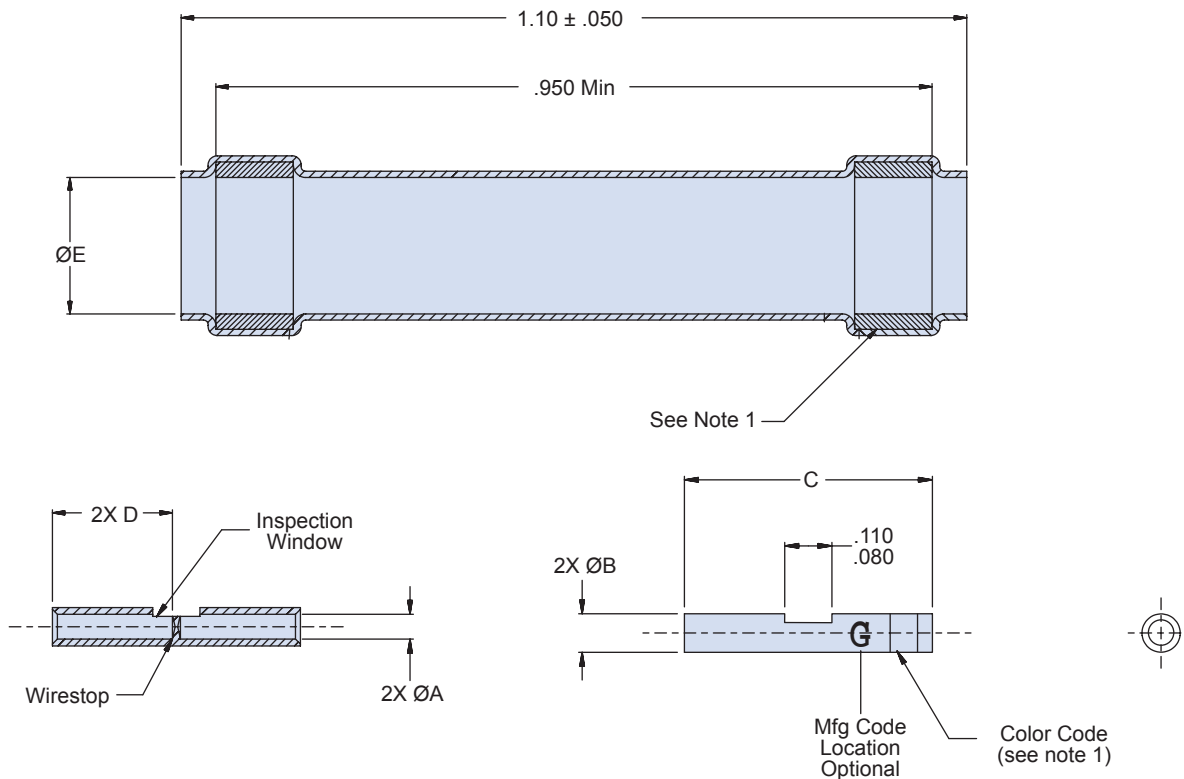
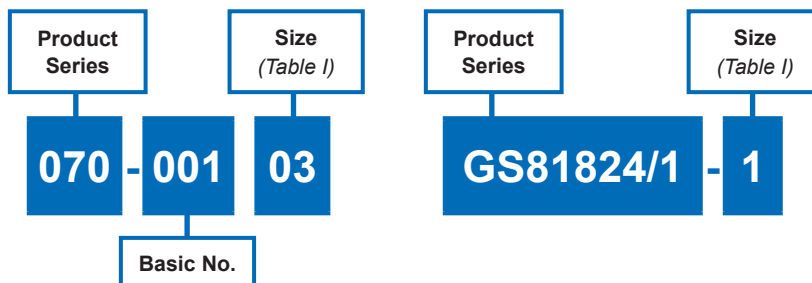




GS81824/1 • 070-001
Mil-Qualified Splice
 In-Line, Insulated, Environmental

MIL-QUALIFIED IN-LINE SPLICE

How To Order



Material and Finish

- Splice: Copper UNS C10100 ASTM F68 or ASTM B187
- Finish: Tin plate per ASTM B 545, .00010 min thick over nickel per AMS-QQ-N-290
- Sealing material: Thermally stabilized thermoplastic
- Shrink Sleeve: transparent, heat shrinkable, cross-linked polyvinylidene fluoride per AMS-DTL-23053/8

