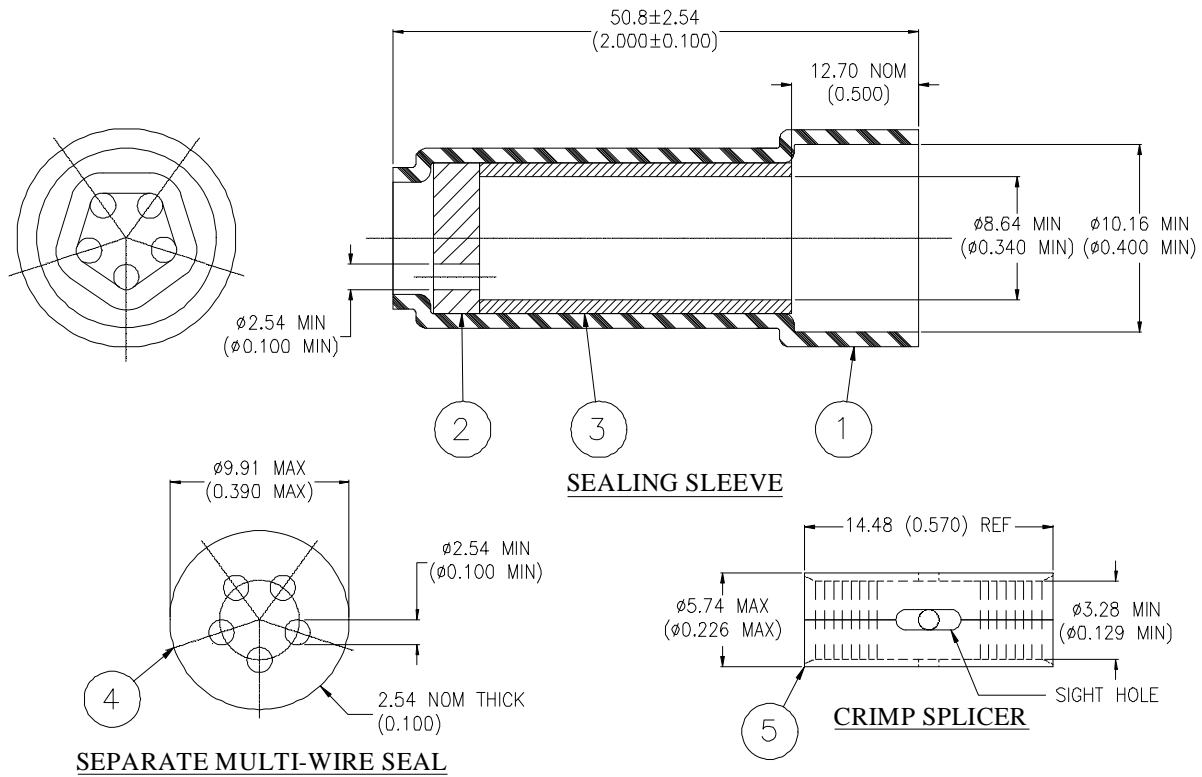


## CUSTOMER DRAWING




### MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
2. INTEGRAL MULTI-WIRE SEAL: Modified thermoplastic, color - red.
3. MELTABLE LINER: Modified thermoplastic, color - natural.
4. SEPARATE MULTI-WIRE SEAL: Modified thermoplastic, color - red.
5. CRIMP SPLICER: Base Metal: Copper alloy per ASTM B-152, Annealed.  
Plating: Tin-plated per ASTM B545.  
Wire Size Range: 2.62 - 6.64 mm<sup>2</sup> [5,180 - 13,100 CMA], 12 - 10 AWG, Solid or Stranded.

### APPLICATION

1. This assembly is designed to provide immersion resistant in-line splices in wires rated for at least 135°C. It may be used on splice combinations from 2 to 1 through 5 to 5 where the CMA of the conductors on each side is between 5180 and 13100 circular mils. Wires are limited to a maximum insulation diameter of 2.36 [.093].
2. Use AMP crimp tool 49900 (or equivalent tool) to install crimp barrel. Sealing sleeve may be installed with convection heaters.
3. Strip length on wires shall be 6.35 – 7.92 [.250 - .312].

			TITLE: <b>IN-LINE SPLICE SEALING SYSTEM                  MULTI-TO-MULTI</b>		
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]		Raychem Devices	DOCUMENT NO.: <b>D-436-29</b>		
TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A	ANGLES: N/A  ROUGHNESS IN MICRON	Tyco Electronics Corporation reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.		REV: B1	DATE: June 13, 2018
PREPARED BY: LRODRIGUEZ	CAGE CODE: 06090	ECO NUMBER: ECO-18-009289	SCALE: NTS	SIZE: A	SHEET: 1 of 2

## CUSTOMER DRAWING

### INSTALLATION PROCEDURE

1. Strip 6.35 – 7.92 [.250 - .312] of insulation from each wire to be spliced.
2. Pass the wires to be attached to one barrel through the holes in the separate multi-wire seal being careful to avoid twisting. Crimp barrel using AMP 49900 crimp tool (use 12 –10 nest).
3. Pass the wires to be attached to the other crimp barrel through the sleeve from the multi-hole insert end.
4. Slide the sleeve far enough onto wires to permit completion of splice.
5. Complete splice, again being careful to keep wires untwisted between the crimped splicer and the multi-hole seals or the sleeve cannot be positioned properly.
6. Position the separate insert as close as possible to the crimp splicer. Hold the insert in place by squeezing the wires directly behind it and slide the sealing sleeve over the assembly so that the separate insert is completely inside the outer sleeve.
7. Apply heat to the assembly as follows:
  - A. Use Raychem Thermogun, Model 500A, equipped with Raychem TG-12 Reflector, adjusted to give heat of 350 - 400°C.
  - B. Place the sleeve in the heat so that the “separate” insert is centered in the air stream. Apply heat until the insert has melted and flowed axially along the wires.
  - C. Work heat across sleeve causing liner to melt and flow, then concentrate heat on the second multi-wire insert until it, also, melts and flows.
  - D. The time required is largely dependent upon the temperature of the air-stream and mass of the wire bundle being encapsulated.

Unless otherwise specified dimensions are in millimeters.  
(Inches dimensions are shown in brackets)

DOCUMENT NO.: <b>D-436-29</b>	CAGE CODE: 06090	REV: B1	ECO NUMBER: ECO-18-009289	DATE: 13-June-2018	SHEET: 2 of 2
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