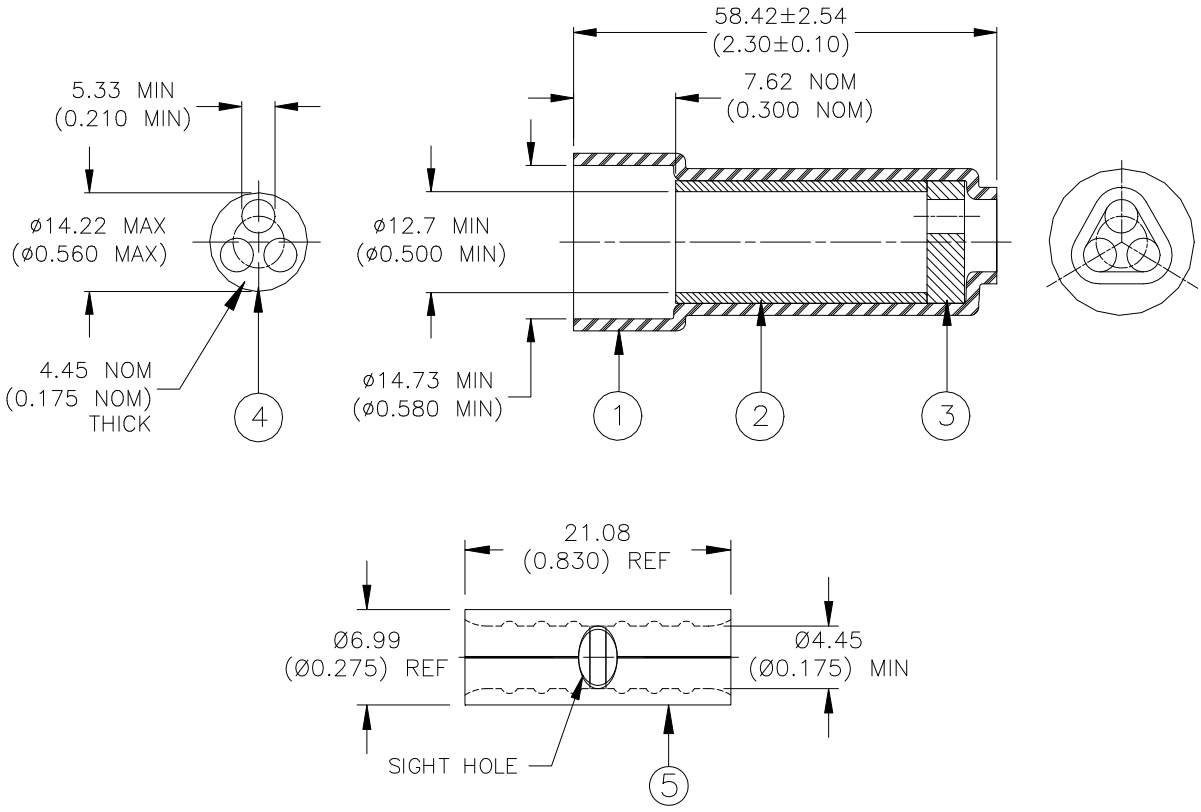
CUSTOMER DRAWING



MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
2. MELTABLE LINER: Modified thermoplastic.
3. INTEGRAL MULTI-WIRE SEAL: Modified thermoplastic. Color: blue.
4. SEPARATE MULTI-WIRE SEAL: Modified thermoplastic. Color: blue.
5. CRIMP SPLICE: Base Metal: Copper Alloy 101 or 102 per ASTM B-75.
   Plating: Nickel per SAE AMS-QQ-N-290.

APPLICATION

1. These parts are designed to provide immersion resistant in-line splices of 2-to-2 or 3-to-3 wires falling within a CMA range of 13,100 to 20,800, having nickel-plated conductors and insulations rated above 135°C.
2. Parts are to be installed per assembly procedure as outlined below.
3. Inside diameter and outside diameter of splice are to be measured in crimp area, 2.54 to 5.08 mm [0.100 to 0.200 in] from ends of part. Slight burr permitted on parted surfaces.
4. Acceptance sampling shall be in accordance with Paragraph 4.6.1 of SAE AS81824.
5. Packing and packaging shall be in accordance with Section 5, Level C, of SAE AS81824.
6. This document takes precedence over documents referenced herein.
7. Temperature range: -65°C to +175°C.

TE Connectivity			TITLE: IN-LINE SPLICE SEALING SYSTEM, MULTI-WIRE, NICKEL PLATED CRIMP, AWG 8		
Unless otherwise specified dimensions are in millimeters.[Inches dimensions are shown in brackets]		Raychem Devices	DOCUMENT NO.: D-436-96		
TOLERANCES: 0.00 ± 0.02 MM, 0.0 ± 0.2 MM, 0 ± 0.5 MM	ANGLES: ± 0°30' 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: A	DATE: October 13, 2011	
PREPARED BY: *YNGUYEN*	CAGE CODE: 06090	ECO NUMBER: ECO-11-020627	SCALE: NTS	SIZE: A	SHEET: 1 of 2

ASSEMBLY PROCEDURE

1. SCOPE

This document outlines the procedure to be followed to obtain immersion resistant multiple wire butt splices using Multi-Wire In- Line Splice Sealing system D-436-96.

2. PROCEDURE

a) Pass the wires to be attached to one barrel through the separate multi-wire seal (3).
Pass the wires to be attached to the other barrel through the sealing sleeve from the three hole insert end.

b) Strip wires 10.31 mm (0.406 in) to 11.13 mm (0.438 in) and crimp into splice using a TE Connectivity 69355 crimp tool.
Care must be taken so that the wires remain untwisted between the splice and the separate multi-wire seal (3) or the sealing sleeve cannot be positioned properly.

c) Position the separate multi-wire seal (3) as close as possible to the splice. Hold this piece in position by squeezing the wires directly behind it, and slide the sealing sleeve over the assembly so that the separate multi-wire seal (3) is as far inside the sleeve as possible.

d) Apply heat, using the recommended heat source, first to the separate multi-wire seal end, and then to the other.
Heat should be applied until insert melts and flows axially along the wire.

3. RECOMMENDED RAYCHEM HEATING TOOLS

Heater Reflector Recommended setting
Heat Gun CV-1981 PR52D 7.5 - 8 on Dial
Steinel HL-1910E PR52D 8 - 9 on Dial
Steinel HL-2010E PR52D 750-800F on LCD