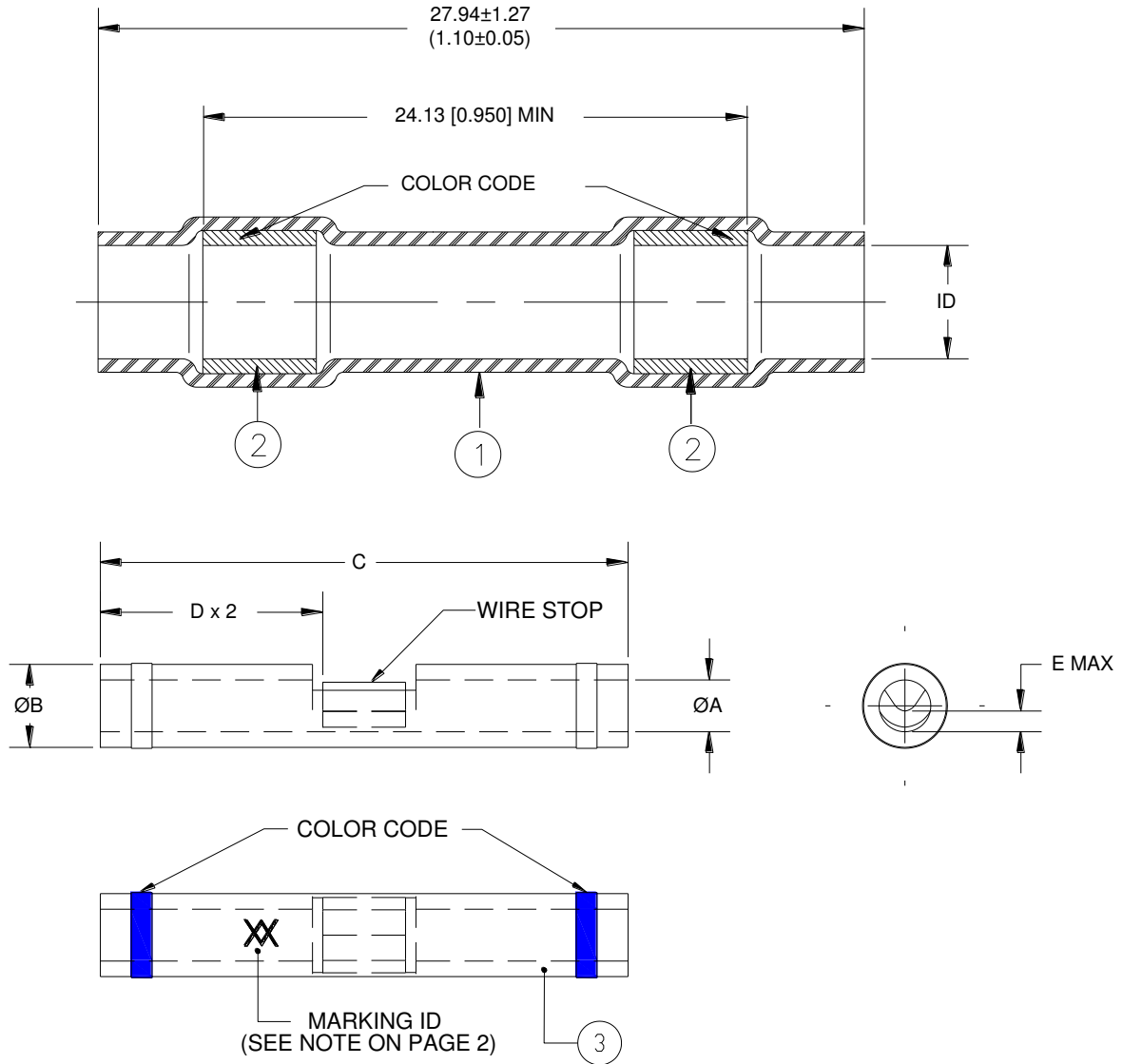


CUSTOMER DRAWING



MATERIALS

- ① INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified fluoropolymer.
- ② MELTABLE RINGS: Environment resistant modified thermoplastic Fluoropolymer. Color Code: See Table I.
- 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 I.
 - Stamp marking XX approximately as shown on the back of inspection window.

