

INCH-POUND

MIL-DTL-28754/91A

7 March 2019

SUPERSEDING

MIL-C-28754/91(SH)

31 OCTOBER 1989

DETAIL SPECIFICATION SHEET

CONNECTORS, ELECTRICAL, MODULAR, CONNECTOR FRAME, TYPE IV, CENTER FIN, 0.5 PITCH, FORMAT C AND E

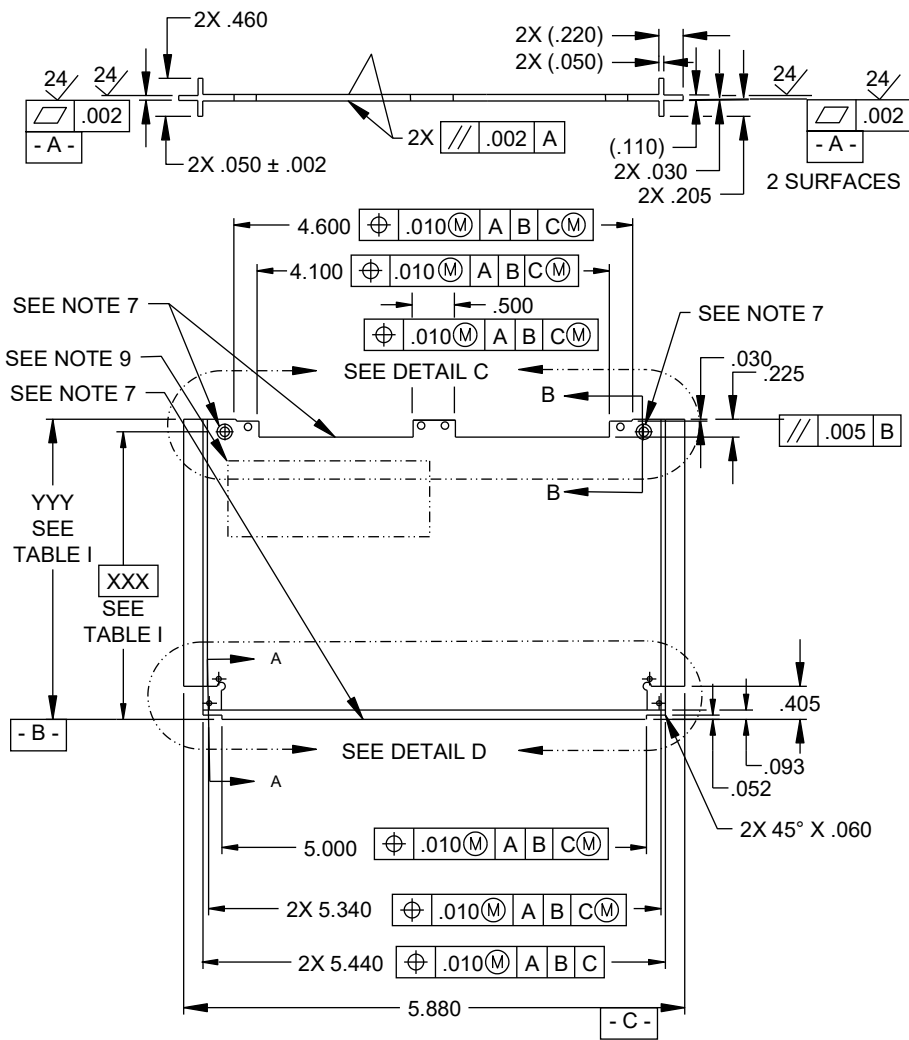
This specification is approved for use all Departments and Agencies of the Department of Defense.

The requirements for acquiring the product described herein shall consist of this specification and MIL-DTL-28754.

