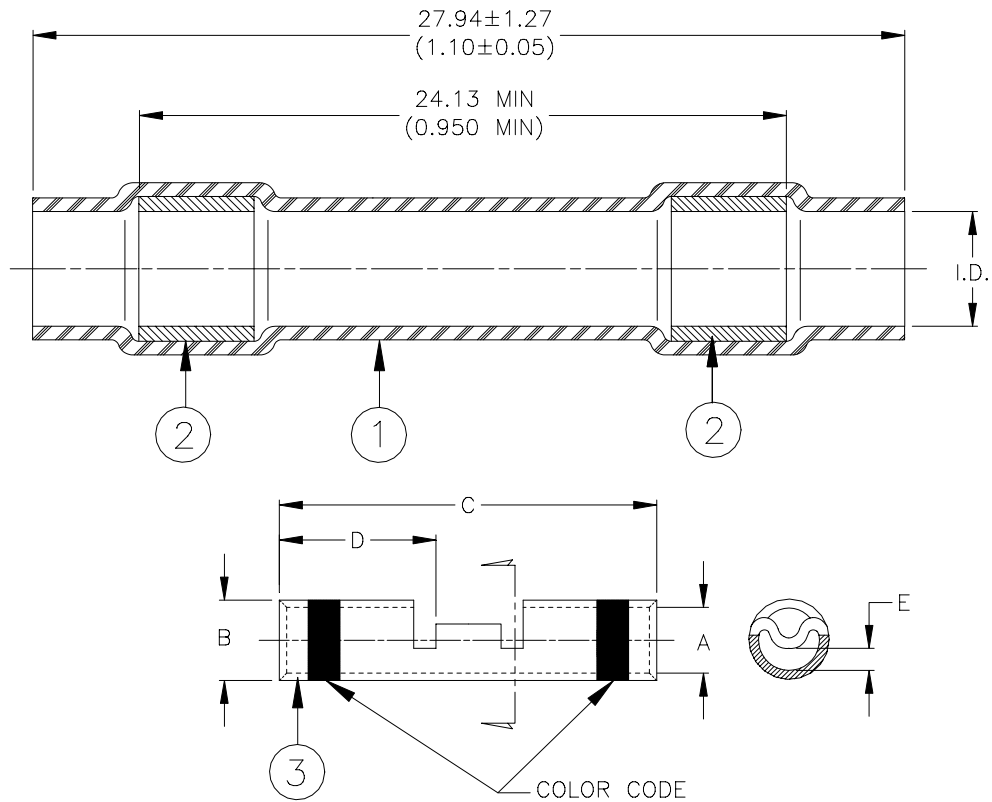


## SPECIFICATION CONTROL DRAWING



### **MATERIALS**

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene flouride.
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.

### Dimensions:

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

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

<b>tyco</b> Electronics		Tyco Electronics Corporation 305 Constitution Drive Menlo Park, CA 94025, USA		<b>Raychem</b> Products		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		Tyco Electronics reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.		DATE: <b>25-Jan-02</b>	
DRAWN BY: <b>mforonda</b>		REPLACES: <b>D001298</b>		DCR NUMBER: <b>D020028</b>		PROD. REV. <b>SEE TABLE</b>	
				SCALE: <b>None</b>		SIZE: <b>A</b>	
						SHEET: <b>1 of 2</b>	

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## SPECIFICATION CONTROL DRAWING

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

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

### ASSEMBLY PROCEDURE:

- a. Slide sealing sleeve onto one of the wires to be spliced.
- b. Strip wires 5/16" to 11/32".
- c. Insert one wire into barrel of crimp splicer and crimp using a Raychem AD-1377 crimp tool. Repeat for the other wire.
- d. Center sealing sleeve over the splice.
- e. 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>tyco</b> <i>Electronics</i>		Tyco Electronics Corporation 305 Constitution Drive Menlo Park, CA 94025, USA		<b>Raychem</b> Products		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		Tyco Electronics reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.		DATE: 25-Jan-02		DOC ISSUE: 2					
DRAWN BY: mforonda		REPLACES: D001298		DCR NUMBER: D020028		PROD. REV. SEE TABLE		SCALE: None		SIZE: A		SHEET: 2 of 2	

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