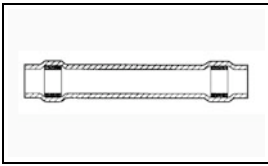


650074-000 Product Details

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650074-000

(D-436-36)

TE Internal Number: 650074-000

Active

MiniSeal Splices

Always EU RoHS/ELV Compliant (Statement of Compliance)

Product Highlights:

- MIL Specification [MIL-S-81824]
- Splice Type = Butt [in-line]
- Silver Wire Material, Tin Wire Material
- Crimp Barrel Size = 304 - 1510 CMA
- Side 1 Max. # of Wires = 2

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Documentation & Additional Information	
<p>Product Drawings:</p> <ul style="list-style-type: none"> • In-line Splice Sealing System, 1 to 1, SAE-AS81824/1 (PDF, English) <p>Catalog Pages/Data Sheets:</p> <ul style="list-style-type: none"> • None Available <p>Product Specifications:</p> <ul style="list-style-type: none"> • None Available <p>Application Specifications:</p> <ul style="list-style-type: none"> • None Available <p>Instruction Sheets:</p> <ul style="list-style-type: none"> • None Available <p>CAD Files:</p> <ul style="list-style-type: none"> • None Available 	<p>Related Products:</p> <ul style="list-style-type: none"> • Tooling

[List all Documents](#)

Product Features (Please use the Product Drawing for all design activity)	
<p>Product Type Features:</p> <ul style="list-style-type: none"> • Splice Type = Butt [in-line] • Wire Material = Silver, Tin • Color Code = Red <p>Termination Features:</p> <ul style="list-style-type: none"> • Crimp Barrel Size (CMA [mm²]) = 304 - 1510 [0.15 - 0.75] • Connection Type = Crimp • Crimp Barrel Plating = Tin <p>Housing Features:</p> <ul style="list-style-type: none"> • Side 1 Max. # of Wires = 2 • Side 2 Max. # of Wires = 2 • Side 1 Sealing Insert I.D. (mm [in]) = 2.16 [0.085] • Side 2 Sealing Insert I.D. (mm [in]) = 2.16 [0.085] 	<p>Industry Standards:</p> <ul style="list-style-type: none"> • Government/Industry Qualification = Yes • Government/Industry Part Number = M81824/1-1 • MIL Specification [MIL-S-81824] = Yes • RoHS/ELV Compliance = RoHS compliant, ELV compliant • Lead Free Solder Processes = Not relevant for lead free process • RoHS/ELV Compliance History = Always was RoHS compliant <p>Environmental:</p> <ul style="list-style-type: none"> • Operating Temperature (Max.) (°C) = 150 <p>Operation/Application:</p> <ul style="list-style-type: none"> • Application Type = Wire to Wire Splicing <p>Other:</p> <ul style="list-style-type: none"> • Brand = Raychem • Comment = Mil Spec M81824/1-1

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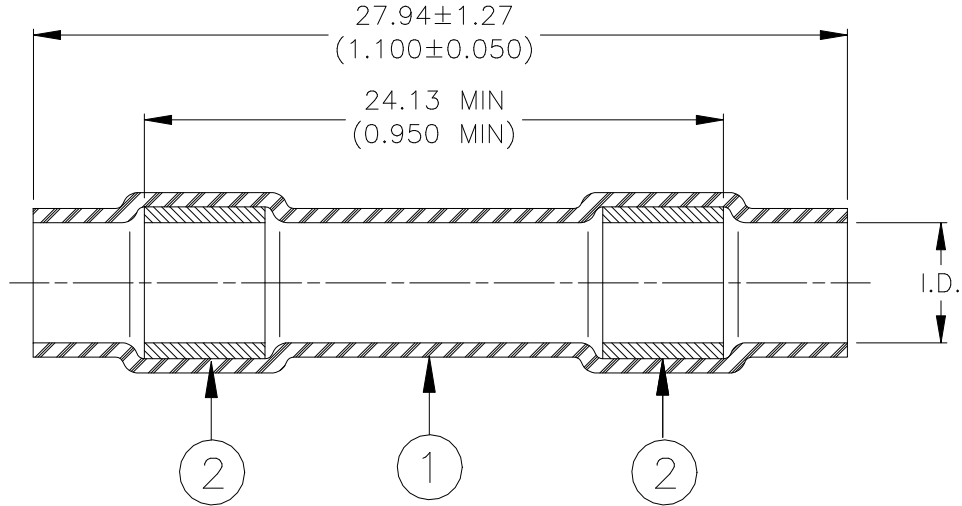
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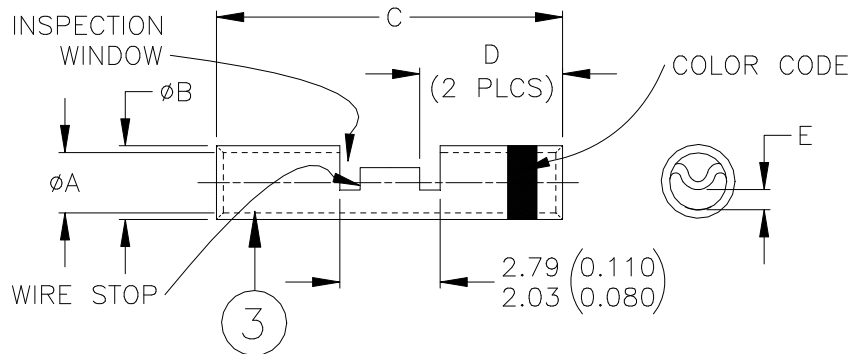
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CUSTOMER DRAWING



