Unless otherwise specified dimensions are in millimeters. Inches dimensions are in between brackets.

1.0 Scope

This document outlines the procedure to be followed to obtain immersion resistant in-line splices using Raychem in-line splice sealing system W-095-01/02/03, W-095-04/05/06/08 or W-096-01/02/03.

2.0 Procedure

A. Select the appropriate size crimp barrel from the table;
B. Slide sealing sleeve onto one of the wires to be spliced;
C. Strip wires 8.00 to 8.70 (0.315 – 0.343).
D. Insert wire(s) into barrel of crimp splice which has been placed in correct color crimp location and crimp. Repeat for other wire(s). The use of test gauge AD 1386 controls calibration of the crimp tool;
E. Slide sealing sleeve into position so that crimp splice is centered between the sealing rings;
F. Apply heat, using the recommended 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.

3.0 Recommended Tools

A. Crimp tool:
Raychem AD 1377-S color coded to obviate incorrect crimping.
B. Heating tools:
Use one of the following heating tools, or a TE Connectivity approved alternative.

1. Steinel HL-1910E or HL2010E with Reflector part no. PR-25. Temperature setting: 399°C - 427°C (750°F - 800°F)
2. CV-1981 Digital with Reflector part no. PR13C. Temperature setting: 399°C - 427°C (750°F - 800°F)