Notes

1. One seal ring must be color coded per Table I. Splice to have matching circumferential color stripe.

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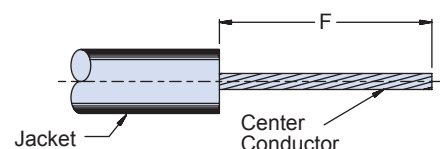


Table I									
Size	Wire Range	A Dia	B Dia	C	D	E Dia		Mil Ref	Color Code (note 1)
						Min (Free State)	After Recovery Ref		
01	20–26 AWG	.050 (1.27) .045 (1.14)	.080 (2.03) .075 (1.90)	.510 (12.95) .490 (12.45)	.245 (6.22) .225 (5.72)	.085 (2.2)	.025 (0.6)	M81824/1-1	Red
02	16–20 AWG	.069 (1.75) .064 (1.63)	.106 (2.69) .101 (2.57)	.585 (14.86) .565 (14.35)	.280 (7.11) .260 (6.60)	.110 (2.8)	.025 (0.6)	M81824/1-2	Blue
03	12–16 AWG	.102 (2.59) .097 (2.46)	.153 (3.89) .147 (3.74)	.585 (14.86) .565 (14.35)	.280 (7.11) .260 (6.60)	.170 (4.3)	.025 (0.6)	M81824/1-3	Yellow

ASSEMBLY INSTRUCTIONS

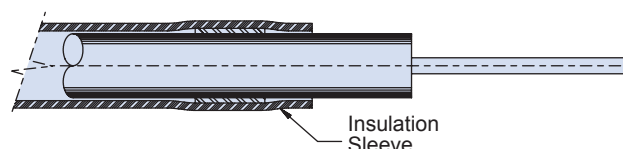
Step A

- Strip wires per Table II. Ends must be cut cleanly and at right angles to the axial plane of the wire. The wire must not be deformed while making cuts.



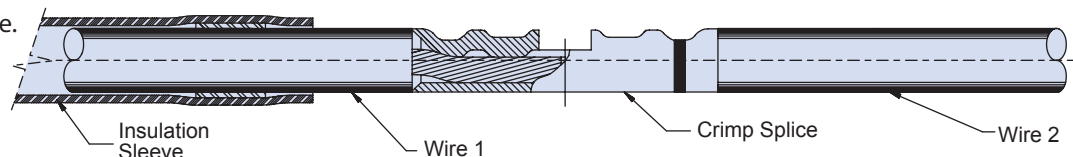
Step B

- Slide Insulation Sleeve onto one of the wires



Step C

- Insert one wire into barrel of crimp splice and crimp using crimp tool and dies listed in Table II.
- Repeat for second wire.



Step D

- Slide Insulation Sleeve over the splice until centered.
- Apply heat using acceptable heat source for military equipment as qualified by the services for Class 2 splices. Sealing rings shall melt and insulation sleeve shall seal around crimp splice and wires.

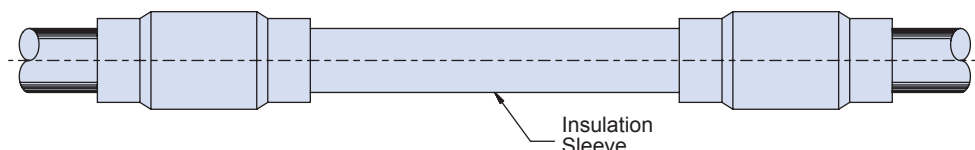


Table II			
Part No.	Wire Range	F	Crimp Tool Data
070-00101	20, 22, 24, 26	.24	Crimp Tool: M22520/5-01 Crimp Dies: M22520/5-102, -103 OR
070-00102	16, 18, 20	.28	Crimp Tool: M22520/10-01 Crimp Dies: M22520/10-103, -104 OR
070-00103	12, 14, 16	.28	Crimp Tool: M22520/37-01 Crimp Dies: None