SEALING SLEEVE



METAL CRIMP SPLICE

Product Rev		I.D.* a (min) b (max)	Product Dimensions				
Product Name			A	B	C	D	E max
D-436-36	A	<u>2.16 (0.085)</u>	<u>1.27 (0.050)</u>	<u>2.03 (0.080)</u>	<u>12.95 (0.510)</u>	<u>6.22 (0.245)</u>	0.38
		0.64 (0.025)	1.14 (0.045)	1.91 (0.075)	12.45 (0.490)	5.72 (0.225)	(0.015)
D-436-37	A	<u>2.79 (0.110)</u>	<u>1.75 (0.069)</u>	<u>2.69 (0.106)</u>	<u>14.86 (0.585)</u>	<u>7.11 (0.280)</u>	0.51
		0.64 (0.025)	1.63 (0.064)	2.57 (0.101)	14.35 (0.565)	6.60 (0.260)	(0.020)
D-436-38	A	<u>4.32 (0.170)</u>	<u>2.59 (0.102)</u>	<u>3.89 (0.153)</u>	<u>14.86 (0.585)</u>	<u>7.11 (0.280)</u>	1.27
		0.64 (0.025)	2.46 (0.097)	3.73 (0.147)	14.35 (0.565)	6.60 (0.260)	(0.050)

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

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		Raychem Devices	TITLE: IN-LINE SPLICE SEALING SYSTEM, 1 TO 1 SAE AS81824/1		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS. INCHES DIMENSIONS ARE BETWEEN BRACKETS.			DOCUMENT NO.: D-436-36/-37/-38		
TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A	ANGLES: N/A ROUGHNESS IN MICRON	TE Connectivity reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.	DATE: 02-21-2013	REVISION: C	
DRAWN BY: T.NGUYEN	ECO NUMBER: ECO-13-003156		SCALE: N/A	SIZE: A	SHEET: 1 of 2

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CUSTOMER DRAWING

MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
2. SEALING RINGS: Immersion resistant thermoplastic. Color: one clear, one color coded (see table below).
3. CRIMP SPLICER:
 - Base Metal: Copper alloy 101 or 102 per ASTM B-75.
 - Plating: Tin, per ASTM B545
 - Color code: See table below.

Product Name	MIL Spec Equivalent	Wire Range (AWG)	Color Code	Wgt. - Lbs/Mpc max
D-436-36	M81824/-1-1	26 - 20	RED	1.02
D-436-37	M81824/-1-2	20 - 16	BLUE	1.61
D-436-38	M81824/-1-3	16 - 12	YELLOW	2.720


APPLICATION

1. These parts are designed to provide immersion resistant in-line splices of 1 to 1 wires falling within size range listed above, and having insulations rated for 135°C.
2. Parts will meet all requirements of SAE AS81824/1 when installed as outlined below. Assembly is not required for acceptance testing inspection.
3. Acceptance sampling shall be in accordance with Paragraph 4.6.1 of SAE AS81824.
4. Packing and packaging shall be in accordance with Sections 5, Level C, of SAE AS81824.
5. This document takes precedence over documents reference herein.

ASSEMBLY PROCEDURE:

1. Slide sealing sleeve onto one of the wires to be spliced.
2. Strip wires 5/16" to 11/32".
3. Insert one wire into barrel of crimp splicer and crimp using a Raychem AD-1377 crimp tool. Repeat for other wire.
4. Center sealing sleeve over the splice.
5. 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.

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 TE Connectivity		Raychem Devices	TITLE: IN-LINE SPLICE SEALING SYSTEM, 1 TO 1 SAE AS81824/1		
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TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A	ANGLES: N/A ROUGHNESS IN MICRON	TE Connectivity reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.	DATE: 02-21-2013	REVISION: C	
DRAWN BY: T.NGUYEN	ECO NUMBER: ECO-13-003156		SCALE: N/A	SIZE: A	SHEET: 2 of 2

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