

INCH-POUND

MIL-DTL-55302/97D
w/AMENDMENT 2
12 September 2012
SUPERSEDING
MIL-DTL-55302/97D
w/AMENDMENT 1
3 June 2010

DETAIL SPECIFICATION SHEET

CONNECTORS, PRINTED CIRCUIT SUBASSEMBLY AND ACCESSORIES:
CONTACTS, HERMAPHRODITIC, CRIMP REMOVABLE FOR WIRE (STRANDED)

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-55302.

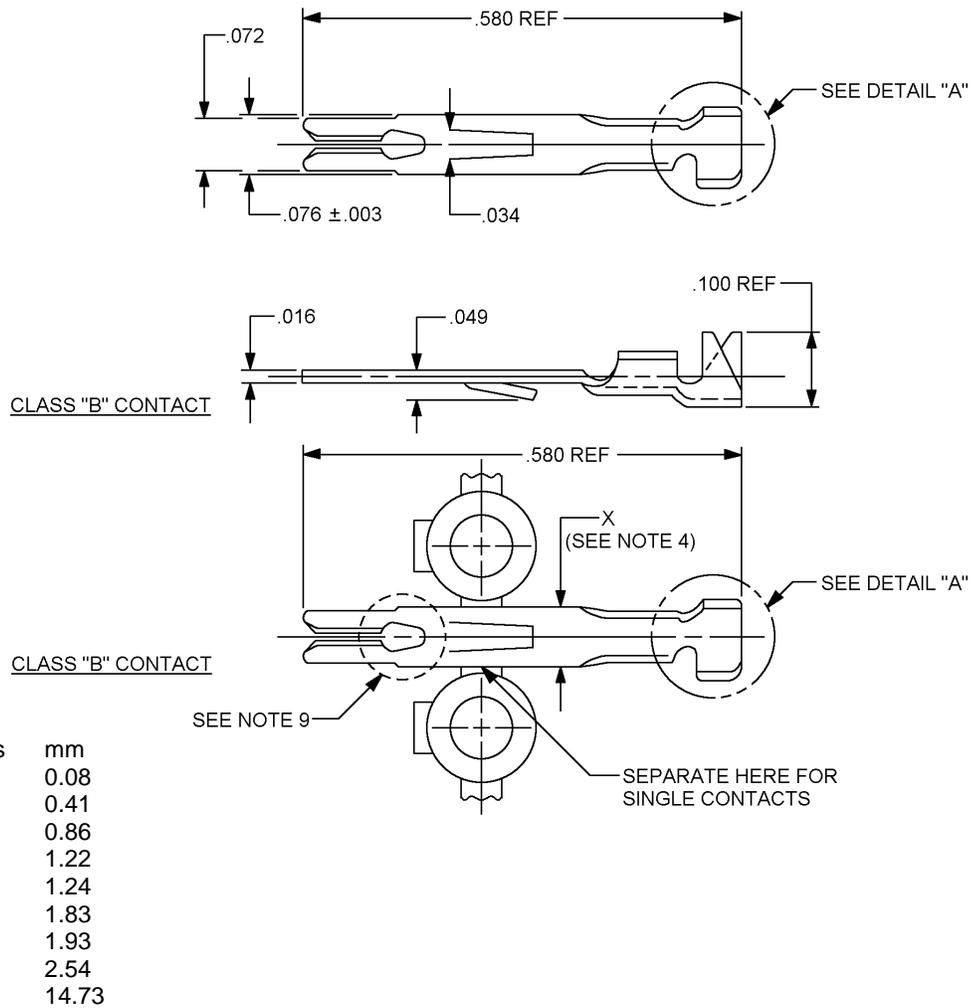
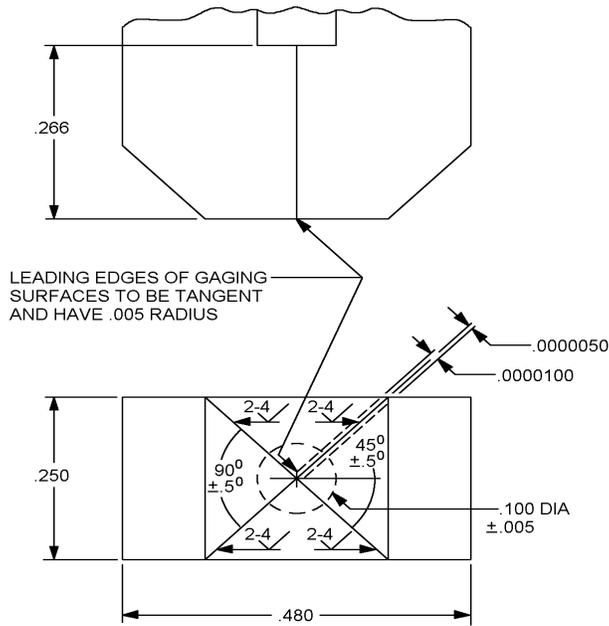


