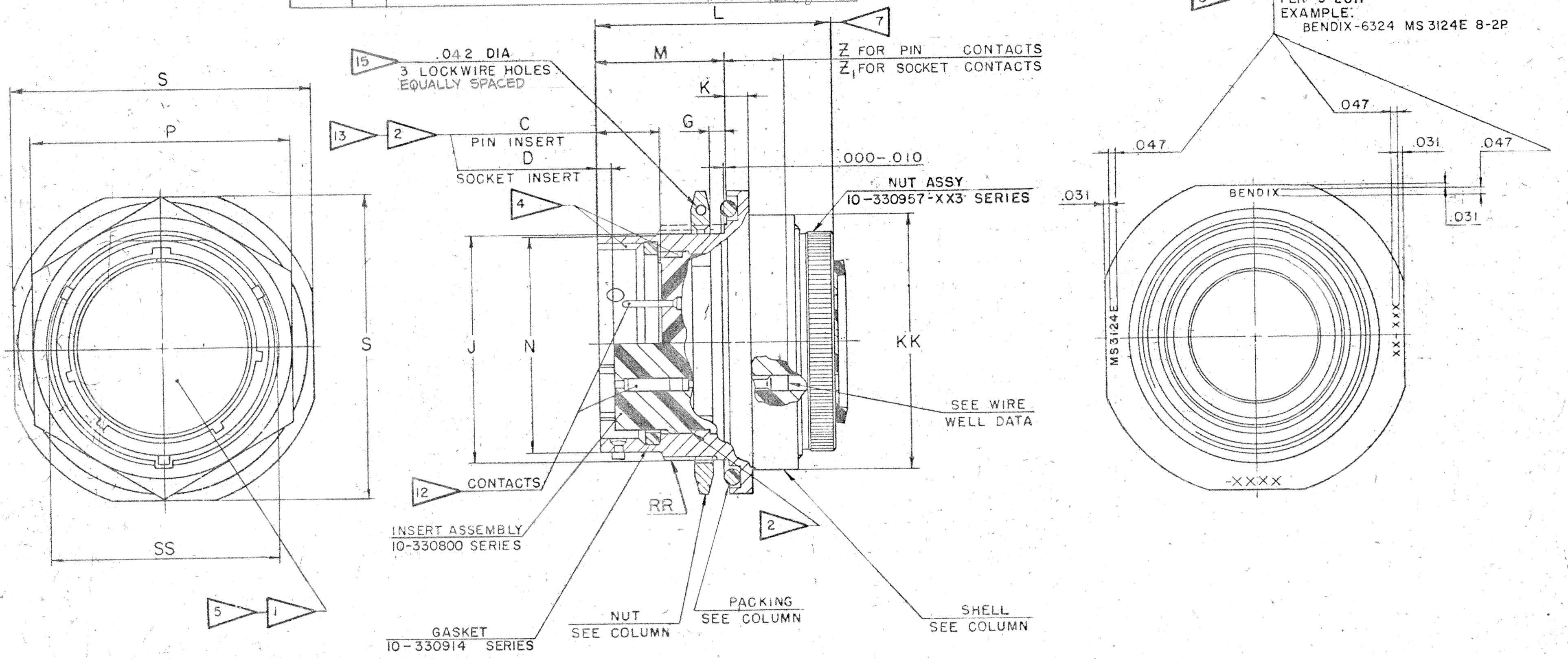


REVISIONS				
CHG NO	SYM	DESCRIPTION	DATE	APPROVAL
53524-178	A4	ADD. & REL -B & DATA	1-7-72 HANNI	L Hayes
53899-1	A5	WAS TEST 9-4039-1 (PROCESS SPEC)	6-21-72 Russell	L Hayes
58476-1	B	(MFG) WAS 10-101033 (NOTE 11)	3-23-77 L. HALL	L Hayes
74790-3	C	(CL II) REV NOTE 11	12-13-85 Prescott	L Hayes
77003-1	D	(CL II) ADDED SIZE 12 WIRE WELL DATA	1-30-86 Prescott	L Hayes
25732	E	(CL II) SEE CHG NOTICE	11/1/91 Prescott	cm JES

