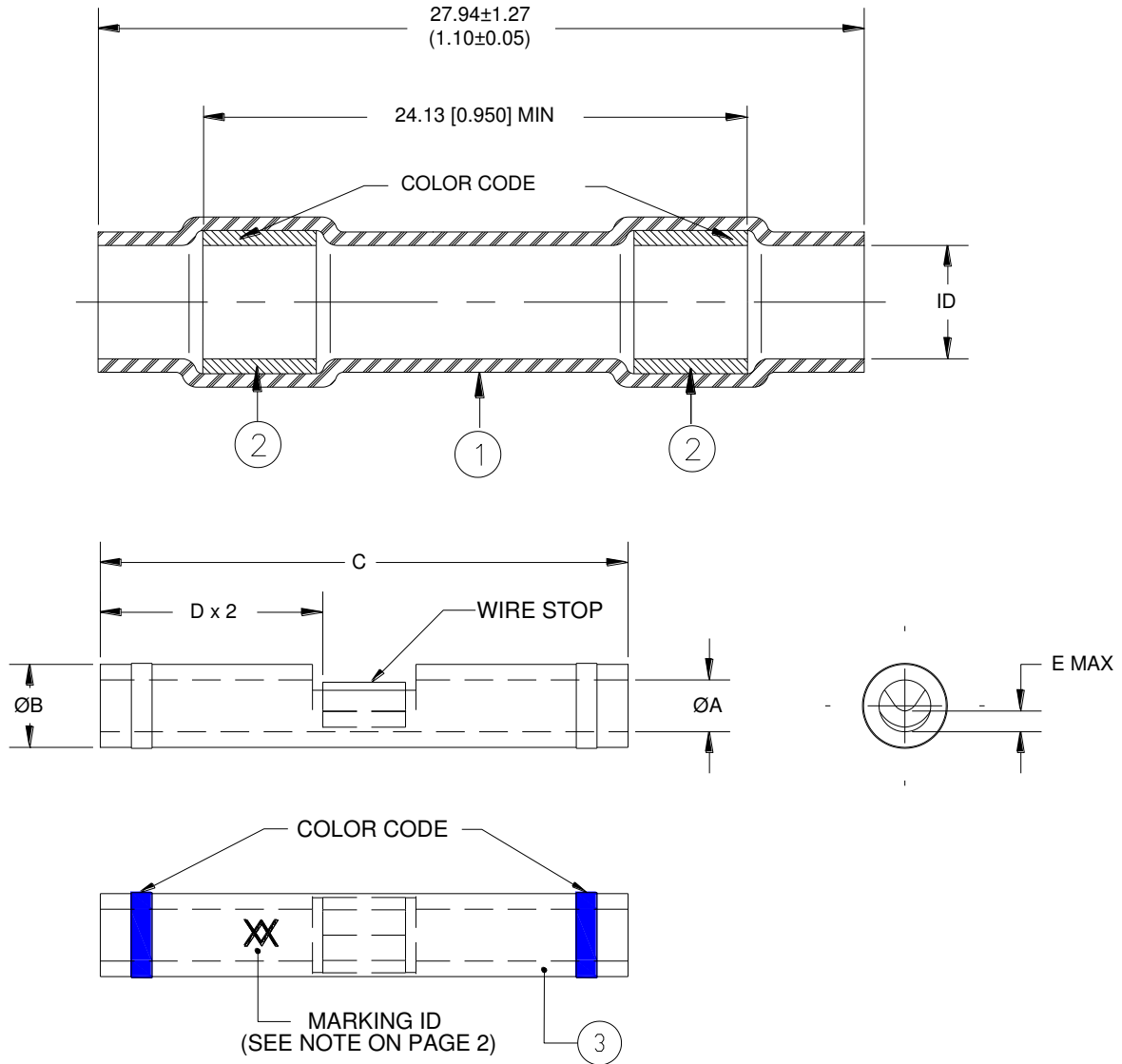


## CUSTOMER DRAWING



### **MATERIALS**

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene flouride.
2. MELTABLE RINGS: Immersion resistant thermoplastic; one clear, one color coded per table I.
3. CRIMP SPLICER: Base Metal: Copper Alloy 101 or 102 per ASTM B-75.  
Plating: Nickel per QQ-N-290.  
Color Code: See table I.  
Stamp marking XX approximately as shown on the back of inspection window.

