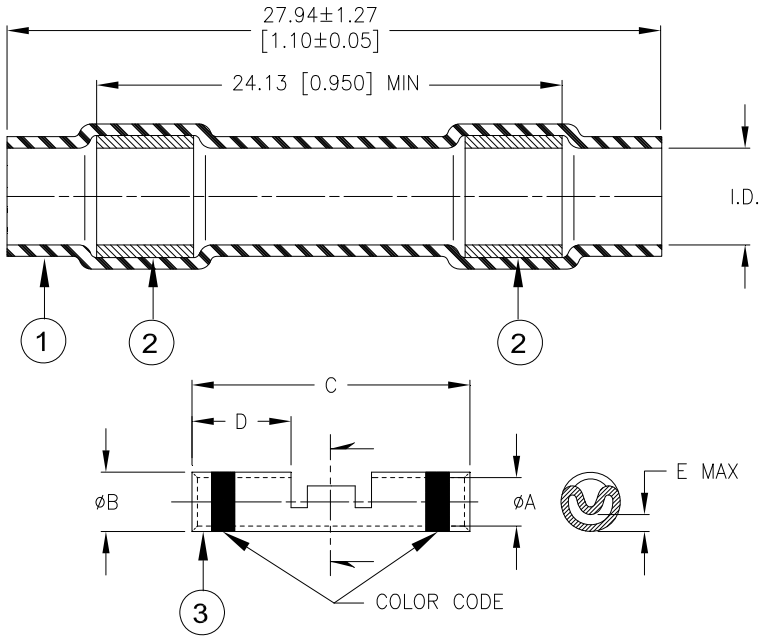
CUSTOMER DRAWING



Product Name	Prod. Rev:	I.D.* a min / b max	Crimp Splicer					
			øA	øB	C	D	E max	Color Code
D-200-82-G	A	2.16 (0.085) 0.64 (0.025)	1.27 (0.050) 1.14 (0.045)	2.03 (0.080) 1.91 (0.075)	12.95 (0.510) 12.45 (0.490)	6.22 (0.245) 5.72 (0.225)	0.38 (0.015)	Red
D-200-83-G	A	2.79 (0.110) 0.64 (0.025)	1.75 (0.069) 1.63 (0.064)	2.70 (0.106) 2.57 (0.101)	14.86 (0.585) 14.35 (0.565)	7.11 (0.280) 6.60 (0.260)	0.51 (0.020)	Blue
D-200-84-G	A	4.32 (0.170) 0.64 (0.025)	2.60 (0.102) 2.46 (0.097)	3.89 (0.153) 3.73 (0.147)	14.86 (0.585) 14.35 (0.565)	7.11 (0.280) 6.60 (0.260)	1.27 (0.050)	Yellow

* I.D: a- As received; b- After unrestricted recovery thru meltable insert.

Product Name	MIL Spec Equivalent Size	Wire Range	Wgt. Lbs/Mpc max
D-200-82-G	M81824/1-1	26-20	1.02
D-200-83-G	M81824/1-2	20-16	1.61
D-200-84-G	M81824/1-3	16-12	2.72

MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified fluoropolymer.
2. MELTABLE RINGS: Environment resistant modified thermoplastic fluoroelastomer. Color: light blue.
3. CRIMP SPLICER: Base Metal: Copper Alloy 101 or 102 per ASTM B75.
   Plating: Gold plated per MIL-C-45204B TYP III, CLASS I.
   Color Code: See table.

TE Connectivity			Raychem Devices	TITLE: IN-LINE SPLICE SEALING SYSTEM, 1 TO 1 GOLD PLATED CRIMP, 200deg.C			
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]				DOCUMENT NO.: D-200-8X-G			
TOLERANCES: 0.00 N/A, 0.0 N/A, 0 N/A	ANGLES: N/A ROUGHNESS IN MICRON	Tyco Electronics reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.		REVISION: A		DATE: 18-Dec-12	
PREPARED BY: TNGUYEN	ECO NUMBER: ECO-12-022113	REPLACES: N/A		CAGE CODE : 06090	SCALE: N/A	SIZE: A	SHEET: 1 of 2

APPLICATION

1. These parts are designed to provide an immersion resistant in-line splices of 1 to 1 wires falling within the size range listed, and having nickel-plated conductors and insulations rated for at least 135°C.
2. Parts will meet all performance requirements of SAE AS-81824 when installed as outlined below with the following modifications:
   -Heat ageing test temperature of 200ºC.
   -Thermal shock maximum temperature of 200ºC.
3. Acceptance sampling shall be in accordance with Paragraph 4.6.1 of SAE AS-81824.
4. Packing and packaging shall be in accordance with Section 5, Level C, of SAE AS-81824.
5. This document takes precedence over documents referenced herein.

ASSEMBLY PROCEDURE:

1. Slide sealing sleeve onto one of the wires to be spliced.
2. Strip wires 7.95 [5/16”] to 8.73 [11/32”].
3. Insert one wire into barrel of crimp splicer and crimp using a Raychem AD-1377 crimp tool.

   Repeat for the other wire.
4. Center sealing sleeve over the splice.
5. Apply heat, using an approved heat source, first to one of the inserts and then the other. Heat should be applied until insert melts and flows axially along the wire.