AMSC N/A

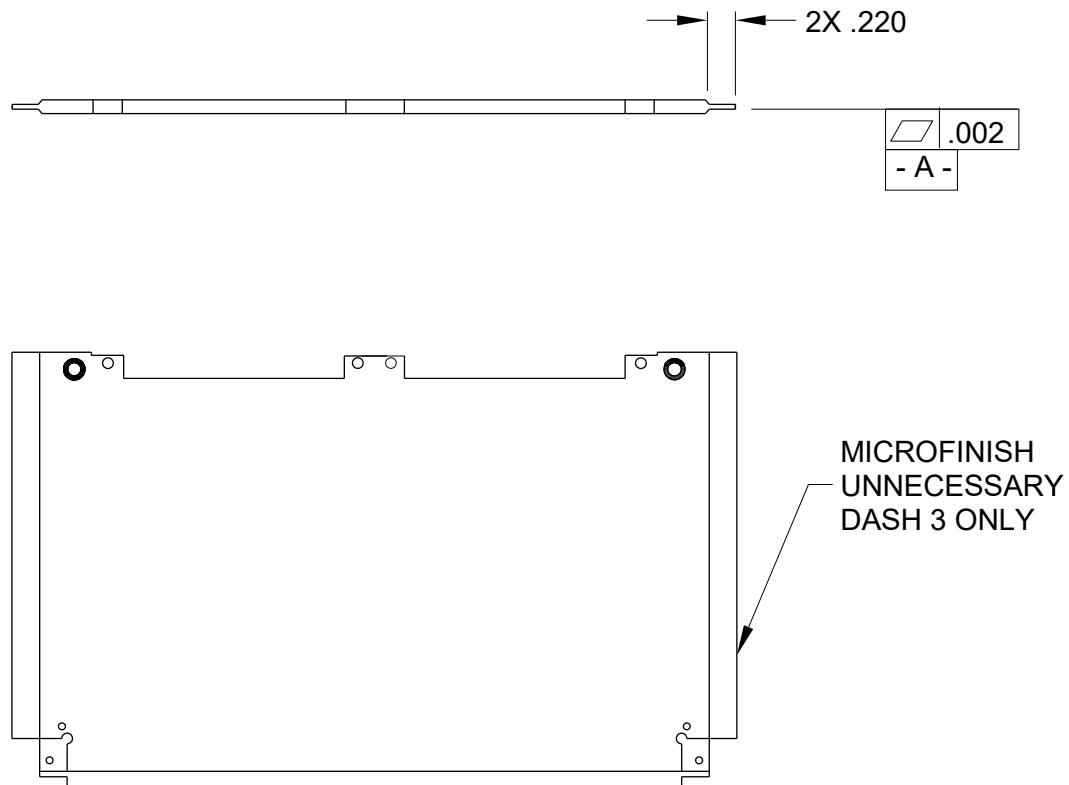
FSC 5935





CONFIGURATION FOR DASH Nos. 1 and 2

FIGURE 1. Dimensions and configurations.



NOTE: DASH 3 IS THE SAME AS DASH 2 EXCEPT FOR LACK CROSSPIECES ON RIBS

CONFIGURATION FOR DASH NO. 3

FIGURE 1. Dimensions and configurations – Continued.

