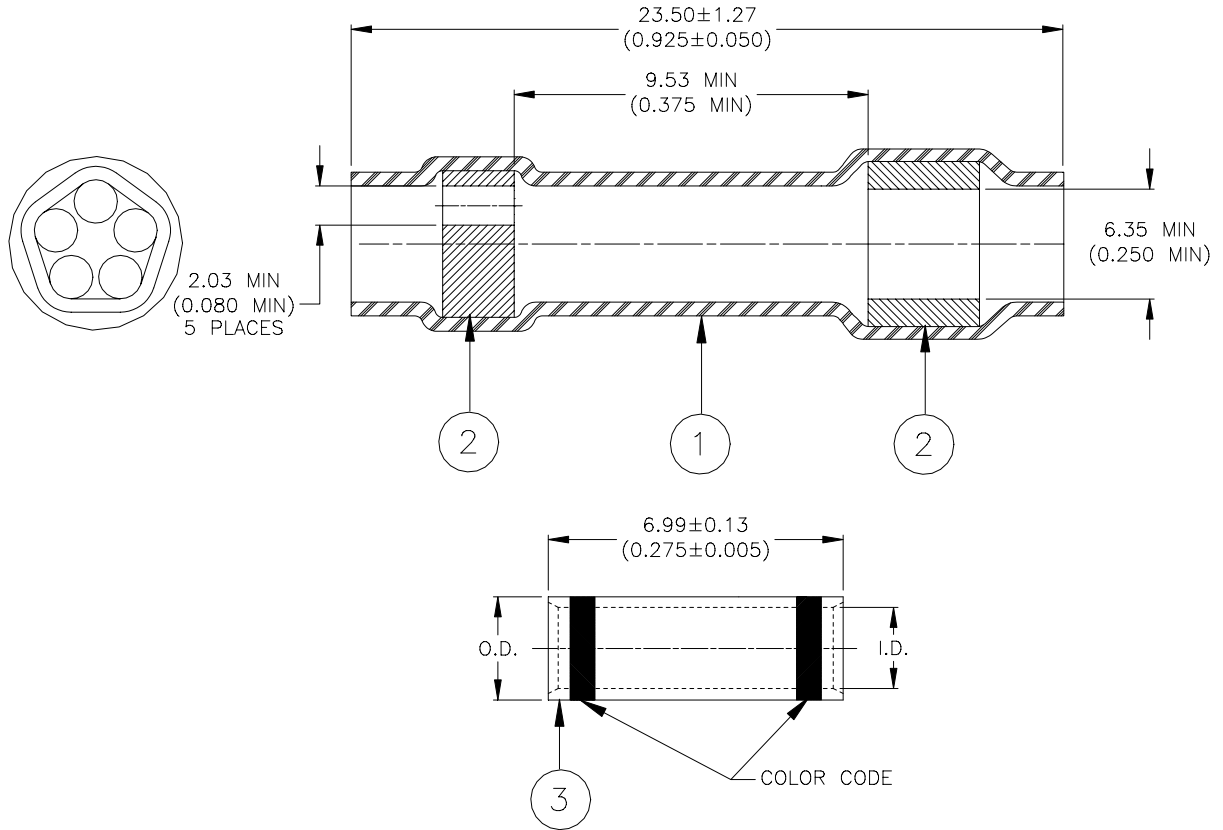


# SPECIFICATION CONTROL DRAWING



## **MATERIALS**

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
2. MELTABLE SEALING RINGS: Modified thermoplastic.
3. SEAMLESS STUB SPLICER: Base Metal: Copper Alloy 101 or 102 per ASTM B-75.  
Plating: Nickel per QQ-N-290.  
Color code: See table below.

### Dimensions of Stub Splicer:

Part Name	Prod. Rev.	CMA Range*	I.D.	O.D.	Max. Weight	Color Code
D-436-77	D	779 - 2680	<u>1.75 (0.069)</u> 1.65 (0.065)	<u>2.67 (0.105)</u> 2.57 (0.101)	1.65 lbs/Mpc	Blue
D-436-78	D	1900 - 6755	<u>2.60 (0.102)</u> 2.49 (0.098)	<u>3.89 (0.153)</u> 3.73 (0.147)	2.15 lbs/Mpc	Yellow

\* Not all wire combinations falling within the CMA range can be accommodated within the splicer barrel. For list of some of the usable wire combinations which can be spliced and sealed, see Thermofit Splicing Table D-436-60/-61.

<b>tyco</b> Electronics		Tyco Electronics Corporation 305 Constitution Drive Menlo Park, CA 94025, USA		<b>Raychem</b> Products		TITLE: <b>STUB SPLICE SEALING SYSTEM MULTI-WIRE</b>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS. INCHES DIMENSIONS ARE BETWEEN BRACKETS.				DOCUMENT NO.: <b>D-436-77/-78</b>			
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: 05-Dec.-00	
DOC ISSUE: 1		REPLACES: N/A		DCR NUMBER: D001300		PROD. REV. SEE TABLE	
DRAWN BY: M. FORONDA		REPLACES: N/A		DCR NUMBER: D001300		SCALE: None	
SIZE: A		SHEET: 1 of 2		PROD. REV. SEE TABLE		SCALE: None	

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# SPECIFICATION CONTROL DRAWING

## APPLICATION

1. These parts are designed to provide an immersion resistant stub splices made with wires having insulations rated for at least 135°C.
2. Part will seal assemblies which require insertion of not more than two wires per hole of the inserts. If two wires are inserted through one hole, they must be of same gauge size.
3. Recovered dimensions of insulation sleeve: I.D – 3.18 (0.125) max  
Wall – 0.33 (0.013) min

## INSTALLATION PROCEDURE:

1. Pass wires to be crimped through the holes of the multi-holed insert (NOT MORE THAN TWO WIRES THROUGH ANY HOLE). Care must be taken to avoid twisting of the wires as this will prevent proper positioning of the sleeve.
2. Strip wires 7.94 to 8.73 (5/16" to 11/32").
3. Insert wires into crimp splicer leaving a gap of 0.79 (1/32") between the wire insulation and the barrel.
4. Crimp using a Raychem AD-1377 Crimp Tool or equivalent
5. Slide sleeve as close as possible to the crimp barrel. Hold sleeve in this position by squeezing the wires directly behind it.
6. Apply heat as follows:
  - a) Use a Raychem Model 500A Thermogun, equipped with a TG-14A reflector.
  - b) Adjust side vent of Thermogun to give an air-stream temperature of 650 – 750°F.
  - c) Center assembly in the reflector well long enough to cause the center section of the sleeve to recover and lock itself in place.
  - d) Move assembly to position the top (major wire entry end) in the hot air-stream. Hold in this position until insert has completely melted and flowed axially along the wires.
  - e) Apply heat to bottom of sleeve until insert melts and flows.
  - f) The total time required to install the sealing sleeve is dependent upon the air-stream temperature and mass of the crimped assembly being encapsulated.

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