

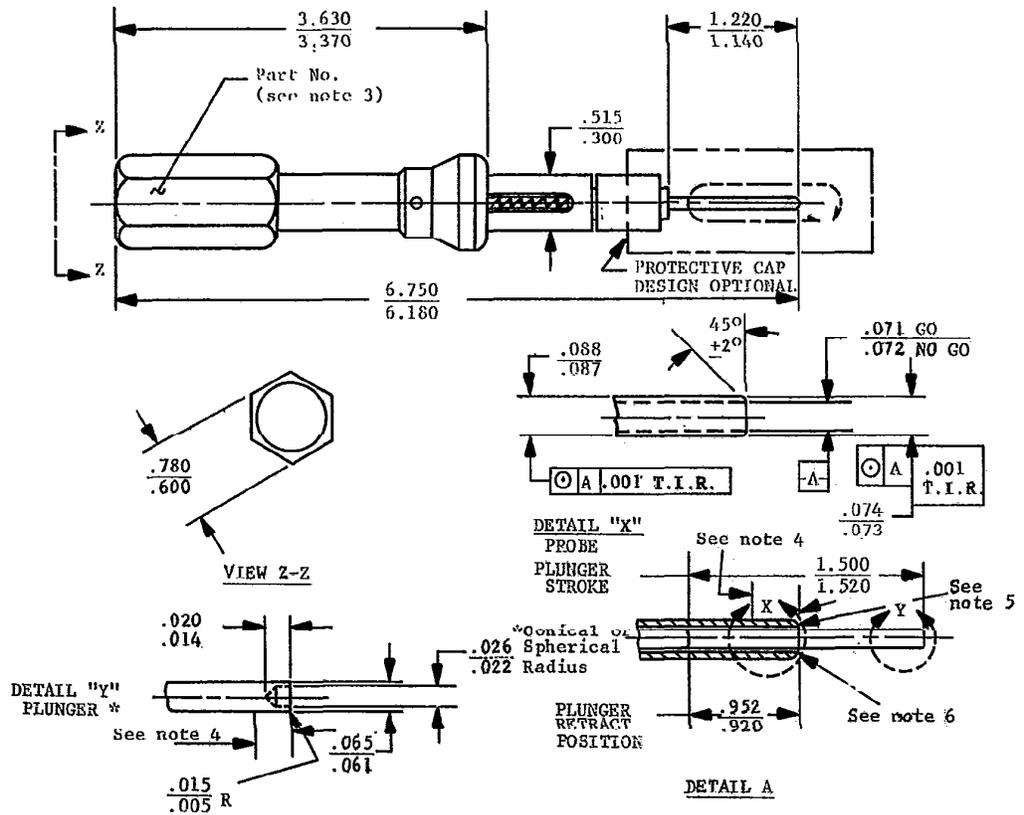
MIL-I-81969/34F(EC)
 7 September 1982
 SUPERSEDING
 MIL-I-81969/34E(EC)
 18 March 1982

MILITARY SPECIFICATION SHEET

INSTALLING AND REMOVAL TOOLS, CONNECTOR
 ELECTRICAL CONTACT, TYPE II, CLASS 1, COMPOSITION A
 (For Use On MIL-C-28840(EC) Connectors)

This specification sheet is approved for use by the Naval Electronic Systems Command, Department of the Navy, and is available for use by all Departments and Agencies of the Department of Defense.

The complete requirements for procuring the tools described herein shall consist of this document and the latest issue of specification MIL-I-81969.



Ⓣ FIGURE 1. Removal tool.

Ⓣ Denotes change

FSC 5120

INCHES	MM	INCHES	MM
.0002	.005	.300	7.62
.005	.13	.515	13.08
.014	.36	.600	15.24
.015	.38	.780	19.81
.020	.51	.920	23.37
.022	.56	.952	24.18
.026	.66	1.140	28.96
.061	1.55	1.220	30.99
.065	1.65	1.500	38.10
.071	1.80	1.520	38.61
.072	1.83	3.370	85.60
.073	1.85	3.630	92.20
.074	1.88	6.180	156.97
.087	2.21	6.750	171.45
.088	2.24		

NOTES:

1. Dimensions are in inches
2. Metric equivalents are given for general information only and are based upon 1 inch = 25.4 mm.
3. Each tool shall be legibly and permanently marked in accordance with MIL-STD-130.
4. Polish $\sqrt{32}$.100 inch minimum on O.D.
5. Polish $\sqrt{.001R}$
 $\sqrt{.002}$
6. Polish angle $\sqrt{32}$

(F) FIGURE 1. Removal tool. (Continued)

REQUIREMENTS:

Dimensions and configuration: See FIGURE 1.

Material:

Probe: Types 410 and 420 CRES heat-treated to Rockwell C48-52.
Plunger: Corrosion resistant metal (stainless steel).
Handle: Aluminum alloy.

Finish:

Probe: Polished, free from nicks and burrs.
Probe and plunger: Passivated QQ-P-35.
Handle: Not applicable, red anodized only.

Diameter:

$\sqrt{.071}$ Go Test with GO-NO-GO test pins having a tolerance of -.0000 to
 $\sqrt{.072}$ No Go +.0002. Tolerance applicable for .952 minimum length.

Tool tip:

Replaceable.

Plunger:

Spring loaded with a retract force of $1 \frac{1}{2} \pm 1$ pound.

Application:

These tools are used for the removal of removable contacts from connectors conforming to specification MIL-C-28840.

Part number:

M81969/34-01

QPL evaluating activity

Naval Weapons Support Center, Crane, Indiana 47522

Preparing activity:
Navy - EC
(Project 5120-NB19)