|                                                                                                         |                                           |                                                                                                                                                            |                                  |  |                                                                       |                    |                |                      |
|---------------------------------------------------------------------------------------------------------|-------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------|--|-----------------------------------------------------------------------|--------------------|----------------|----------------------|
|  TE Connectivity     |                                           |                                                                                                                                                            | Raychem<br>Devices               |  | TITLE :<br>(NICKEL PLATED CRIMPS)<br>IN-LINE SPLICE SEALING<br>SYSTEM |                    |                |                      |
| Unless otherwise specified dimensions are in millimeters.<br>Inches dimensions are in between brackets. |                                           |                                                                                                                                                            |                                  |  | DOCUMENT NO.: D-436-82/-84                                            |                    |                |                      |
| TOLERANCES:<br>0.00 N/A<br>0.0 N/A<br>0 N/A                                                             | ANGLES: N/A<br><br>ROUGHNESS IN<br>MICRON | TE Connectivity reserves the right to amend<br>this drawing at any time. Users should<br>evaluate the suitability of the product for their<br>application. |                                  |  | DATE:<br><br>August 17, 2016                                          |                    | REV.<br><br>E  |                      |
| DRAWN BY:<br><br>tnguyen                                                                                |                                           | CAGE CODE:<br><br>06090                                                                                                                                    | ECO NUMBER:<br><br>ECO-14-012043 |  | PROD. REV.<br><br>SEE TABLE                                           | SCALE:<br><br>None | SIZE:<br><br>A | SHEET:<br><br>1 of 3 |

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# CUSTOMER DRAWING

**TABLE I – DIMENSION TABLE**

| Part Name | I.D.*<br>a min<br>b max             | Crimp Splicer                       |                                     |                                       |                                     |                 |            |                  |
|-----------|-------------------------------------|-------------------------------------|-------------------------------------|---------------------------------------|-------------------------------------|-----------------|------------|------------------|
|           |                                     | øA                                  | øB                                  | C                                     | D                                   | E max           | Color Code | Wgt. Lbs/Mpc max |
| D-436-82  | <u>2.16 (0.085)</u><br>0.64 (0.025) | <u>1.27 (0.050)</u><br>1.14 (0.045) | <u>2.03 (0.080)</u><br>1.91 (0.075) | <u>12.95 (0.510)</u><br>12.45 (0.490) | <u>6.22 (0.245)</u><br>5.72 (0.225) | 0.38<br>(0.015) | Red        | 1.02             |
| D-436-83  | <u>2.79 (0.110)</u><br>0.64 (0.025) | <u>1.75 (0.069)</u><br>1.63 (0.064) | <u>2.70 (0.106)</u><br>2.57 (0.101) | <u>14.86 (0.585)</u><br>14.35 (0.565) | <u>7.11 (0.280)</u><br>6.60 (0.260) | 0.51<br>(0.020) | Blue       | 1.61             |
| D-436-84  | <u>4.32 (0.170)</u><br>0.64 (0.025) | <u>2.60 (0.102)</u><br>2.46 (0.097) | <u>3.89 (0.153)</u><br>3.73 (0.147) | <u>14.86 (0.585)</u><br>14.35 (0.565) | <u>7.11 (0.280)</u><br>6.60 (0.260) | 1.27<br>(0.050) | Yellow     | 2.72             |

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

**TABLE II – RECOMMENDED WIRE RANGE BASED ON CONDUCTOR CMA (mm<sup>2</sup>) (REFERENCE)**

| PART NUMBER | MIL SPEC EQUIVALENT SIZE | SINGLE WIRE | MULTIPLE WIRE RANGE CMA (mm <sup>2</sup> ) | MULTIPLE WIRE TOTAL OD (OD <sub>1</sub> + OD <sub>2</sub> ) MAX |
|-------------|--------------------------|-------------|--------------------------------------------|-----------------------------------------------------------------|
| D-436-82    | M81824/6                 | 26-24-22-20 | 304 - 1510 (0.15 - 0.75)                   | 0.085 (2.16)                                                    |
| D-436-83    | M81824/6                 | 20-18-16    | 1058 - 2680 (0.53 – 1.34)                  | 0.110 (2.79)                                                    |
| D-436-84    | M81824/6                 | 16-14-12    | 2375 – 6755 (1.19 – 3.37)                  | 0.170 (4.32)                                                    |

