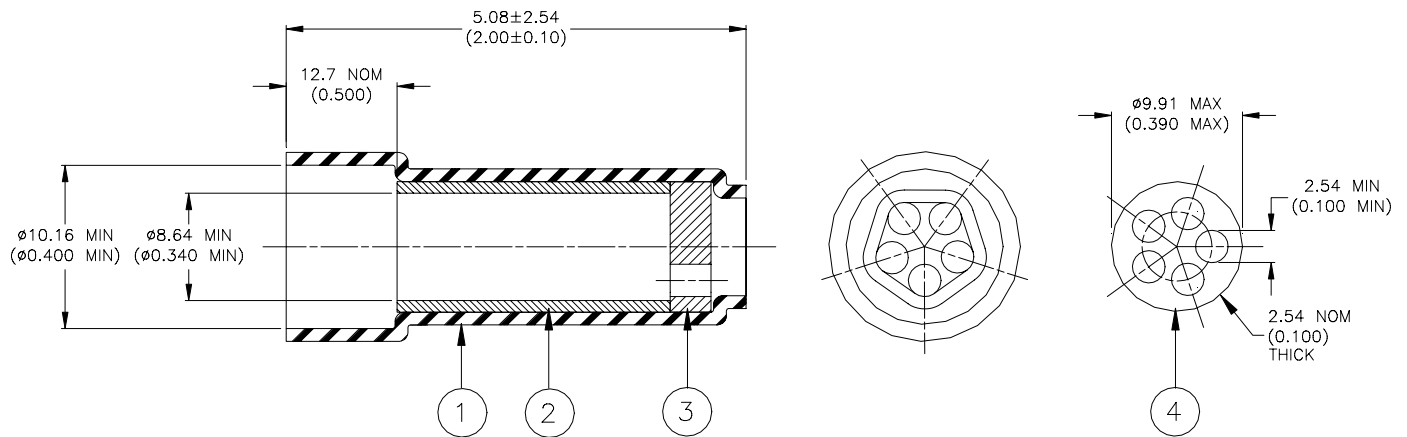


SPECIFICATION CONTROL DRAWING



MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
2. MELTABLE LINER: Modified thermoplastic.
3. INTEGRAL MULTI-WIRE SEAL: Modified thermoplastic. Color: red.
4. SEPARATE MULTI-WIRE SEAL: Modified thermoplastic. Color: red.

APPLICATION

1. This part is designed to provide an immersion resistant seal on in-line splices made with wires having insulations rated for at least 135°C.
2. Part will seal assemblies which require insertion of not more than two wires per hole of the multi-hole inserts.
3. For assembly technique, see Installation Procedure on sheet 2.
4. For other sizes of similar usage, see Devices Specification Drawings D-436-40 and D-436-41.

Raychem Interconnect a division of tyco Electronics 300 Constitution Drive Menlo Park, CA 94025, USA		THERMOFIT DEVICES		TITLE SEALING SLEEVE, MULTI-WIRE SPLICE			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS. INCHES DIMENSIONS ARE BETWEEN BRACKETS.				DOCUMENT NO.: D-436-39			
TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A	ANGLES: N/A ROUGHNESS IN MICRON	Raychem reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.		DCR NUMBER: D000424		REPLACES: N/A	
DRAWN BY: M. FORONDA		DATE: 27-Sept-00	PROD. REV. F	DOC ISSUE: 1	SCALE: None	SIZE: A	SHEET: 1 of 2

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SPECIFICATION CONTROL DRAWING

This procedure describes the method to be used to install Raychem Devices Sealing Sleeve D-436-39 to obtain immersion resistant multi-wire crimped in-line splices.

INSTALLATION PROCEDURE

1. Pass the wires to be attached to one barrel through the holes in the separate multi-wire seal to avoid twisting. Crimp into barrel.
2. Pass the wires to be attached to the other barrel through the sleeve from the multi-hole insert end.
3. Slide the sleeve far enough onto the wires to permit the completion of splice.
4. Complete splice, again being careful to keep wires untwisted between the crimped splicer and the multi-hole seals or the sleeve cannot be positioned properly.
5. Position the separate insert as close as possible to the crimp splicer. Hold the insert in place by squeezing the wires directly behind it and slide the sealing sleeve over the assembly so that the separate insert is completely inside the outer sleeve.
6. Apply heat to the assembly as follows:
 - a) Use a Raychem Thermogun, Model 500A, equipped with a Raychem Reflector, TG-12, adjusted to give a heat of 650 – 750°F.
 - b) Place the sleeve in the heat so that the “separate” insert is centered in the air-stream. Apply heat until insert has melted and flowed axially along the wires.
 - c) Work the heat across sleeve causing liner to melt and flow, then concentrate heat on the second multi-wire insert until it, also, melts and flows.
 - d) The time required is largely dependent upon the temperature of the air-stream and the mass of the wire bundle being encapsulated.

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