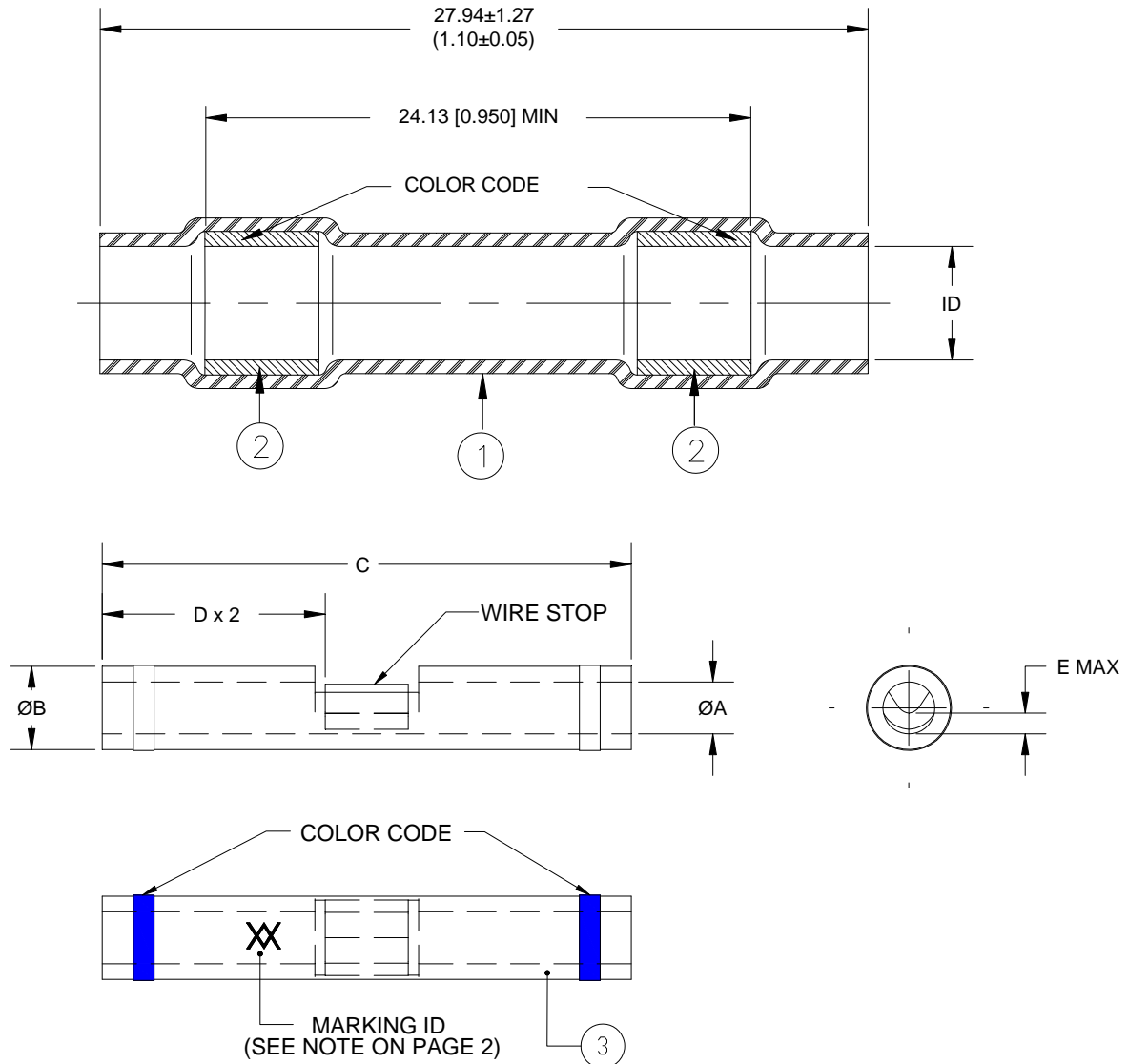



## CUSTOMER DRAWING



### **MATERIALS**

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
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.  
Stamp marking XX approximately as shown on the back of inspection window.

 TE Connectivity			Raychem Devices		TITLE : (NICKEL PLATED CRIMPS) IN-LINE SPLICE SEALING SYSTEM, 1 TO 1		
Unless otherwise specified dimensions are in millimeters. Inches dimensions are in between brackets.				DOCUMENT NO.: D-436-82/-84			
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:  February 21, 2014		REV.  D	
DRAWN BY:  nguyen	CAGE CODE:  06090	ECO NUMBER:  ECO-14-002613		PROD. REV.  SEE TABLE	SCALE:  None	SIZE:  A	SHEET:  1 of 2

© 2014 Tyco Electronics Corporation. All rights reserved.

If this document is printed it becomes uncontrolled. Check for the latest revision.

## CUSTOMER DRAWING

Dimensions:

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

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


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

- 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.
- Parts will meet all performance requirements of MIL-S-81824/1, EN 3373-001 and EN 3373-012 when installed as outlined below.
- Acceptance sampling shall be in accordance with Paragraph 4.6.1 of MIL-S-81824.
- Packing and packaging shall be in accordance with Section 5, Level C, of MIL-S-81824.
- This document takes precedence over documents referenced herein.

### ASSEMBLY PROCEDURE:

- Slide sealing sleeve onto one of the wires to be spliced.
- Strip wires 5/16" to 11/32".
- Insert one wire into barrel of crimp splicer and crimp using a Raychem AD-1377 crimp tool. Repeat for the other wire.
- Center sealing sleeve over the splice.
- 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> Devices	TITLE : <b>(NICKEL PLATED CRIMPS) IN-LINE SPLICE SEALING SYSTEM, 1 TO 1</b>				
Unless otherwise specified dimensions are in millimeters. Inches dimensions are in between brackets.				DOCUMENT NO.: <b>D-436-82/-84</b>			
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: February 21, 2014	REV. D		
DRAWN BY: tnguyen	CAGE CODE: 06090	ECO NUMBER: ECO-14-002613	PROD. REV. SEE TABLE	SCALE: None	SIZE: A	SHEET: 2 of 2	

© 2014 Tyco Electronics Corporation. All rights reserved.

If this document is printed it becomes uncontrolled. Check for the latest revision.