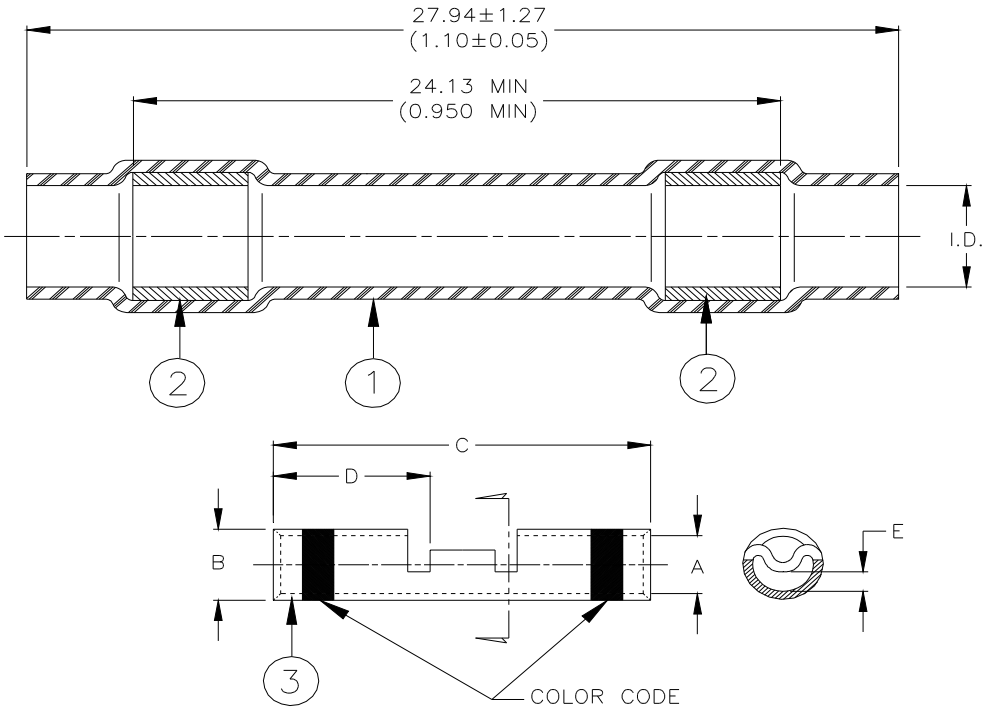
# SPECIFICATION CONTROL DRAWING




## 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.
3. CRIMP SPLICER: Base Metal: Copper Alloy 101 or 102 per ASTM B-75.
   Plating: Nickel per QQ-N-290.
   Color Code: See table below.

Dimensions:

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

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

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| TE connectivity | TE Connectivity<br>305 Constitution Drive<br>Menlo Park, CA 94025, USA | **Raychem** Products | TITLE :<br>**(NICKEL PLATED CRIMPS) IN-LINE SPLICE SEALING SYSTEM, 1 TO 1** | | | | |
| 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 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:<br>15-Apr-11 | | | DOC ISSUE:<br>3 | |
| DRAWN BY:<br>mforonda | REPLACES:<br>D001298 | DCR NUMBER:<br>D020028 | PROD. REV.<br>SEE TABLE | SCALE:<br>None | SIZE:<br>A | SHEET:<br>1 of 2 | |

Print Date: 9-May-11 If this document is printed it becomes uncontrolled. Check for the latest revision.

# SPECIFICATION CONTROL DRAWING

| Part Name | Prod Rev. | MIL Spec Equivalent Size | Wire Range | Wgt. Lbs/Mpc max |
|---|---|---|---|---|
| D-436-82 | C | M81824/1-1 | 26-20 | 1.02 |
| D-436-83 | C | M81824/1-2 | 20-16 | 1.61 |
| D-436-84 | C | M81824/1-3 | 16-12 | 2.72 |

## APPLICATION

1. These parts are designed to provide an immersion resistant in-line splices of 1 to 1 wires falling within the size range listed on sheet 1, and having nickel plated conductors and insulations rated for at least 135°C.
2. Parts will meet all performance requirements of MIL-S-81824/1, EN 3373-001 and EN 3373-012 when installed as outlined below.
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 Section 5, Level C, of MIL-S-81824.
5. This document takes precedence over documents referenced herein.

ASSEMBLY PROCEDURE:

a. Slide sealing sleeve onto one of the wires to be spliced.
b. Strip wires 5/16” to 11/32”.
c. Insert one wire into barrel of crimp splicer and crimp using a Raychem AD-1377 crimp tool. Repeat for the other wire.
d. Center sealing sleeve over the splice.
e. 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.