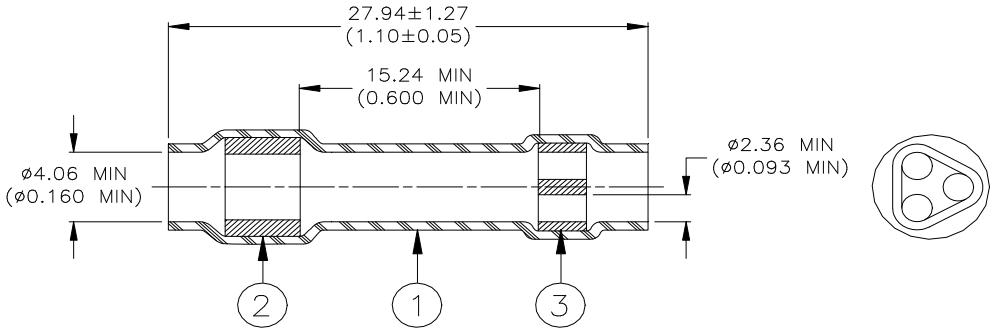
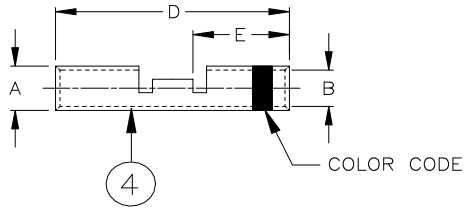
CUSTOMER DRAWING



ITEM #1: SEALING SLEEVE



ITEM #2: CRIMP SPLICE

MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene flouride.
2. SINGLE-WIRE SEAL: Low outgassing immersion resistant thermoplastic fluoroelastomer. Color: BLUE.
3. INTEGRAL-WIRE SEAL: Low outgassing immersion resistant thermoplastic fluoroelastomer. Color: BLUE.
4. CRIMP SPLICE: Base metal: Copper Alloy 101 or 102 per ASTM B-75.
   Plating: Tin per MIL-T-10727, Type 1.
   Color code: See table below.

Dimensions of Crimp Splice :

Part Name	Prod. Rev.	Size	Crimp Splice				
			ØA	ØB	D	E	Color Code
D-436-52	C	16	2.69 (0.106) 2.56 (0.101)	1.75 (0.069) 1.63 (0.064)	14.86 (0.585) 14.35 (0.565)	7.11 (0.280) 6.60 (0.260)	Blue
D-436-53	C	12	3.91 (0.154) 3.73 (0.147)	2.59 (0.102) 2.46 (0.097)	14.86 (0.585) 14.35 (0.565)	7.11 (0.280) 6.60 (0.260)	Yellow

Installation Data:

Splicer Size	Wire Size Range of Crimp Splice					
	One Wire		Two wires		Three wires	
	Minimum	Maximum	Minimum	Maximum	Minimum	Maximum
16	20	16	24	20	24	22
12	16	12	22	16	22	18

TE Connectivity		Raychem Devices	TITLE : IN-LINE SPLICE SEALING SYSTEM, 2 OR 3 TO 1 SPLICE: Tin Plated, Color Coded, with Inspection Slots		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS. INCHES DIMENSIONS ARE BETWEEN BRACKETS.			DOCUMENT NO. : D-436-52/-53		
TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A	ANGLES: N/A ROUGHNESS IN MICRON	TE CONNECTIVITY (TE) RESERVES THE RIGHT TO CHANGE THIS DRAWING AT ANYTIME. USER SHOULD EVALUATE THE SUITABILITY OF THE PRODUCT FOR THEIR APPLICATION.	DATE: June 26, 2015	REVISION: C	
DRAWN BY: M. FORONDA	ECO APPROVED: L. RODRIGUEZ	ECO NUMBER: 15-009842	SCALE: None	SIZE: A	SHEET: 1 of 2

CUSTOMER DRAWING

APPLICATION

1. These parts are designed to provide an immersion resistant in-line splices of 2 or 3 to 1 wires falling within the size range listed on sheet 1, having insulations rated for at least 135°C.
2. Parts are available only as an assembly of one of each Item #1 and Item #2.
3. Parts are to be installed per Thermofit Assembly Procedure, see below.
4. Inside diameter and outside diameter of splice are to be measured in crimp areas, 2.54 to 5.08 (0.100 to 0.200) from ends of part. Slight burr permitted on parted surfaces.
5. Acceptance sampling shall be in accordance with Paragraph 4.6.1 of MIL-T-7928.
6 . Packing and packaging shall be in accordance with Section 5, Level C, of MIL-T-7928.
7. This document takes precedence over documents referenced herein.

THERMOFIT ASSEMBLY PROCEDURE

1.0 SCOPE

This document outlines the procedure to be followed to obtain immersion resistant 3 or 2 to 1 in-line splices using Thermofit In-Line Splice Sealing System D-436-52/-53.

2.0 PROCEDURE:

a) Strip all wires 7.92 (0.312) to 8.74 (0.344).
b) Attach the single lead to the appropriate size crimp splice using a Raychem AD-1377 Crimp Tool.
c) Pass the wires to be attached to other barrel through the sealing sleeve from the three-hole insert end.
d) Insert wires into barrel and crimp. Care must be taken that the wires remain untwisted between the crimp splice and the three wire seal or the sealing sleeve cannot be positioned properly.
e) Apply heat, using the recommended heat source, first to the three-hole insert and then the other. Heat should be applied until insert melts and flows axially along the wires.

3.0 RECOMMENDED RAYCHEM HEATING TOOLS

Heater	*Reflector*
Thermogun #500A	TG-14
Shop Air Heater #CV-4504	991180
Mini-Gun #CV-5300	991319

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TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A	ANGLES: N/A ROUGHNESS IN MICRON	TE CONNECTIVITY (TE) RESERVES THE RIGHT TO CHANGE THIS DRAWING AT ANYTIME. USER SHOULD EVALUATE THE SUITABILITY OF THE PRODUCT FOR THEIR APPLICATION.	DATE: June 26, 2015	REVISION: C	
DRAWN BY: M. FORONDA	ECO APPROVED: L. RODRIGUEZ	ECO NUMBER: 15-009842	SCALE: None	SIZE: A	SHEET: 2 of 2