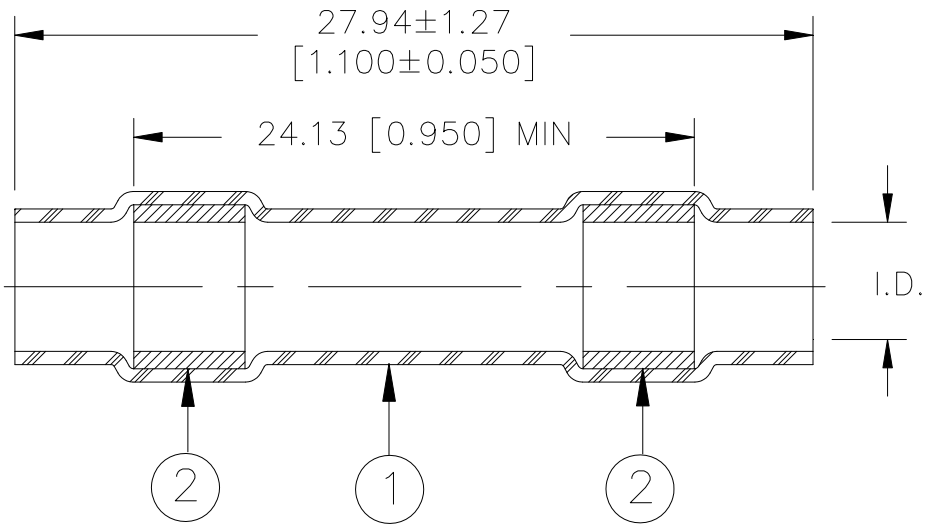
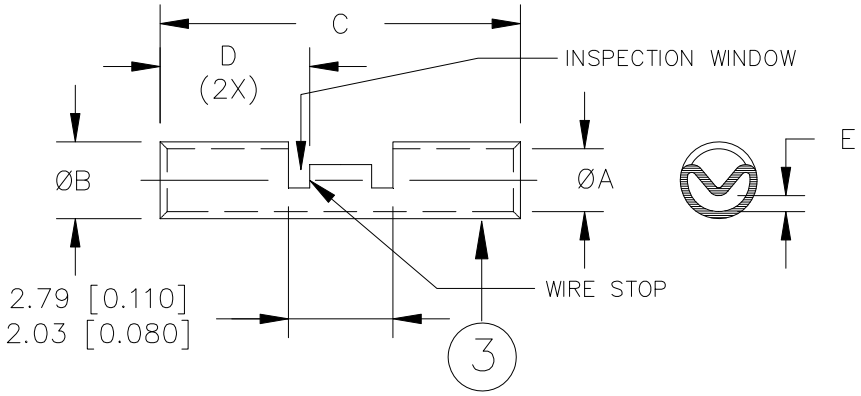
CUSTOMER DRAWING



SEALING SLEEVE



METAL CRIMP SPLICE

Product Rev Product Name	I.D.* a (min) b (max)	Product Dimensions				
		A	B	C	D	E max
D-436-36-UP	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)

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

Tyco Electronics	300 Constitution Dr Menlo Park, CA 94025, U.S.A.	TITLE: **IN-LINE SPLICE SEALING SYSTEM, UN-PLATED**		
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]	Raychem Devices	DOCUMENT NO.: **D-436-36-UP**		
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.	REV: A	DATE: February 16, 2011	
REVISED BY: *UNGUYEN*	CAGE CODE: 06090	ECO NUMBER: ECO-11-003297	SCALE: NTS	SIZE: A / SHEET: 1 of 2

CUSTOMER 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: None

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. 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.