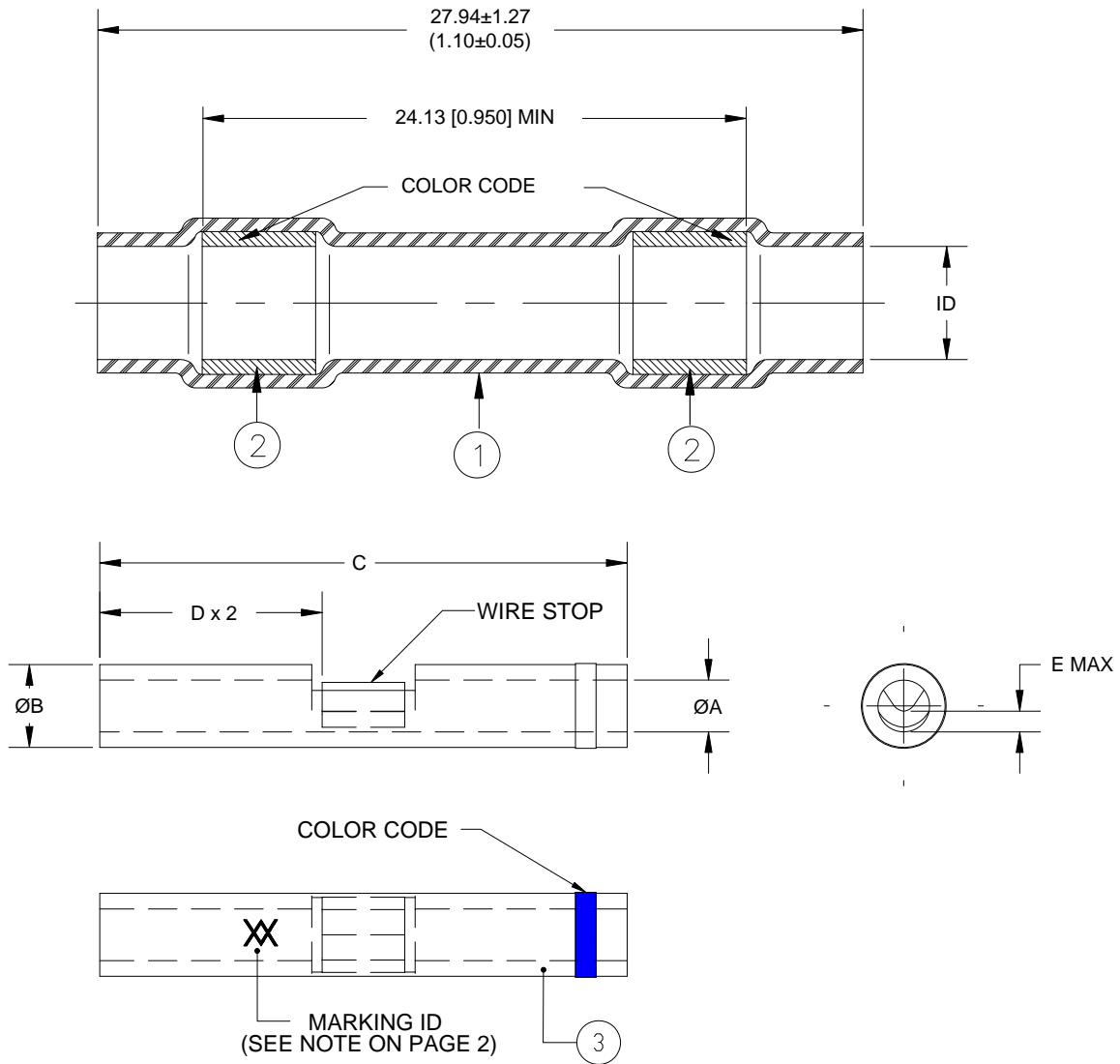


CUSTOMER DRAWING



Product Name	I.D.* a (min) b (max)	Product Dimensions				
		A	B	C	D	E max
D-436-36	2.16 (0.085)	1.27 (0.050)	2.03 (0.080)	12.95 (0.510)	6.22 (0.245)	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	2.79 (0.110)	1.75 (0.069)	2.69 (0.106)	14.86 (0.585)	7.11 (0.280)	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	4.32 (0.170)	2.59 (0.102)	3.89 (0.153)	14.86 (0.585)	7.11 (0.280)	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.

			TITLE: SEALED IN-LINE CRIMP SPLICE, SAE AS81824/1		
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]		Raychem Devices	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	Tyco Electronics reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.	REV: E	DATE: February 21, 2014	
PREPARED BY: TNGUYEN	CAGE CODE: 06090	ECO NUMBER: ECO-14-002613	SCALE: NTS	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.
Stamp marking XX approximately as shown on the back of inspection window.
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.

Unless otherwise specified dimensions are in millimeters.
(Inches dimensions are shown in brackets)

DOCUMENT NO.: D-436-36/-37/-38	REV: E	ECO NUMBER: ECO-14-002613	DATE: February 21, 2014	SHEET: 2 of 2
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