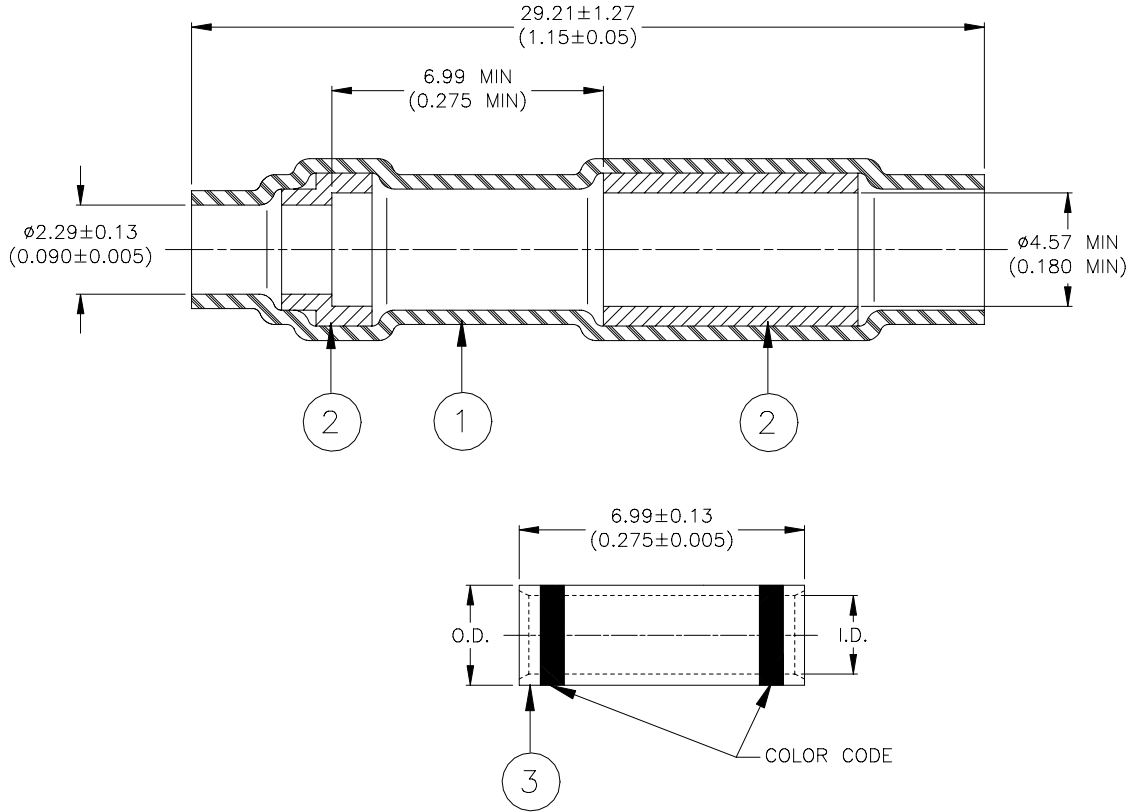


# SPECIFICATION CONTROL DRAWING



## MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene flouride.
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-436-75	A	779 - 2680	1.75 (0.069)	2.67 (0.105)	1.40 lbs/Mpc	Blue
			1.65 (0.065)	2.57 (0.101)		
D-436-76	A	1900 - 6755	2.60 (0.102)	3.89 (0.153)	1.80 lbs/Mpc	Yellow
			2.49 (0.098)	3.73 (0.147)		

\* 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-436-58/-59.

<b>tyco</b> <i>Electronics</i>		Tyco Electronics Corporation 305 Constitution Drive Menlo Park, CA 94025, USA		<b>Raychem</b> Products		TITLE: <b>STUB SPLICE SEALING SYSTEM</b>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS. INCHES DIMENSIONS ARE BETWEEN BRACKETS.				DOCUMENT NO.: <b>D-436-75/-76</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	
DRAWN BY: M. FORONDA		REPLACES: N/A		DCR NUMBER: D001299		PROD. REV. SEE TABLE	
				SCALE: None		SIZE: A	
						DOC ISSUE: 1	
						SHEET: 1 of 2	

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## SPECIFICATION CONTROL DRAWING

### APPLICATION

1. These parts are designed to provide an immersion resistant 2 wire stub splices or 2 to 1 parallel splices made with wire having insulations rated for at least 135°C.
2. These parts are available only as an assembly of one of each sealing sleeve and splicer.
3. Recovered dimensions of Insulation Sleeve: I.D – 2.41 (0.095) max  
Wall – 0.36 (0.014) min

### INSTALLATION PROCEDURE:

1. Strip wires 5/16” to 11/32”.
2. Insert wires into crimp splicer leaving a gap of 1/32” between the wire insulation and the barrel. Note in doing parallel splices, the sealing sleeve must be placed on the single wire – small end away from the stripped conductor – prior to insertion of the wire into the crimper.
3. Crimp using a Raychem AD-1377 Crimp Tool or equivalent
4. Position sealing sleeve over assembly so that the crimp barrel bottoms against the shoulder of the sleeve.
5. 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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