ACCESSORIES
(NOT PART OF STANDARD ASSEMBLY)
SEE DRAWING 10-150000

REVISIONS				
NO.	SYM	DESCRIPTION	DATE	APPROVAL
42194-3	1	WAS .337+.000-.020 (10/18)(C COL); .399+.000-.020 (20/24) (C COL); REM DASH (MS NO COL); ADD 9-3895 (PRO SPEC) REV NOTE 14, LOCAL STAMP BENDIX NOTE	11-27-63 LOUDON	L Hayes
43718-1	A1	INCORP HOODED SOCKETS	7-9-64 Lambrec	L Hayes
46585-3	A2	REV STAMPING	2-7-66 CABLE	L Hayes
49188-4	A3	REM NOTE 10, REV NOTE 14	6-24-68 Russell	L Hayes



SEE SHEET 2
NOTES

PROCESS SPEC SEE SHEET 2		ITEM-REQD PART NO. DESCRIPTION UNIT WT NEXT ASSY USED ON APPLICATION	
LINEAR DIMENSIONS ARE IN INCHES. TOLERANCES: .XXX ± .010, .XX ± .03, .X ± .1, ANGLES ± 2°. OTHER STANDARDS PER 9-3800 AND MIL-D-1000. NOTE REF		LIST OF MATERIAL	
MATERIAL SPEC. HEAT TREAT SPEC		CONNECTOR ELECTRICAL RECEPTACLE, TYPE MS-SEL JFW, OLIVE DRAB	
FINISH SPEC		SCINTILLA DIVISION BENDIX AVIATION CORPORATION SIDNEY N.Y. U.S.A.	
ORIG ENG JOB NO. 05929		71-254406 THRU 71-254450	
DRAWN: A. NILES DATE: 3-22-62		C SHEET 1 OF 2	
CHECKED: DATE: 4-13-62		DRAWING 71-331706/80	
MATERIAL: STG 93		SCALE: NONE	
CH DR: DATE: 4-16-62		WGT: ACT (PL) LBS REF 71-331706/80	
APP'D: DATE: 4-16-62		QDE 7782	

71-254406 THRU 71-254450

REF NO		REVISIONS		
CHG NO	SYM	DESCRIPTION	DATE	APPROVAL
	1	SEE SHEET ONE FOR ALL CHANGES	7-76	
	A1			
	A2			
	A3			
	A4			
	A5			
	B			
	C			
	D			
	E			

ASSEMBLY NUMBER	MS NUMBER	DETAILS			DIMENSIONS																
		SHELL	NUT	PACKING	C	D	G		J	K	L	M	N	P	S	Z	Z1	KK	RR	SS	
					+ .000 - .020	+ .000 - .020	MIN	MAX	+ .000 - .010	+ .011 - .010	MAX	± .005	DIA + .001 - .005	HEX MAX	MAX	± .030	± .030	DIA MAX	THREAD (PLATED) CLASS 2A	DIA + .000 - .016	
71-254406-	3124E6-	NOT AVAILABLE																			
71-254408-	8-	10-330923-83	10-123017-83	10-90351-17	.332	.025	.062	.125	.530	.125	1.422	.696	.473	.767	.954	.293	.232	.749	.5625-24UNEF	.563	
71-254410-	10-	10-330923-103	10-123017-103	10-90351-19	.332	.025	.062	.125	.655	.125	1.422	.696	.590	.892	1.078	.293	.232	.874	.6875-24NEF	.680	
71-254412-	12-	-123	-123	-22					.818				.750	1.079	1.266			.999	.8750-20UNEF	.859	
71-254414-	14-	-143	-143	-24					.942				.875	1.205	1.391			1.124	1.0000-20UNEF	.984	
71-254416-	16-	-163	-163	-26					1.066				1.000	1.329	1.516			1.249	1.1250-18NEF	1.108	
71-254418-	18-	-183	-183	-28					1.191				1.125	1.455	1.641			1.374	1.2500-18NEF	1.233	
71-254420-	20-	-203	-203	-128	.394	.087		.250	1.316	.156	1.609	.884	1.250	1.579	1.828	.167	.106	1.530	1.3750-18NEF	1.358	
71-254422-	22-	-223	-223	-130					1.441		1.609	.884	1.375	1.705	1.954	.167	.106	1.655	1.5000-18NEF	1.483	
71-254424-	24-	-243	-243	-132					1.566		1.672	.917	1.500	1.829	2.078	.134	.073	1.780	1.6250-18NEF	1.610	
71-254425/50		NOT AVAILABLE																			

