANDLE SHALL BE DESIGNED SO IT LATCHES IN THE CLOSED POSITION WHEN THE PRESET TENSION IS ACHIEVED.
6. THE ROLLOVER/CUTOFF HANDLE SHALL BE EASILY ACCESSIBLE TO THE USER, AND SHALL BEND THE BAND AT THE EXIT POINT WHILE UNDER THE PRESET TENSION BY RAISING THE HANDLE (SEE FIGURE 1). THE SAME HANDLE SHALL CUT THE BAND COMPLETELY AND SMOOTHLY WHEN LOWERING THE HANDLE AS SHOWN IN FIGURE 1.

	<b>AEROSPACE STANDARD</b>	<b>AS81306/2</b> SHEET 4 OF 5	<b>REV.</b> <b>A</b>
	BAND INSTALLATION TOOL, HAND, TWO STEP TERMINAL, FOR AS85049/128 CONNECTOR ACCESSORY CABLE SHIELD TERMINATION BANDS		