TE Connectivity		Raychem Devices	TITLE: IN-LINE SPLICE SEALING SYSTEM, 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: August 17, 2016	REV. D		
DRAWN BY: T. NGUYEN	CAGE CODE: 06090	REVISED PER: ECO-16-012043	PROD. REV.: SEE TABLE	SCALE: None	SIZE: A	SHEET: 1 of 3	

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CUSTOMER DRAWING

TABLE I - DIMENSIONS

Part Name	I.D.* a min b max	Crimp Splicer						Color Code	Wgt. Lbs/Mpc max
		øA	øB	C	D	E max			
D-200-82	<u>2.16 (.085)</u> 0.64 (.025)	<u>1.27 (.050)</u> 1.14 (.045)	<u>2.03 (.080)</u> 1.91 (.075)	<u>12.95 (.510)</u> 12.45 (.490)	<u>6.22 (.245)</u> 5.72 (.225)	0.38 (.015)	Red	1.02	
D-200-83	<u>2.79 (.110)</u> 0.64 (.025)	<u>1.75 (.069)</u> 1.63 (.064)	<u>2.70 (.106)</u> 2.57 (.101)	<u>14.86 (.585)</u> 14.35 (.565)	<u>7.11 (.280)</u> 6.60 (.260)	0.51 (.020)	Blue	1.61	
D-200-84	<u>4.32 (.170)</u> 0.64 (.025)	<u>2.60 (.102)</u> 2.46 (.097)	<u>3.89 (.153)</u> 3.73 (.147)	<u>14.86 (.585)</u> 14.35 (.565)	<u>7.11 (.280)</u> 6.60 (.260)	1.27 (.050)	Yellow	2.72	

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

TABLE II – RECOMMENDED WIRE RANGE BASED ON CONDUCTOR CMA (mm²) (REFERENCE)

PART NUMBER	MIL SPEC EQUIVALENT SIZE	SINGLE WIRE	MULTIPLE WIRE RANGE CMA (mm ²)	MULTIPLE WIRE TOTAL OD (OD ₁ + OD ₂) MAX
D-200-82	M81824/11	26-24-22-20	304 - 1510 (0.15 - 0.75)	0.085 (2.16)
D-200-83	M81824/11	20-18-16	1058 - 2680 (0.53 – 1.34)	0.110 (2.79)
D-200-84	M81824/11	16-14-12	2375 – 6755 (1.19 – 3.37)	0.170 (4.32)


TABLE III – STANDARD CONDUCTOR CMA (REFERENCE)

CONDUCTOR CONFIGURATION	SIZE							
	26	24	22	20	18	16	14	12
STRANDS	19	19	19	19	19	19	19	37
CMA	304	475	754	1216	1900	2426	3831	5874
(MM ²)	(0.15)	(0.24)	(0.38)	(0.61)	(0.95)	(1.21)	(1.92)	(2.94)

APPLICATION

- These parts are designed to provide an immersion resistant in-line splices, maximum of two wires per side of crimp and falling within the diameter range specified in this customer drawing., and having insulations rated for at least 135°C.
- Parts will meet all performance requirements of AS81824/11Tm 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 AS81824Tm.
- Packing and packaging shall be in accordance with Section 5, Level C of AS81824Tm.
- This document takes precedence over documents referenced herein.

*Tm – AS81824 is a trademark of SAE

 TE Connectivity		Raychem Devices	TITLE: IN-LINE SPLICE SEALING SYSTEM, 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: August 17, 2016	REV. D		
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CUSTOMER DRAWING

ASSEMBLY PROCEDURE:

1. Slide sealing sleeve over both wire on one side of the crimp if two wires will be use..
2. Strip wires 7.95 [5/16"] to 8.73 [11/32"].
3. Insert one or two wires on one side of the barrel and crimp using a Raychem AD-1377 crimp tool. Repeat on the other side of barrel.
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.

 TE Connectivity		Raychem Devices	TITLE : IN-LINE SPLICE SEALING SYSTEM, NICKEL PLATED CRIMP, 200°C			
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DRAWN BY: T. NGUYEN	CAGE CODE: 06090	REVISED PER: ECO-16-012043	PROD. REV.: SEE TABLE	SCALE: None	SIZE: A	SHEET: 3 of 3