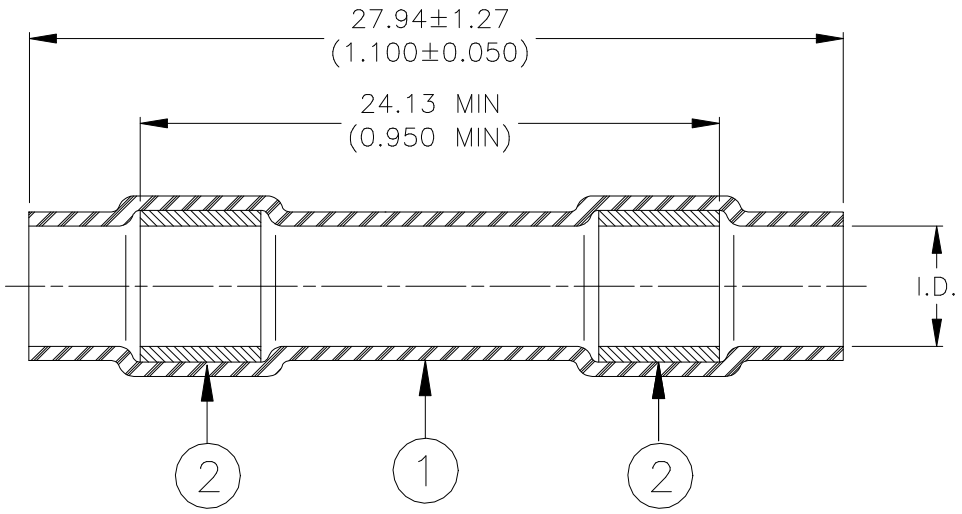
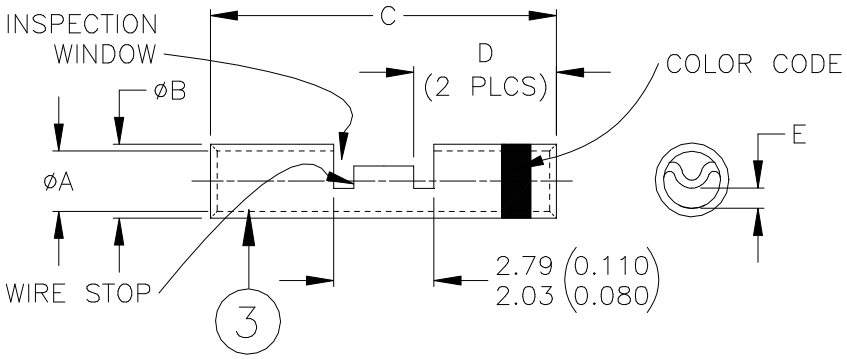
SPECIFICATION CONTROL DRAWING



SEALING SLEEVE



METAL CRIMP SPLICE

Product Name	Rev	I.D.* a (min) b (max)	Product Dimensions A	B	C	D	E max
D-436-36	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)
D-436-37	A	2.79 (0.110) 0.64 (0.025)	1.75 (0.069) 1.63 (0.064)	2.69 (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)
D-436-38	A	4.32 (0.170) 0.64 (0.025)	2.59 (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)

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

TE Connectivity 305 Constitution Drive Menlo Park, CA 94025, USA	***Raychem*** Products		TITLE: **IN-LINE SPLICE SEALING SYSTEM, 1 TO 1 MIL-S-81824/1**			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS. INCHES DIMENSIONS ARE BETWEEN BRACKETS.			DOCUMENT NO.: **D-436-36/-37/-38**			
TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A	ANGLES: N/A ROUGHNESS IN MICRON	TE Connectivity reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.	DATE: 11MAY11			DOC ISSUE: 2
DRAWN BY: M. FORONDA	REPLACES: N/A	DCR NUMBER: D000566	PROD. REV. SEE TABLE	SCALE: None	SIZE: A	SHEET: 1 of 2

SPECIFICATION CONTROL DRAWING

MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
2. SEALING RINGS: Immersion resistant thermoplastic. Color: one clear, one color coded (see table below).
3. CRIMP SPLICER:
   Base Metal: Copper alloy 101 or 102 per ASTM B-75.
   Plating: Tin, per MIL-T-10727, Type I
   Color code: See table below.

Product Name	MIL Spec Equivalent	Wire Range (AWG)	Color Code	Wgt. - Lbs/Mpc max
D-436-36	M81824/-1-1	26 - 20	RED	1.02
D-436-37	M81824/-1-2	20 - 16	BLUE	1.61
D-436-38	M81824/-1-3	16 - 12	YELLOW	2.720

APPLICATION

1. These parts are designed to provide immersion resistant in-line splices of 1 to 1 wires falling within size range listed above, and having insulations rated for 135°C.
2. Parts will meet all requirements of MIL-S-81824/1 when installed as outlined below. Assembly is not required for acceptance testing inspection.
3. Acceptance sampling shall be in accordance with Paragraph 4.6.1 of MIL-S-81824.
4. Packing and packaging shall be in accordance with Sections 5, Level C, of MIL-S-81824.
5. This document takes precedence over documents reference herein.

ASSEMBLY PROCEDURE:

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