

INCH - POUNDS

MIL-DTL-28731/20E
 25 May 2012
 SUPERSEDING
 MIL-C-28731/20D
 25 May 1984

DETAIL SPECIFICATION SHEET

CONNECTOR, ELECTRICAL, CONTACT, FORK TYPE,
 CRIMP REMOVABLE (8.5 AMPERES)

This specification is approved for use by all Departments and Agencies of the Department of Defense.

The requirements for acquiring the product described herein shall consist of this specification sheet and MIL-DTL-28731.

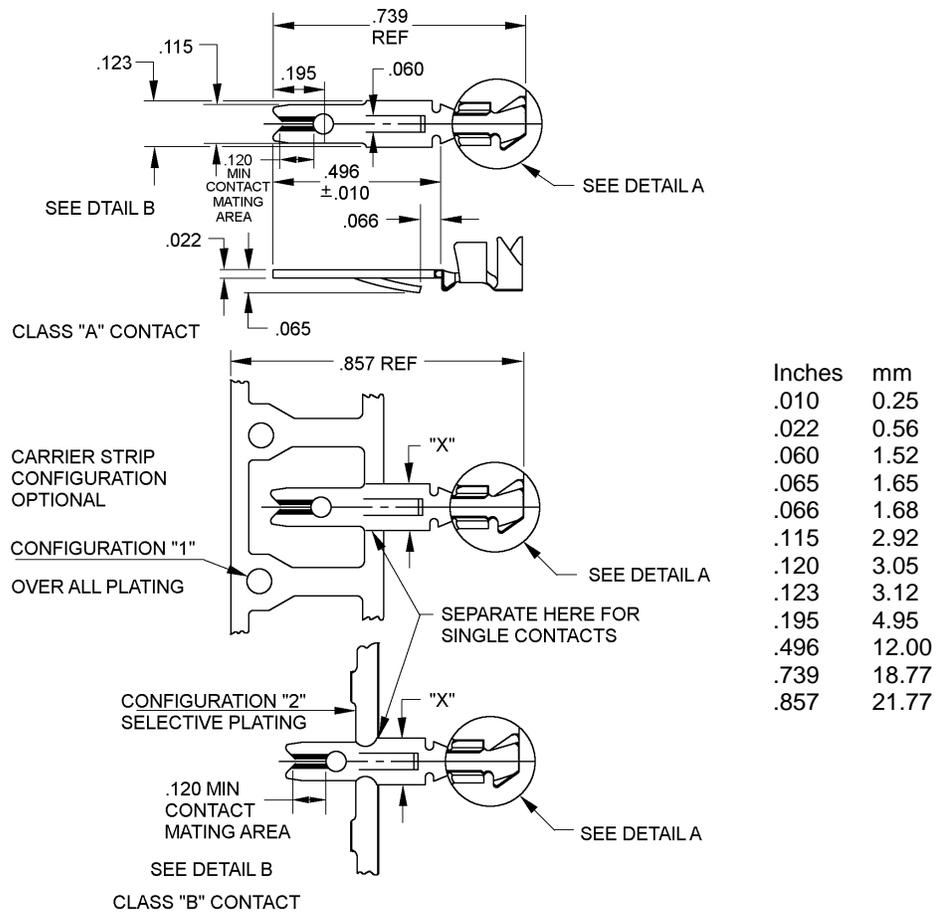
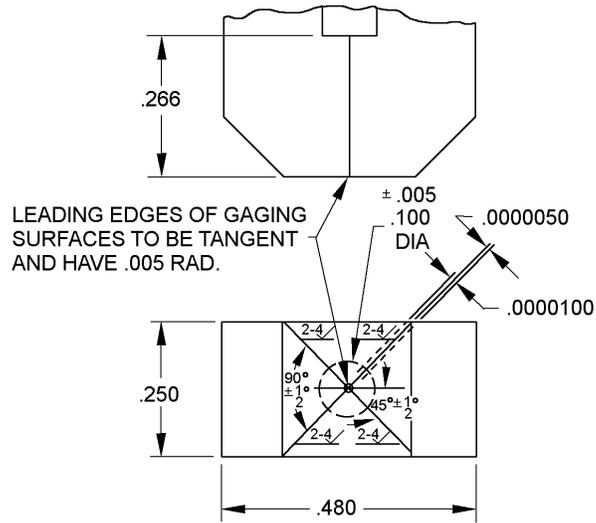


FIGURE 1. Contact, fork type, crimp removable.

