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REV.
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SAE AS27488

FEDERAL SUPPLY CLASS
5935

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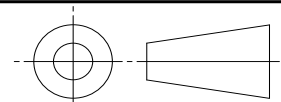
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THIRD ANGLE PROJECTION



CUSTODIAN: AE-8/AE-8C1

PROCUREMENT SPECIFICATION: MIL-DTL-5015

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

PLUG, END SEAL,
ELECTRICAL CONNECTOR

SAE AS27488
SHEET 1 OF 6

REV.
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ISSUED 2004-06 CANCELLED 2009-03

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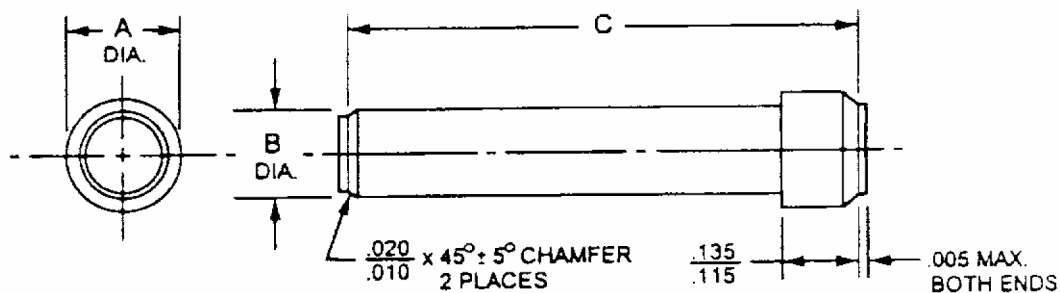


TABLE I. SEALING PLUG DIMENSIONS.

DASH NO.	COLOR CODE	A DIA.	B DIA.	C DIM.	CONNECTOR CONTACT SIZE (GROMMET CAVITY SIZE)
-22-1	BLACK	0.066 0.058	0.045 0.038	0.796 0.746	23-22
-20-1	RED	0.090 0.080	0.058 0.048	0.805 0.755	20
-16-1	BLUE	0.130 0.120	0.079 0.069	1.472 1.422	16
-12-1	YELLOW	0.170 0.160	0.125 0.115	1.441 1.391	12
-8-1	RED	0.315 0.305	0.175 0.165	1.189 1.139	8
-4-1	BLUE	0.414 0.404	0.283 0.273	1.189 1.139	4
-0-1	YELLOW	0.606 0.596	0.431 0.416	1.071 1.021	0

NOTE: DIMENSIONS ARE IN INCHES

TABLE II. METRIC EQUIVALENTS.

INCH	MILLIMETER	INCH	MILLIMETER	INCH	MILLIMETER	INCH	MILLIMETER
0.010	0.254	0.120	3.048	0.404	10.262	1.139	28.931
0.020	0.508	0.125	3.175	0.414	10.516	1.189	30.200
0.038	0.965	0.130	3.302	0.416	10.566	1.391	35.331
0.045	1.143	0.135	3.429	0.431	10.947	1.422	36.119
0.048	1.219	0.160	4.064	0.596	15.128	1.441	36.601
0.058	1.473	0.165	4.191	0.606	15.393	1.472	37.389
0.066	1.676	0.170	4.318	0.746	18.948		
0.069	1.753	0.175	4.445	0.755	19.177		
0.079	2.007	0.273	6.934	0.796	20.218		
0.080	2.032	0.283	7.188	0.805	20.447		
0.090	2.286	0.305	7.747	1.021	25.933		
0.115	2.921	0.315	8.001	1.071	27.203		

NOTE: METRIC EQUIVALENTS (TO THE NEAREST .001 MM) ARE GIVEN FOR GENERAL INFORMATION ONLY AND ARE BASED UPON 1 INCH = 25.4 MM.

REQUIREMENTS:

1. MIL-DTL-5015: 3.2 THROUGH 3.32 AND 4.1 THROUGH 4.6.25, NOT REQUIRED.
2. MATERIAL. PLASTIC ROD, MOLDED AND EXTRUDED - TEMPERATURE LIMIT 200 °C MINIMUM. THE MATERIAL USED TO FABRICATE SEALING PLUGS SHALL BE POLYTETRAFLUOROETHYLENE (PTFE) IN ACCORDANCE WITH ASTM-D1710, FLUORINATED ETHYLENE PROPYLENE (FEP) IN ACCORDANCE WITH ASTM-D2116, PERFLUOROALKOXY (PFA) IN ACCORDANCE WITH ASTM-D3307, OR POLYPHENYLSULFONE (PPSU) IN ACCORDANCE WITH ASTM-D6394.
3. COLOR. COLOR OF ITEMS SHALL BE IN ACCORDANCE WITH EIA-359.
4. RESISTIVITY. MATERIAL RESISTIVITY SHALL BE NOT LESS THAN 100 MEGOHMS WHEN TESTED IN ACCORDANCE WITH ASTM-D257.
5. INSTALLATION. WHEN INSTALLING SEALING PLUGS IN CONNECTOR OR MODULE GROMMETS, THE HEAD OF THE SEALING PLUG SHALL BE INSERTED FIRST. THE SEALING PLUG SHALL THEN BE PUSHED INTO THE GROMMET UNTIL THE HEAD IS POSITIONED AGAINST THE END OF THE UNWIRED CONTACT OR EMPTY GROMMET CAVITY. SEE NOTE 7 FOR ADDITIONAL INFORMATION REGARDING SEALING PLUG INSTALLATION AND NOTE 8 FOR INSTALLING TOOL GUIDANCE.
6. WORKMANSHIP. THE ITEM SHALL BE FREE FROM FLASH AND BURRS. THE LENGTH OF DIAMETER B SHALL BE FREE OF ALL MOLDING MARKS, PROTRUSIONS, AND BLEMISHES. MOLDING MARKS, PROTRUSIONS, AND BLEMISHES FROM GATE CUTOFFS ARE PERMISSIBLE BUT ONLY ON THE PLUG ENDS OR SIDE OF THE HEAD AND SHALL NOT BE GREATER THAN .005 INCH IN HEIGHT.
7. PART MARKING. MARKING IS NOT REQUIRED. ITEMS SHALL BE IDENTIFIED AT THE BAG OR HIGHER PACKAGING LEVEL.
8. SUPERSEDED ITEMS MAY BE SUPPLIED UNTIL DEPLETION, OR UNTIL ONE YEAR FROM THE DATE OF THIS AMENDMENT. THEREAFTER MANUFACTURERS, THEIR DISTRIBUTORS, AND AGENTS SUPPLYING MILITARY CONNECTORS AND MODULES AS NOTED, SHALL ONLY FURNISH END SEALS PLUGS IN ACCORDANCE WITH THIS SPECIFICATION.

NOTES:

1. DIMENSIONING AND TOLERANCING PER ANSI-Y14.5M.
2. TABLE III LISTS THE DOCUMENTS THAT USE MS27488 SEALING PLUGS ALONG WITH THEIR STATUS AND SUPERSEDING DOCUMENT INFORMATION.

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