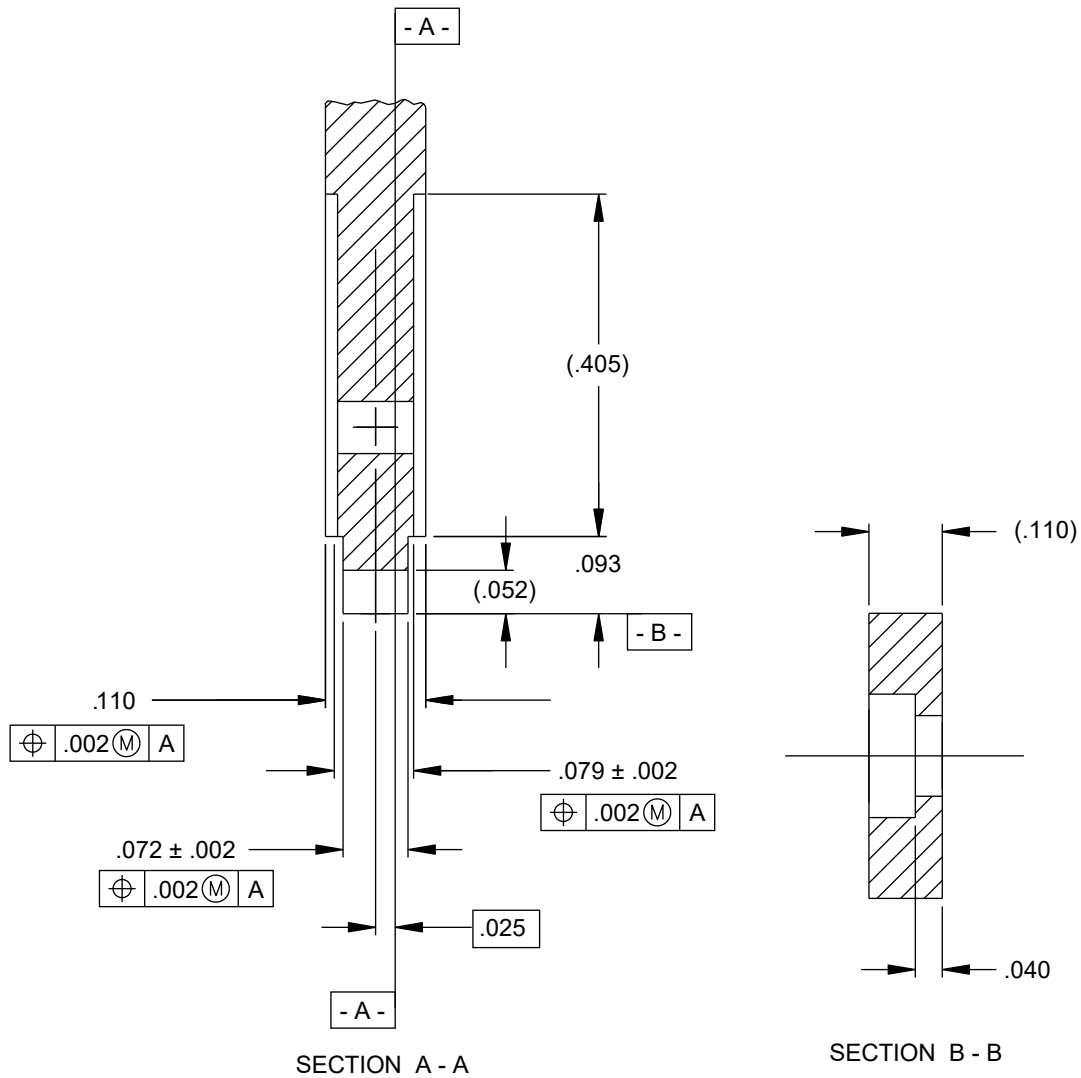


FIGURE 1. Dimensions and configurations – Continued.

MIL-DTL-28754/91A

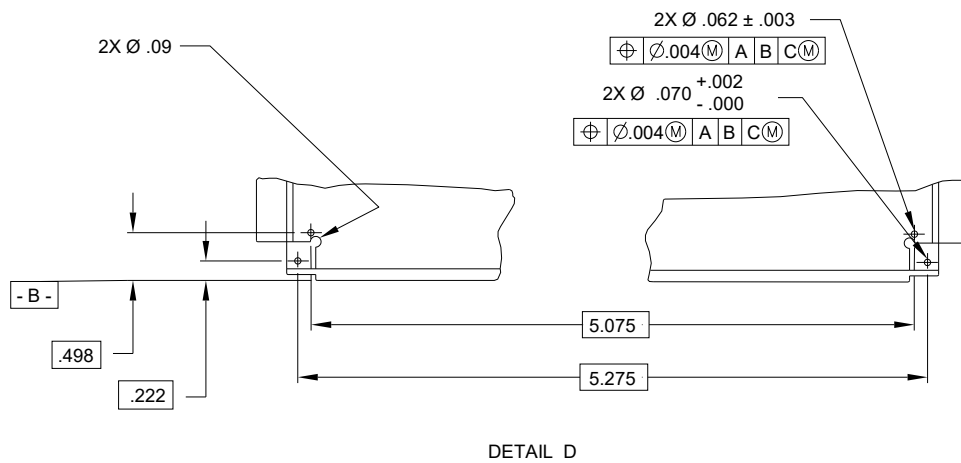
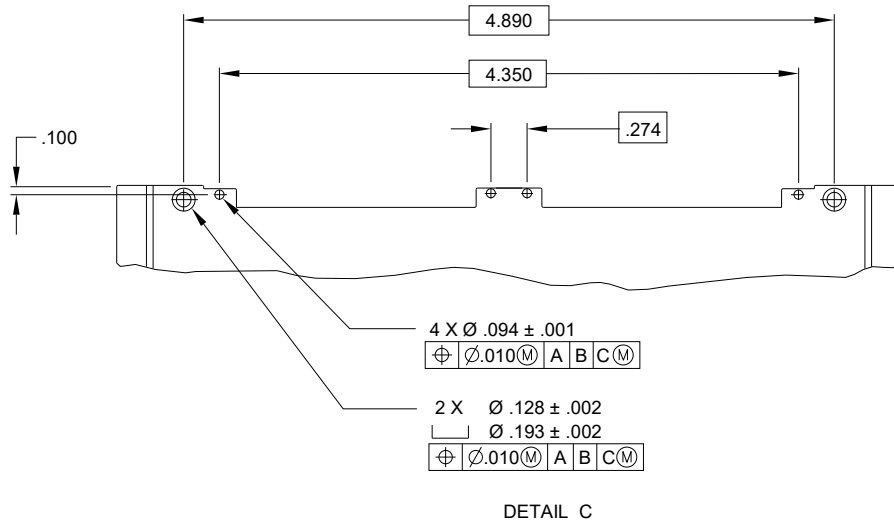


FIGURE 1. Dimensions and configurations – Continued.

