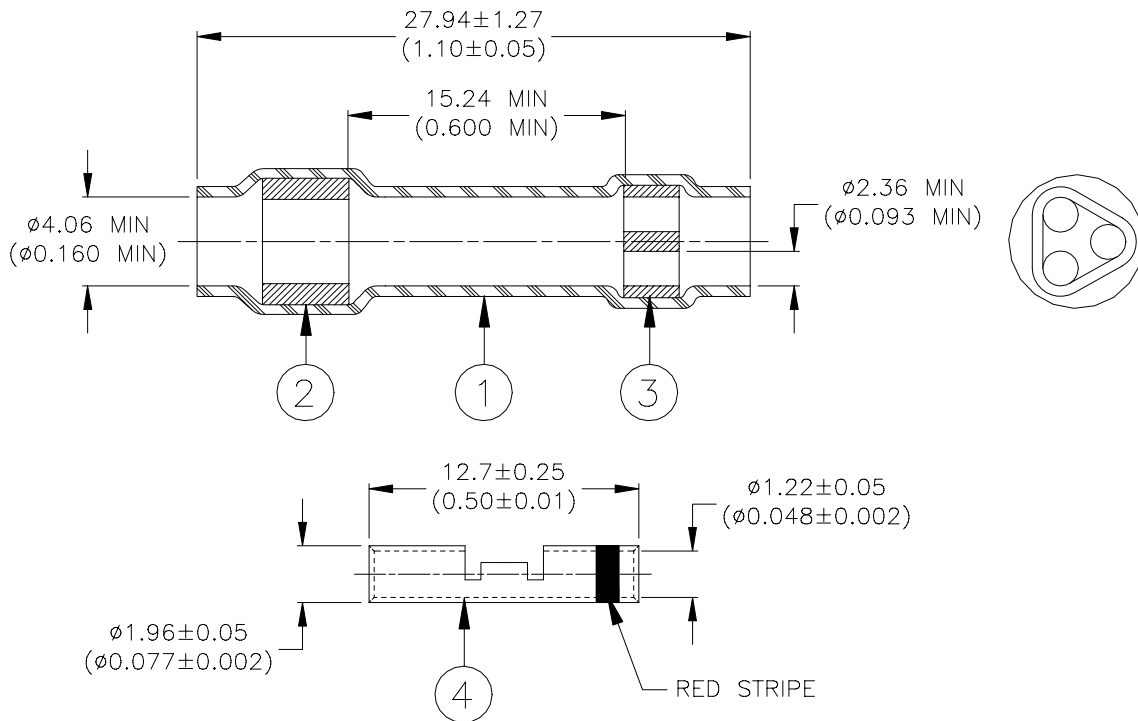


SPECIFICATION CONTROL DRAWING



MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
2. SINGLE WIRE SEAL: Low outgassing immersion resistant thermoplastic.
3. THREE WIRE SEAL: Low outgassing immersion resistant thermoplastic.
4. CRIMP SPLICE: Base Metal: Copper Alloy 102 per ASTM B-75.
Plating: Tin, per MIL-T-10727, Type I

Wire Size Range of Crimp Splice

Size	One Wire		Two Wires		Three Wires	
	min	max	min	max	min	max
20 - 26	26	20	26	24	28	26

APPLICATION

1. These parts are designed to provide immersion resistant in-line splices of 2 or 3 to 1 wires falling within size range listed above, and having insulations rated for 135°C.
2. Parts are available only as an assembly of one each item #I and item #II.
3. Parts are to be installed following Devices Assembly Procedure (see sheet 2 of 2).
4. Inside diameter and outside diameter of splicer are to be measured in crimp areas, 2.54 to 5.08 (0.100 to 0.200) from ends of part. Slight burr permitted on parted surfaces.
5. Packing and packaging shall be accordance with Section 5, Level C, of MIL-T-7928.
6. This document takes precedence over documents referenced herein.
7. For other sizes of this configuration, see Devices specification Control Drawings D-436-42/-43.

tyco <i>Electronics</i>	Tyco Electronics Corporation 305 Constitution Drive Menlo Park, CA 94025, USA	Raychem Products	TITLE: IN-LINE SPLICE SEALING SYSTEM, 2 or 3 to 1 SPLICE: TIN PLATED, COLOR CODED with Inspection Slots				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS. INCHES DIMENSIONS ARE BETWEEN BRACKETS.			DOCUMENT NO.: D-436-0110				
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.			DATE: 14-Nov.-00	DOC ISSUE: 1	
DRAWN BY: M. FORONDA	REPLACES: N/A	DCR NUMBER: D001273	PROD. REV. A	SCALE: None	SIZE: A	SHEET: 1 of 2	

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SPECIFICATION CONTROL DRAWING

DEVICES ASSEMBLY PROCEDURE

1.0 SCOPE

This document outlines the procedure to be followed to obtain immersion resistant 3 or 2 to 1 in-line splices using Devices In-line Splice Sealing System D-436-0110.

2.0 PROCEDURE

- a. Strip all wires 6.35 to 7.92 (0.250 to 0.312).
- b. Attach the single lead to the appropriate size crimp splicer using a Raychem AD-1377 crimp tool.
- c. Pass the wires to be attached to the other barrel through the sealing sleeve from the three-hole insert end.
- d. Insert wires into barrel and crimp. Care must be taken so that wires remain untwisted between the crimp splicer and the three wire seal or the sealing sleeve cannot be positioned properly.
- e. Apply heat, first to the three-hole insert and then to the other. Heat should be applied until insert melts and flows axially along the wire.

tyco <i>Electronics</i>		Tyco Electronics Corporation 305 Constitution Drive Menlo Park, CA 94025, USA		Raychem Products		TITLE: IN-LINE SPLICE SEALING SYSTEM, 2 or 3 to 1 SPLICE: TIN PLATED, COLOR CODED with Inspection Slots	
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DRAWN BY: M. FORONDA		REPLACES: N/A		DCR NUMBER: D001273		PROD. REV. A	SCALE: None
						SIZE: A	SHEET: 2 of 2

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