

RATIONALE

AS81969/19 PERMITS THE CANCELLATION AND SUPERSESION OF MIL-I-81969/19 WITH THIS DOCUMENT. IT INCLUDES ENGINEERING POSITION LETTERS, MILITARY SPECIFICATION AMENDMENTS, AND MINOR TECHNICAL CHANGES REQUIRED TO REFLECT THE APPROVED QUALIFIED TOOLS. GOVERNMENT DOCUMENTATION REFERENCES ARE REMOVED.

NOTICE

THE COMPLETE REQUIREMENTS FOR PROCURING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF AS81969.

**SAE AS81969/19**

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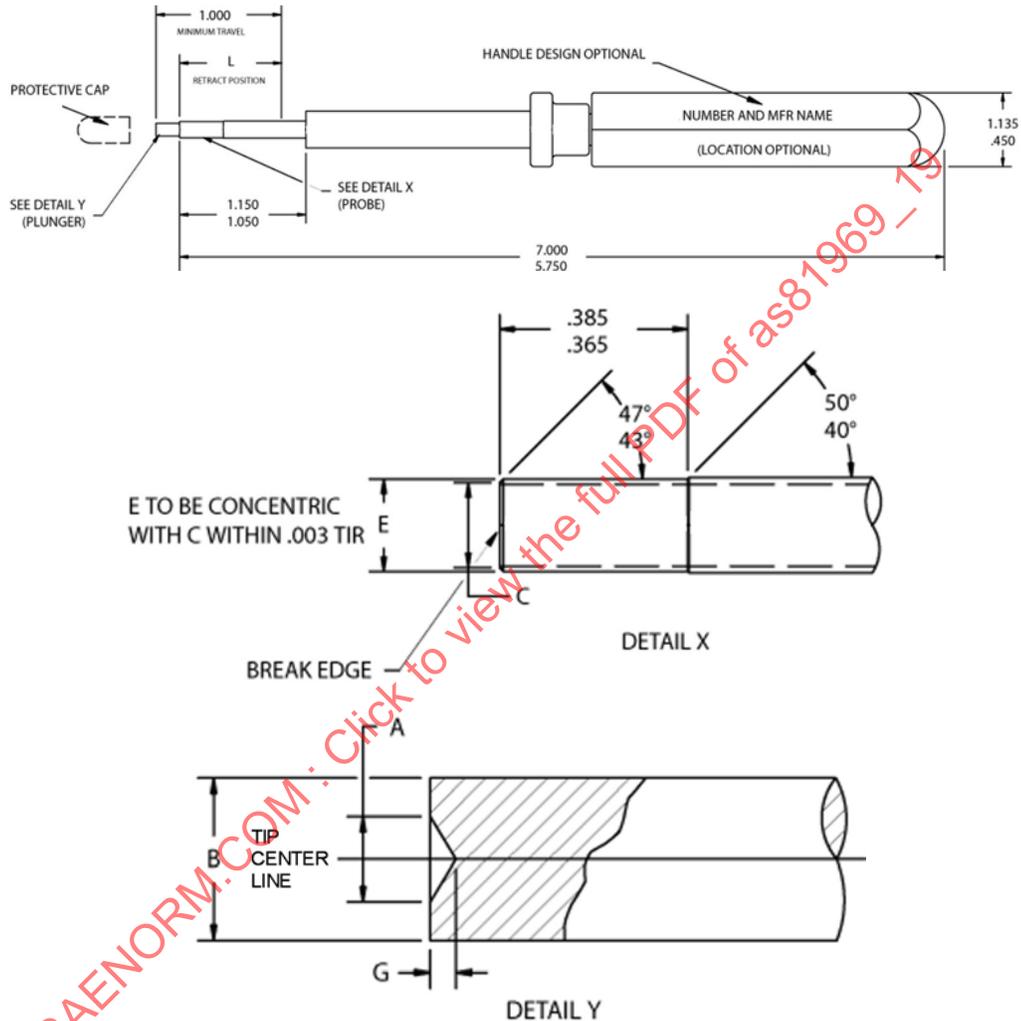
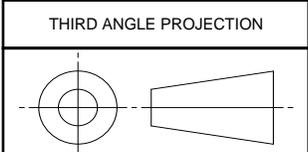