3

15. FORMED LOCKWIRE HOLE DESIGN (6 HOLES)
15 OPTIONAL.

- 7. DIMENSION INDICATES FINAL INSTALLATION. FOR STORAGE & SHIPPING, SHELL & CLAMP ASSEMBLY MUST BE LOOSELY COUPLED.
- 6. SEE WORK ORDER FOR PERMISSIBLE ADDITIONAL OR ALTERNATE STAMPING.
- 5. INSERT ASSEMBLIES ARE NOT REMOVABLE.
- 4. VERTICAL CENTERLINES OF INSERT ARRANGEMENT & THE MAIN SHELL POLARIZING KEYWAY TO BE WITHIN .005 OF INDICATED ROTATION PER 9-2437-1.
- 3. TO COMPLETE ASSEMBLY NO. & MS NO., ADD APPLICABLE INSERT ARRANGEMENT SUFFIX TO BASE NUMBERS LISTED ABOVE PER 9-2437-1.
- 2. DIMENSIONS MUST BE MAINTAINED WHEN INSERT ASSEMBLY IS PRESSED FIRMLY AGAINST INDICATED SHOULDER.
- 1. FOR CONTACT ARRANGEMENTS, SEE DRAWINGS MS33709 THRU MS33716 OR SCINTILLA DRAWINGS L-15206-() THRU L-15250-().
- 14. UNITS ILLUSTRATED MEET THE MATERIAL & FINISH REQUIREMENTS OF MIL-C-26482.
- 13. INSERT LOCATING DIMENSIONS APPLY BEFORE ASSEMBLY OF CONTACTS.
- 12. PLACE CONTACTS IN AN APPLICABLE POLYETHYLENE BAG 10-215999 SERIES (SEE PARTS LISTS) & INCLUDE IN A POLYETHYLENE BAG CONTAINING CONNECTOR.
- 11. FOR FINAL INSTALLATION, CONTACTS MUST BE ASSEMBLED INTO ALL INSERT HOLES. ALL UNUSED GROMMET HOLES MUST BE FILLED WITH THE APPROPRIATE SIZE SEALING PLUGS.
- 10.
- 9. FOR COMPONENT PART NUMBERS OF DESIRED ARRANGEMENT, SEE APPLICABLE PARTS LIST (PL).
- 8. SEE DRAWING 71-254606/50 & OTHERS FOR REQUIRED MATING PLUG ASSEMBLY.

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WIRE WELL DATA			
CONTACT SIZE	20	16	12
CONDUCTOR WELL DIA	0.43 ± .002 - .000	0.66 ± .002 - .000	0.99-1.03
CONDUCTOR WELL DEPTH	1.84 ± .037 - .000	2.34 ± .031 - .000	2.40-2.60
INSULATION WELL DIA	0.91 ± .002 - .000	NOT AVAILABLE	NOT AVAILABLE
INSULATION WELL DEPTH	0.77 ± .006 - .000	NOT AVAILABLE	NOT AVAILABLE

PROCESS SPEC TEST 9-4039-3 ASSY 9-3836-2, 9-2437-1 9-2811, 9-3895		ITEM REQD PART NO DESCRIPTION UNIT WT NEXT ASSY USED ON	LIST OF MATERIAL TITLE CONDUCTOR, ELECTRICAL RECEPTACLE TYPE MS-SEI JFW, OLIVE DRAB	APPLICATION SCINTILLA DIVISION BENDIX AVIATION CORPORATION SYDNEY, N.Y., U.S.A. 71-254406 THRU 71-254450 C SHEET 2 OF 2
LINEAR DIMENSIONS ARE IN INCHES. TOLERANCES: .XXX ± .010, .XX ± .03, .X ± .1, ANGLES ± 2°. OTHER STANDARDS PER 9-3800 AND MIL-D-1000. NOTE REF	ORIG ENG JOB NO 05929	DRAWN A. NILES DATE 3-22-62	CHECKED Barr DATE 4-13-62	DRAWING 71-331706/50 C

NOTES:

71-254406 THRU 71-254450