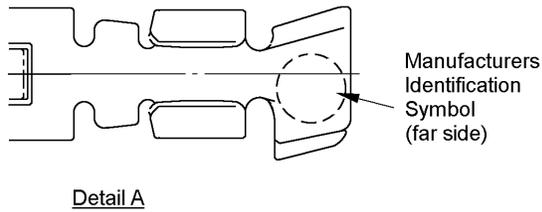
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Material: Medium alloy steel bonded titanium carbide, Rockwell-C-67-69

Configuration A, test gage.

Inches	mm
.000050	0.00127
.0000100	0.00254
.005	0.13
.100	2.54
.120	3.05
.250	6.35
.266	6.76
.480	12.19



Manufacturers identification symbol shall be imprinted approximately as shown.

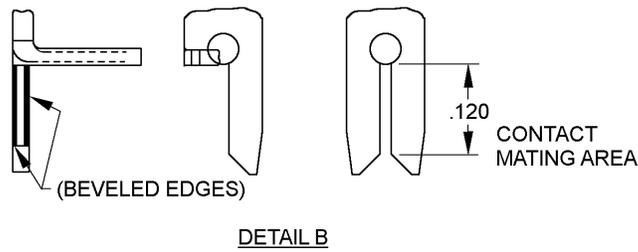


FIGURE 1. Contact, fork type, crimp removable – Continued.

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NOTES:

1. Dimensions are in inches.
2. Metric equivalents are given for information only.
3. Tolerance shall be $\pm .005$ (0.13 mm) unless otherwise specified. All dimensions are for parts after plating.
4. Trim area not to exceed width of contact across retaining lance area "X".
5. Contact crimp for use with (AWG) wire range No. 26 to No. 18. Wire size No. 16 can be used with the following exception: Insulation crimp must be crimped over conductor member only. No insulating material is permitted in insulator crimp barrel which will hamper insertion of contact into connector cavity.
6. Remove all burrs and sharp edges .0005 (0.013 mm) maximum.
7. Crimp tool MIL-C-22520/17-01.
8. Insertion and removal tool MIL-I-81969/13-01 and MIL-I-81969/11-01.
9. Patent Notice. Patent No. 3,248,686 owned by Elco corporation. The Government has a royalty-free license under the above patent for the benefit of manufacturers of the items called for in this specification, either for the government or for use in equipment to be delivered to the government.

FIGURE 1. Contact, fork type, crimp removable – Continued.

REQUIREMENTS:

Dimensions and configuration: See figure 1.

Contact separation force (see configuration A):

Polished steel gage from unplated contacts: 2 to 10 ounces.

Plated gold over nickel contacts: 2 to 16 ounces.

Crimp tensile strength: Minimum tensile strength during crimp tensile strength testing shall be 40.0 pounds for AWG 16 wire.

Contact mating area: Contacts may be supplied with either overall plating or localized finish. For localized finish the contact mating area shall be in accordance with MIL-DTL-28731.

Identification of contact: Contacts shall be permanently imprinted with manufacturer's symbol for purpose of identifying manufacturer's product (see figure 1, detail A).

Part or Identifying Number (PIN):

M28731/20-0001 – supplied loose for hand crimping installation.

M28731/20-0002 – supplied on a reel for automatic crimping machine installation.

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Changes from previous issue. Marginal notations are not used in this revision to identify changes with respect to the previous issue, due to the extent of the changes.

Referenced documents. This document references MIL-DTL-28731.

CONCLUDING MATERIAL

Custodians:

Army – CR
Navy – EC
Air Force – 85
DLA - CC

Preparing activity:

DLA - CC

(Project 5935-2012-064)

Review activities:

Army – AR, AT, AV, CR4, MI
Navy – AS, MC, OS
Air Force – 19, 99

NOTE: The activities listed above were interested in this document as of the date of this document. Since organizations and responsibilities can change, you should verify the currency of the information above using the ASSIST Online database at <https://assist.daps.dla.mil/>.