FIGURE 1 - REMOVAL TOOL -01 THRU -06

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CUSTODIAN: AE-8/AE-8C2

PROCUREMENT SPECIFICATION: AS81969

**SAE Aerospace**  
An SAE International Group

**AEROSPACE STANDARD**  
INSTALLING AND REMOVAL TOOLS, CONNECTOR  
ELECTRICAL CONTACT, TYPE II, CLASS 1,  
COMPOSITION C

**SAE AS81969/19**  
SHEET 1 OF 4

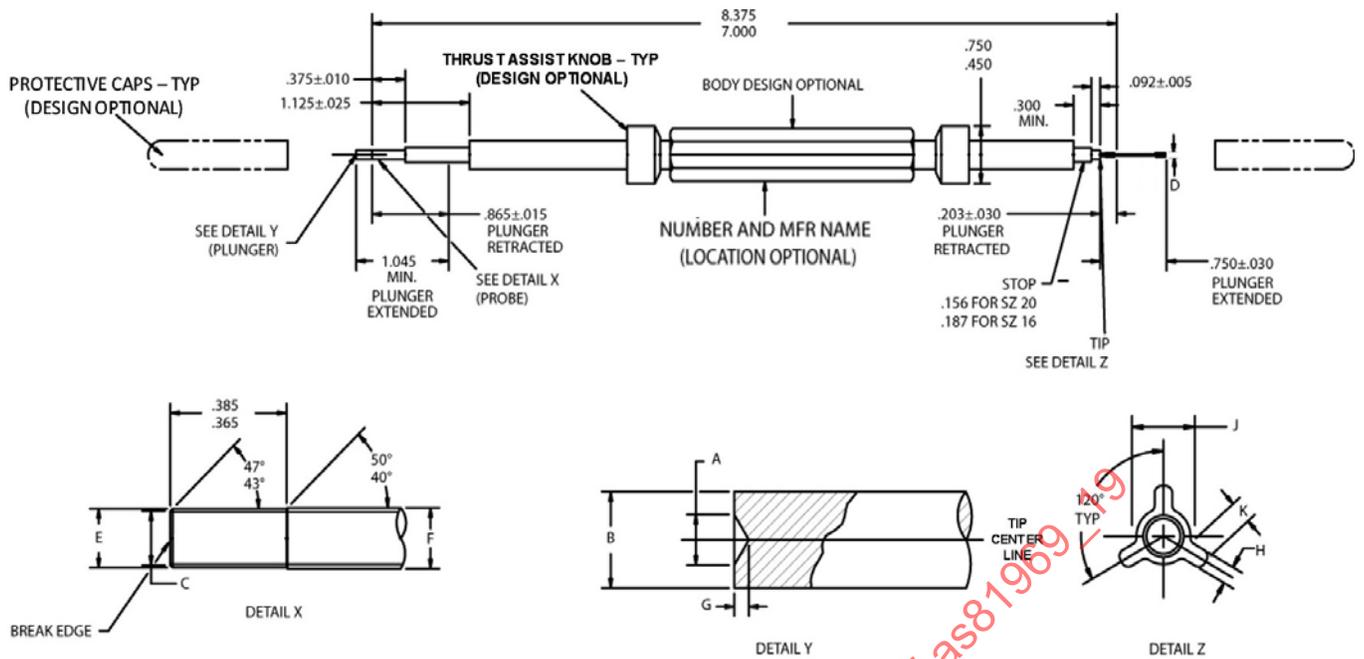


FIGURE 2 - REMOVAL TOOL -10 AND -11

TABLE 1 - REMOVAL TOOL -01 THRU -06 DIMENSIONS (SEE FIGURE 1)

DASH NUMBER	CONTACT SIZE	HANDLE COLOR	A DIA	B DIA	C DIA	E DIA	F DIA	G	L	SUPERSEDES PART NUMBERS
-01	16	BLUE	.064	.107	.116	.138	.144	.027	.880	M81969/19-08
			.050	.103	.114	.136	.140	.017	.850	MS90456-16
-02	12	YELLOW	.107	.155	.164	.185	.192	.035	.955	M81969/19-09
			.081	.151	.162	.183	.188	.025	.925	MS90456-12
-03	8	RED	.139	.247	.255	.282	.325	.051	1.000	MS90456-8
			.129	.243	.253	.280	.321	.041	.900	
-04	4	BLUE	.220	.330	.339	.360	.404	.076	.990	MS90456-4
			.210	.326	.337	.358	.400	.066	.850	
-05	0	YELLOW	.352	.512	.521	.542	.584	.113	.990	MS90456-0
			.342	.508	.519	.540	.580	.103	.850	
-06	20	RED	.047	.072	.081	.099	.107	.021	.880	M81969/19-07
			.030	.068	.079	.097	.103	.011	.850	MS90456-20

TABLE 2 - REMOVAL TOOL -10 AND -11 DIMENSIONS (FIGURE 2)