**TABLE III – STANDARD CONDUCTOR CMA (REFERENCE)**

| CONDUCTOR CONFIGURATION | SIZE   |        |        |        |        |        |        |        |
|-------------------------|--------|--------|--------|--------|--------|--------|--------|--------|
|                         | 26     | 24     | 22     | 20     | 18     | 16     | 14     | 12     |
| STRANDS                 | 19     | 19     | 19     | 19     | 19     | 19     | 19     | 37     |
| CMA                     | 304    | 475    | 754    | 1216   | 1900   | 2426   | 3831   | 5874   |
| (MM <sup>2</sup> )      | (0.15) | (0.24) | (0.38) | (0.61) | (0.95) | (1.21) | (1.92) | (2.94) |

## APPLICATION

- These parts are designed to provide an immersion resistant in-line splices, maximum of two wires per side of crimp and falling within the diameter range specified in this customer drawing and having insulations rated for at least 135°C.
- Parts will meet all performance requirements of AS81824/6<sup>Tm</sup>, EN 3373-001 and EN 3373-012 when installed as outlined below.
- Acceptance sampling shall be in accordance with Paragraph 4.6.1 of AS81824<sup>Tm</sup>.
- Packing and packaging shall be in accordance with Section 5, Level C, of AS81824<sup>Tm</sup>.
- This document takes precedence over documents referenced herein.

- <sup>Tm</sup>–AS81824 is a trademark of SAE

|                                                                                                         |                                           |                                                                                                                                                            |                                  |                              |                                                                       |                |                      |
|---------------------------------------------------------------------------------------------------------|-------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------|------------------------------|-----------------------------------------------------------------------|----------------|----------------------|
|  TE Connectivity     |                                           |                                                                                                                                                            | Raychem<br>Devices               |                              | TITLE :<br>(NICKEL PLATED CRIMPS)<br>IN-LINE SPLICE SEALING<br>SYSTEM |                |                      |
| Unless otherwise specified dimensions are in millimeters.<br>Inches dimensions are in between brackets. |                                           |                                                                                                                                                            |                                  | DOCUMENT NO.: D-436-82/-84   |                                                                       |                |                      |
| TOLERANCES:<br>0.00 N/A<br>0.0 N/A<br>0 N/A                                                             | ANGLES: N/A<br><br>ROUGHNESS IN<br>MICRON | TE Connectivity reserves the right to amend<br>this drawing at any time. Users should<br>evaluate the suitability of the product for their<br>application. |                                  | DATE:<br><br>August 17, 2016 |                                                                       | REV.<br><br>E  |                      |
| DRAWN BY:<br><br>tnguyen                                                                                |                                           | CAGE CODE:<br><br>06090                                                                                                                                    | ECO NUMBER:<br><br>ECO-14-012043 | PROD. REV.<br><br>SEE TABLE  | SCALE:<br><br>None                                                    | SIZE:<br><br>A | SHEET:<br><br>2 of 3 |

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## CUSTOMER DRAWING

### ASSEMBLY PROCEDURE:

1. Slide sealing sleeve over both wire on one side of the crimp if two wires will be use.
2. Strip wires 7.95 [5/16"] to 8.73 [11/32"].
3. Insert one or two wires on one side of the crimp barrel and crimp using a Raychem AD-1377 crimp tool. Repeat on the opposite side of the crimp..
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.

|                                                                                                            |                                           |                                                                                                                                                            |                                                                                |                |               |                  |  |
|------------------------------------------------------------------------------------------------------------|-------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------|----------------|---------------|------------------|--|
|  <b>TE Connectivity</b> |                                           | <b>Raychem</b><br>Devices                                                                                                                                  | TITLE :<br><b>(NICKEL PLATED CRIMPS)<br/>IN-LINE SPLICE SEALING<br/>SYSTEM</b> |                |               |                  |  |
| Unless otherwise specified dimensions are in millimeters.<br>Inches dimensions are in between brackets.    |                                           |                                                                                                                                                            | DOCUMENT NO.: <b>D-436-82/-84</b>                                              |                |               |                  |  |
| TOLERANCES:<br>0.00 N/A<br>0.0 N/A<br>0 N/A                                                                | ANGLES: N/A<br><br>ROUGHNESS IN<br>MICRON | TE Connectivity reserves the right to amend<br>this drawing at any time. Users should<br>evaluate the suitability of the product for their<br>application. | DATE:<br><br>August 17, 2016                                                   |                | REV.<br><br>E |                  |  |
| DRAWN BY:<br>tnguyen                                                                                       | CAGE CODE:<br>06090                       | ECO NUMBER:<br>ECO-14-012043                                                                                                                               | PROD. REV.<br>SEE TABLE                                                        | SCALE:<br>None | SIZE:<br>A    | SHEET:<br>3 of 3 |  |

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