MIL-DTL-28754/91A

INCHES	MM	INCHES	MM	INCHES	MM	INCHES	MM
0.001	0.025	0.072	1.829	0.193	4.902	3.670	93.218
0.002	0.051	0.079	2.007	0.205	5.207	4.350	110.490
0.003	0.076	0.090	2.286	0.220	5.588	4.600	116.840
0.005	0.127	0.093	2.362	0.222	5.639	4.860	123.444
0.010	0.254	0.094	2.388	0.225	5.715	4.890	124.206
0.015	0.381	0.095	2.413	0.274	6.960	5.075	128.905
0.025	0.635	0.100	2.540	0.275	6.985	5.150	130.810
0.030	0.762	0.110	2.794	0.405	10.287	5.275	133.985
0.050	1.270	0.122	3.099	0.498	12.649	5.340	135.636
0.052	1.321	0.128	3.251	1.340	34.036	5.760	145.796
0.062	1.575	0.150	3.810	1.490	37.846	6.140	155.956
0.070	1.778	0.163	4.140	3.520	89.408		

NOTES:

1. Dimensions are in inches.
2. Metric equivalents are given for general information only and are based upon 1.00 inch = 25.40 mm.
3. Unless otherwise specified, tolerances are plus or minus 0.005 inch (0.127 mm) for three place decimals, plus or minus 0.01 inch (0.25 mm) for two place decimals and plus or minus 1° for angles.
4. Unless otherwise specified, all corner radii shall be 0.05 (1.27 mm) inch radius maximum.
5. Surface roughness shall be in accordance with ASME B46.1.
6. The frame must be straight and flat to meet the requirements of the drawing prior to plating. No straightening or bending is permitted after plating.
7. These points are designated as racking points. Anodize on the base material is not required.
8. Dimensional limits apply after plating.
9. Mark part number, revision letter, manufacturer's code ident CAGE and date code in 0.12 (3.05 mm) plus or minus 0.02 (0.51 mm) inch high gothic characters at approximate location shown. Use white epoxy ink, A-A-56032, II, and mark in accordance with MIL-STD-130.
10. Break all sharp corners and edges, 0.005 inch max.

FIGURE 1. Dimensions and configurations – Continued.

REQUIREMENTS:

Dimensions and configurations: See figure 1 and table I.

Material: Aluminum Alloy 6101, ASTM B317/B317M, T6, Extrusion.

Finish: Anodic coating, MIL-A-8625, type III, class 2, black.

Military part number: M28754/91- (dash number from table I).

MIL-DTL-28754/91A
TABLE I. Dash numbers.

DASH NO	FORMAT	DIMENSION "YYY"	DIMENSION "XXX"	CROSS PIECE
-1	C	3.670	3.520	YES
-2	E	6.290	6.140	YES
-3	E	6.290	6.140	NO

FAT information: The frame shall meet the following FAT of MIL-DTL-28754, table III, type IV: Subgroup I, Visual and Mechanical Inspection; Subgroup II, Vibration, Visual and Mechanical Inspection; Subgroup III, Salt Spray, Visual and Mechanical Inspection; Subgroup IV, Shock, Fin/Header torque, Fin cantilever load, Rib strength, Visual and Mechanical inspection.

Number of units to be inspected: Twelve (12) units of each dash number shall be inspected according to FAT. See MIL-DTL-28754 Appendix for exceptions when inspected similar parts.

Compatibility: This frame may be used with the connector described in MIL-DTL-28754/100.

Supersession data: Supersedes Naval Air Systems Command Drawing Number SK-MEL-5200-3, -6 Code Identification Number 30003.

Qualification: Qualification is not required for this specification sheet.

First article testing (FAT): FAT shall be in accordance with MIL-DTL-28754 inspection.

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.

Reference documents. In addition to MIL-DTL-28754, this document references the following:

MIL-A-8625
MIL-DTL-28754/100
MIL-STD-130
ASME B46.1
ASTM B317/B317M
A-A-56032

Custodian:
Navy - AS
DLA - CC

Preparing activity:
DLA - CC

(Project 5935-2018-194)

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>.