DASH NUMBER	CONTACT SIZE	HANDLE COLOR	A DIA	B DIA	C DIA	D DIA	E DIA	F DIA	G	H	J DIA	K	SUPERSEDES PART NUMBERS
-10	20	RED	.040	.072	.081	.041	.099	.107	.021	.016	.048	.034	MS24256RH20
			.030	.068	.079	.039	.097	.103	.011	.014	.038	.032	
-11	16	BLUE	.060	.107	.116	.063	.138	.144	.027	.026	.080	.034	MS24256RH16
			.050	.103	.114	.061	.136	.140	.017	.024	.070	.032	

REQUIREMENTS - ALL REQUIREMENTS SHALL CONSIST OF THIS DETAIL SPECIFICATION AND THE LATEST ISSUE OF AS81969.

1. CONFIGURATION:

TOOL CONFIGURATION SHALL BE IN ACCORDANCE WITH FIGURES 1 AND 2 AND TABLES 1 AND 2.

DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCE IS  $\pm 0.005$  ON THREE PLACE DECIMALS,  $\pm 0.01$  ON TWO PLACE DECIMALS AND  $\pm 4^\circ$ .

HANDLE CONFIGURATION OPTIONAL WITHIN MAXIMUM DIMENSIONS SHOWN.

EACH TOOL SHALL BE FURNISHED WITH A PROTECTIVE PROBE CAP. THE CAP DESIGN AND MATERIAL IS OPTIONAL (SEE APPLICATION NOTE).

TOOL KEYS ROTATE RADIALLY FOR -10 AND -11.

PLUNGER FORCE SHALL BE 1.5 POUND  $\pm 1$  POUND.

TOOL SHALL BE FREE FROM NICKS OR BURRS.

2. MATERIAL:

HANDLE SHALL BE ANODIZED ALUMINUM OR SHALL BE PLASTIC IN ACCORDANCE WITH ASTM D5948, ASTM D4673, OR APPROVED EQUIVALENT

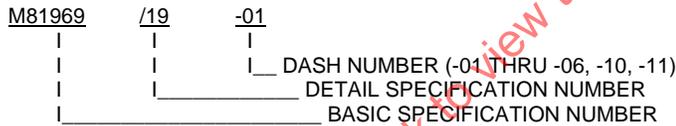
PLUNGER, PROBE AND KEYS SHALL BE STEEL TREATED TO RESIST CORROSION.

3. IDENTIFICATION MARKING:

EACH TOOL SHALL BE LEGIBLY AND PERMANENTLY MARKED ON TOOL HANDLE IN ACCORDANCE WITH MIL-STD-130 (LOCATION OPTIONAL). SUPPLIER SYMBOL, IF USED, SHALL BE IN ACCORDANCE WITH AIR1351.

MARKING SHALL INCLUDE MANUFACTURER NAME OR SYMBOL, MANUFACTURER PART NUMBER, AND AS81969/18 PIN.

4. PART IDENTIFICATION NUMBER (PIN):



APPLICATION NOTES:

- TOOLS SHALL BE USED TO INSTALL CONTACTS IN CONNECTORS SPECIFIED IN TABLE 3.

TABLE 3 - TOOL APPLICATION AND SUPERSEDING SPECIFICATIONS

PART NUMBER M81969/19	APPLICABLE CONNECTOR (CRIMP CONTACT) SPECIFICATIONS	SUPERSEDED TOOL SPECIFICATIONS
-01 THRU -06	AS50151 (AS34001- AS34121) AS81703 (SERIES 2) MIL-DTL-26482 (SERIES 1) MIL-DTL-26500 MIL-DTL-26518	MIL-I-81969/19 1/ MS25256L (USAF), DATED 19 MAY 1976. MS90456C (NAVY), DATED 1 AUGUST 1975 MIL-I-81969/19, DATED 2 AUGUST 1976.
-10, -11	MIL-C-38300	

1/ AS81969/19 SUPERSEDED MIL-I-81969 WITHOUT PART NUMBER CHANGE

- THE PROTECTIVE CAP (SEE FIGURE 1) MINIMIZES DAMAGE TO THE TIP AND IMPROVES PERSONNEL SAFETY. IF LOST, CONTACT THE SUPPLIER FOR REPLACEMENT.

 <small>An SAE International Group</small>	<b>AEROSPACE STANDARD</b>	 <b>SAE AS81969/19</b> SHEET 3 OF 4	
	INSTALLING AND REMOVAL TOOLS, CONNECTOR ELECTRICAL CONTACT, TYPE II, CLASS 1, COMPOSITION C		