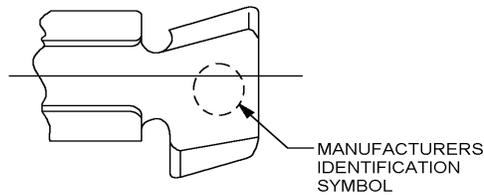
FIGURE 1. Contact, hermaphroditic, crimp removable.

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MATERIAL: MEDIUM ALLOY STEEL BONDED TITANIUM
CARBIDE, ROCKWELL-C-67-69

CONFIGURATION "A" TEST GAGE



DETAIL "A"

Inches	mm
.0000050	0.000127
.0000100	0.000254
.001	0.03
.005	0.13
.250	6.35
.266	6.76
.480	12.19

Manufacturer's identification symbol shall be imprinted approximately as shown.

NOTES:

1. Dimensions are in inches.
2. Metric equivalents are given for general information only.
3. Tolerances shall be $\pm .005$ (0.13 mm) unless otherwise specified. All dimensions are for parts after plating.
4. Trip area not to exceed width of contact across retaining lance area X.
5. Contact crimp for use with (AWG) wire range 22 to 30 stranded type E in accordance with MIL-DTL-16878.
6. Remove all burrs and sharp edges .001 inch (0.03 mm) maximum.
7. Crimp tool M22520/17-02.
8. Contact insertion and removal tool M81969/5-01 and M81969/4-02.
9. Contact relief hole configuration, optional.

FIGURE 1. Contact, hermaphroditic, crimp removable - Continued.

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REQUIREMENTS

Dimensions and configuration: See figure 1.

Material: Phosphor bronze in accordance with ASTM B139/B139M, composition A.

Plating: The contact plating shall be gold in accordance with ASTM B488, type II code D, class 1.27, over nickel plating in accordance with SAE AMS-QQ-N-290, class 2, 30 to 150 microinches in contact engagement area for .120 inch minimum (see figure 1). The remainder of the contact shall be gold in accordance with ASTM B488, type II, code D, class .25 minimum, over nickel plating in accordance with SAE AMS-QQ-N-290, class 2, 30 to 150 microinches.

Contact separating force: See configuration A.

Polished steel gage from unplated contacts: 1 ounce minimum.

Plated gold over nickel contacts (contact to contact): 2 to 10 ounces.

Current rating, maximum: 5 amperes, 22 AWG wire.

Identification of contact:

Contacts shall be permanently imprinted with manufacturer's symbol for purpose of identifying manufacturer's product (see detail A).

Application: Contact, hermaphroditic, crimp removable for wire (stranded), are to be used with connectors, MIL-DTL-55302/93, MIL-DTL-55302/94, and MIL-DTL-55302/102.

Part or Identifying Number (PIN): M55302/97-01, supplied loose for hand crimping installation.
M55302/97-02, supplied on a reel containing 3000 contacts for automatic crimping machine installation.

All contacts shall be tested and qualified in accordance with the applicable connector specification sheet.

Qualification: Qualification is not required for this specification sheet.

First article testing (FAT): FAT shall be in accordance with MIL-DTL-55302, qualification inspection.

Amendment notations. The margins of this specification are marked with vertical lines to indicate where modifications from this amendment 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.

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Referenced documents. In addition to MIL-DTL-55302, this document references the following:

MIL-DTL-16878
MIL-DTL-55302/93
MIL-DTL-55302/94
MIL-DTL-55302/102
ASTM B139/B139M
ASTM B488
SAE AMS-QQ-N-290

CONCLUDING MATERIAL

Custodians:
Army - CR
Air Force - 85
DLA - CC

Preparing activity:
DLA - CC

(Project 5935-2012-105)

Review activities:
Army - AR, AT, AV, CR4, 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>.