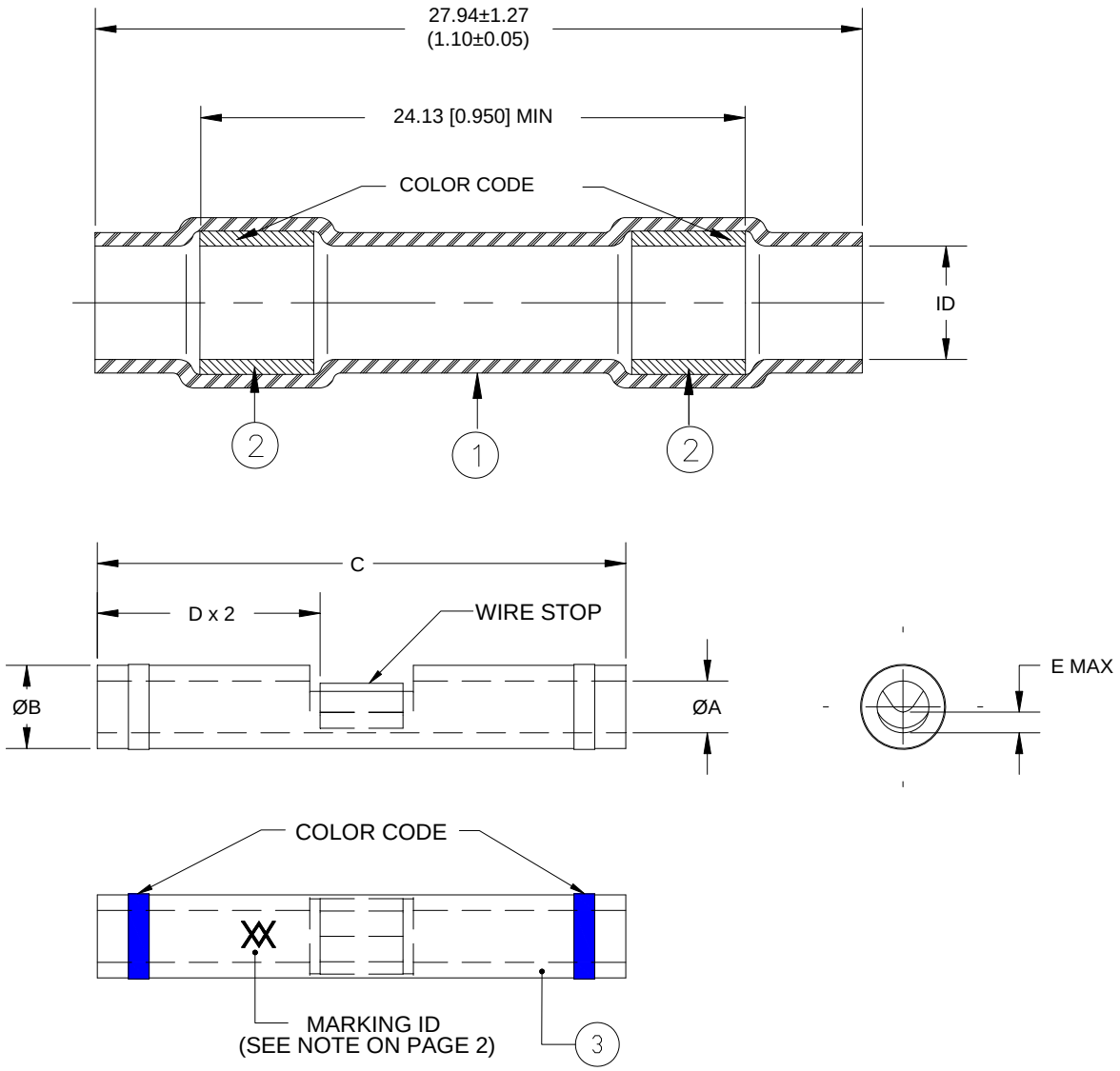
CUSTOMER DRAWING



MATERIALS

① INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified fluoropolymer.
② MELTABLE RINGS: Enviroment resistant modified thermoplastic Fluoropolymer. Color Code: See Table.
③ CRIMP SPLICER: Base Metal: Copper Alloy 101 or 102 per ASTM B75.

- Plating: Nickel per SAE AMS-QQ-N-290.
- Color Code: See Table below.

TE Connectivity			Raychem Devices		TITLE: IN-LINE SPLICE SEALING SYSTEM, 1 TO 1 NICKEL PLATED CRIMP, 200˚C		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS. REFERENCE DIMENSIONS [INCHES] ARE IN BRACKETS.				DOCUMENT NO.: D-200-82/-83/-84			
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. USERS SHOULD EVALUATE THE SUITABILITY OF THE PRODUCT FOR THEIR APPLICATION.		DATE: January 28, 2016		REV. C	
DRAWN BY: T. NGUYEN	CAGE CODE: 06090	REVISED PER: ECO-16-001197	PROD. REV.: SEE TABLE	SCALE: None	SIZE: A	SHEET: 1 of 2	

CUSTOMER DRAWING

DIMENSIONS TABLE

Part Name	I.D.* a min b max	Crimp Splicer					
		øA	øB	C	D	E max	Color Code
D-200-82	2.16 (.085) 0.64 (.025)	1.27 (.050) 1.14 (.045)	2.03 (.080) 1.91 (.075)	12.95 (.510) 12.45 (.490)	6.22 (.245) 5.72 (.225)	0.38 (.015)	Red
D-200-83	2.79 (.110) 0.64 (.025)	1.75 (.069) 1.63 (.064)	2.70 (.106) 2.57 (.101)	14.86 (.585) 14.35 (.565)	7.11 (.280) 6.60 (.260)	0.51 (.020)	Blue
D-200-84	4.32 (.170) 0.64 (.025)	2.60 (.102) 2.46 (.097)	3.89 (.153) 3.73 (.147)	14.86 (.585) 14.35 (.565)	7.11 (.280) 6.60 (.260)	1.27 (.050)	Yellow

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

Part Name	MIL Spec Equivalent Size	Wire Range	Wgt. Lbs/Mpc max
D-200-82	AS81824/1-1	26-20	1.02
D-200-83	AS81824/1-2	20-16	1.61
D-200-84	AS81824/1-3	16-12	2.72

PART MARKING

- Stamp marking XX approximately as shown on the back of inspection window.

APPLICATION

- These parts are designed to provide an immersion resistant in-line splices of 1 to 1 wires falling within the size range listed, and having nickel plated conductors and insulations rated for at least 135°C.
- Parts will meet all performance requirements of SAE-AS81824 when installed as outlined below with the following:
  - Heat ageing test temperature of 200˚C.
  - Thermal shock maximum temperature of 200˚C.
- Acceptance sampling shall be in accordance with Paragraph 4.6.1 of SAE AS81824.
- Packing and packaging shall be in accordance with Section 5, Level C of SAE AS81824.
- This document takes precedence over documents referenced herein.

ASSEMBLY PROCEDURE:

1. Slide sealing sleeve onto one of the wires to be spliced.
2. Strip wires 7.95 [5/16”] to 8.73 [11/32”].
3. Insert one wire into barrel of crimp splicer and crimp using a Raychem AD-1377 crimp tool. Repeat for the
   - Repeat for the 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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DRAWN BY: T. NGUYEN	CAGE CODE: 06090	REVISED PER: ECO-16-001197		PROD. REV.: SEE TABLE	SCALE: None	SIZE: A	SHEET: 2 of 2