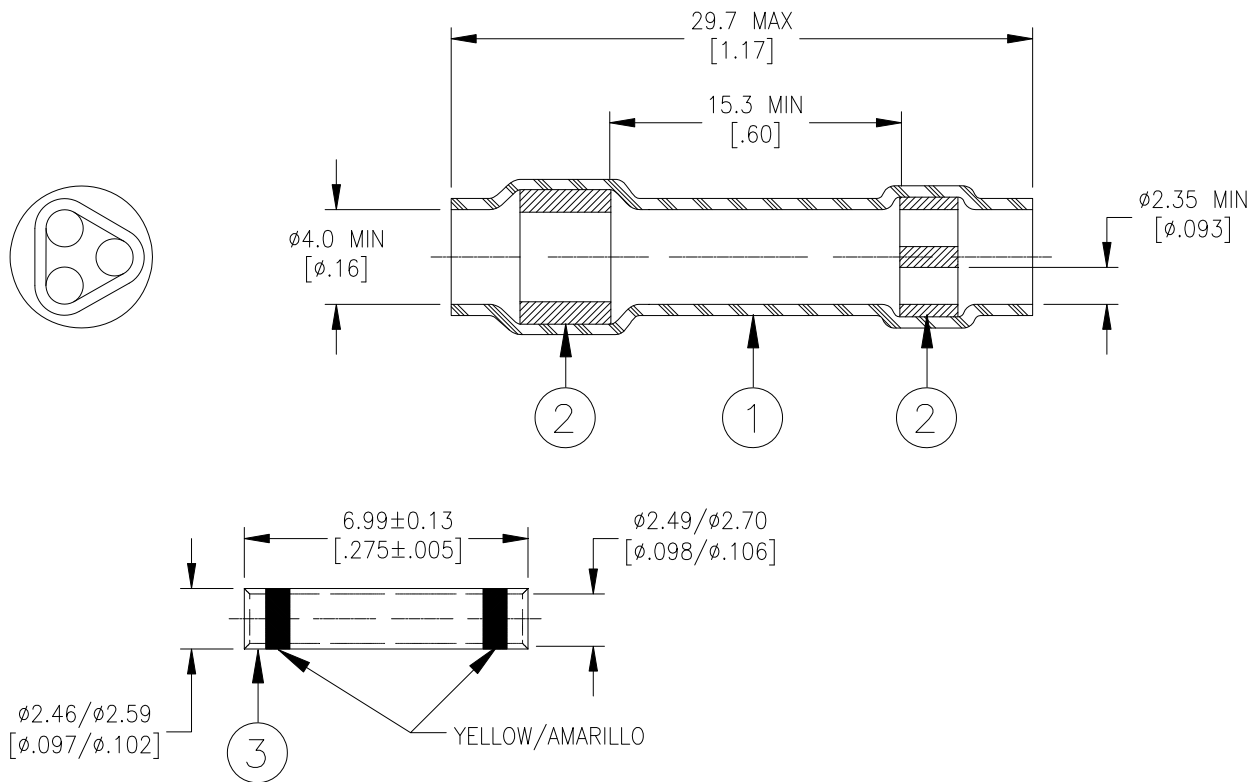



CUSTOMER DRAWING

MATERIALS

1. **INSULATION SLEEVE:** Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
2. **MELTABLE SEALING RINGS:** Immersion resistant modified thermoplastic fluoroelastomer.
Color: Blue.
3. **SEAMLESS STUB SPLICER:**
Base Metal: Copper Alloy 101 or 102 per ASTM B-75.
Plating: Nickel per SAE AMS-QQ-N-290.



 TE Connectivity			TITLE: STUB SPLICE MULTI-WIRE SEALING SYSTEM, 16 THRU 12 AWG, Ni PLATED		
<small>UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN MILLIMETER. INCHES DIMENSIONS ARE IN BETWEEN [xxx] BRACKETS.</small>		Raychem Devices	DOCUMENT NO.: D-436-99		
TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A	ANGLES: N/A ROUGHNESS IN MICRON	<small>Tyco Electronics reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.</small>	REV: A1	DATE: June 17, 2015	
PREPARED BY: RODRIGUEZ	CAGE CODE: 06090	ECO NUMBER: ECO-15-009034	SCALE: NTS	SIZE: A	SHEET: 1 of 2

© 2015 TE CONNECTIVITY LTD. FAMILY OF COMPANIES. ALL RIGHT RESERVED.

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

CUSTOMER DRAWING

APPLICATION

1. This part is designed to provide an immersion resistant seal to 2 to 6 conductors having insulations rated for at least +135°C, when spliced with a stub crimp splice.
2. Splice 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, and the combined jacket outside diameter shall no exceed the inside diameter of the sealing insert.
3. Temperature range: -65°C to +175°C.

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 TE Connectivity 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 TE Connectivity HL1910E or HL2010E heat guns, equipped with a PR-25D reflector.
 - b) Adjust side vent of the heat gun to give an air-stream temperature of 650F – 750F.
 - 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.

DOCUMENT NO.: D-436-99	REV: A1	ECO NUMBER: ECO-15-009034	DATE: June 17, 2015	SHEET: 2 of 2
----------------------------------	------------	------------------------------	------------------------	------------------