

MIL-DTL-28754/70A

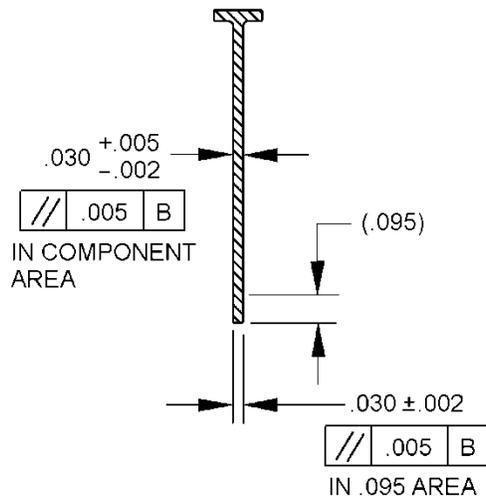
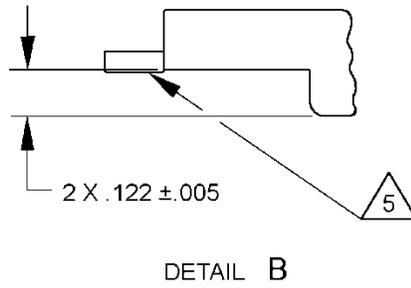
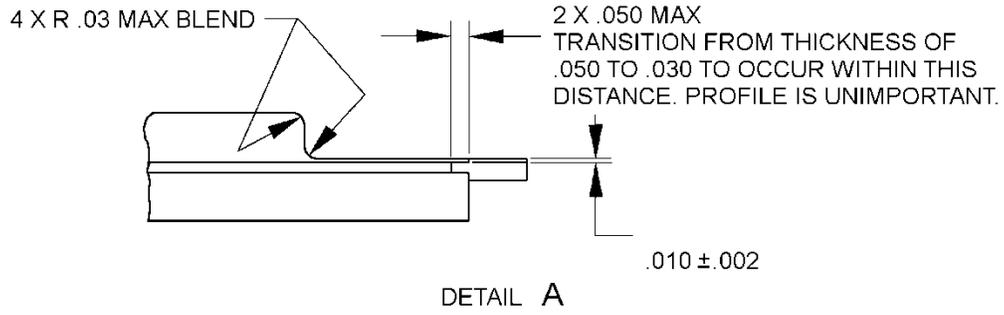


FIGURE 1. Dimensions and configurations – continued.

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Inches	mm	Inches	mm	Inches	mm	Inches	mm	Inches	mm
.001	.03	.015	.38	.100	2.54	.275	6.99	2.150	54.61
.002	.05	.030	.76	.122	3.10	1.490	37.85	2.340	59.44
.003	.08	.050	1.27	.128	3.25	1.600	40.64	2.740	69.60
.005	.13	.062	1.58	.150	3.81	1.860	47.25		
.010	.25	.095	2.41	.163	4.15	1.890	48.01		

NOTES:

1. Dimensions are in inches.
2. Metric equivalents are given for information only and are based upon 1.00 inch = 25.4 mm.
3. Unless otherwise specified, tolerances are $\pm .005$ (.13 mm) inch for three place decimals, $\pm .01$ (.3 mm) inch for two place decimals and $\pm 2^\circ$ for angles.
4. Unless otherwise specified, all corner radii shall be .02 (.51 mm) inch rad max.
5. This surface and the .122 dimension shall be flush to .005 maximum step.
6. Top of T surfaces.
7. Dimensional limits apply after plating.
8. Frame shall be marked in approximate location shown with part number, manufacturer's number and date code with contrasting ink in characters .06 (1.5 mm) inch high.

FIGURE 1. Dimensions and configurations – continued.

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REQUIREMENTS

Dimensions and configuration: See figure 1.

Materials: For M28754/70-01, aluminum alloy 6101, ASTM-B317, T6 extrusion.

For M28754/70-02, copper C11000, H01 temper, per ASTM B152/B152M.

For M28754/70-03, copper-invar-copper (20-60-20 by thickness).

Finish: For M28754/70-01, anodic coating, MIL-A-8625, Type II, Class 2, black.

For M28754/70-03, electroless nickel in accordance with AMS2404, 5 percent phosphorous minimum, Class 1, 0.0010 inch (25 mm) minimum thickness; MIL-DTL-5541, Class 1A, yellow. Within 4 hours after plating, oven bake 275 ± 25°F, 1 hour, for hydrogen relief and adhesion.

Examination: One frame from each plating lot shall be exposed to salt fog per MIL-STD-810, Method 509, Procedure 1, 48 hours, and one frame shall be exposed to oven bake at 375 ± 10°F, 60-90 minutes. Examine each frame, using 6 to 10 power magnification, for loose or blistered coating. Examination results shall be delivered with each order. The examined frames shall be retained by the supplier for a period of 6 months.

Stress relief: For M28754/70-02 and -03, frames shall receive the following bake cycle prior to plating and after all fabrication steps, 375 ± 10°F for 90 ± 10 minutes.

Military part number: M28754/70- (Dash Number from Table I).

TABLE I.

DASH NUMBER	MATERIAL	FINISH
01	Aluminum Alloy	Anodize
02	Copper	Nickel
03	Copper-Invar	Nickel

First article testing (FAT) information: The frame shall meet the following tests of MIL-C-28754 Table IV, Type IV. Subgroup I, Method Paragraph 4.7.1, Subgroup II, method Paragraph 4.7.11 and 4.7.1, Subgroup III, Method Paragraph 4.7.13 and 4.7.1, Subgroup IV, Method Paragraph 4.7.12, 4.7.18, 4.7.19, 4.7.20 and 4.7.1.

Number of units to be inspected. Twelve (12) units of each dash number to be shall be inspected.

Changes from previous issue. The margins of this specification are marked with vertical lines to indicate where changes from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the previous issue.

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Referenced documents. In addition to MIL-C-28754, this document references the following:

MIL-A-8625
MIL-STD-810
MIL-DTL-5541
AMS2404
ASTM B152/B152M
ASTM-B317

CONCLUDING MATERIAL

Custodians:
Army – CR
Navy – AS
Air Force – 85
DLA – CC

Preparing activity:
DLA - CC

(Project 5935-2015-206)

Review activities:
Army - MI
Air Force - 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.dla.mil/>.