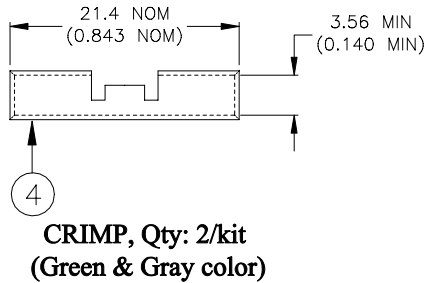
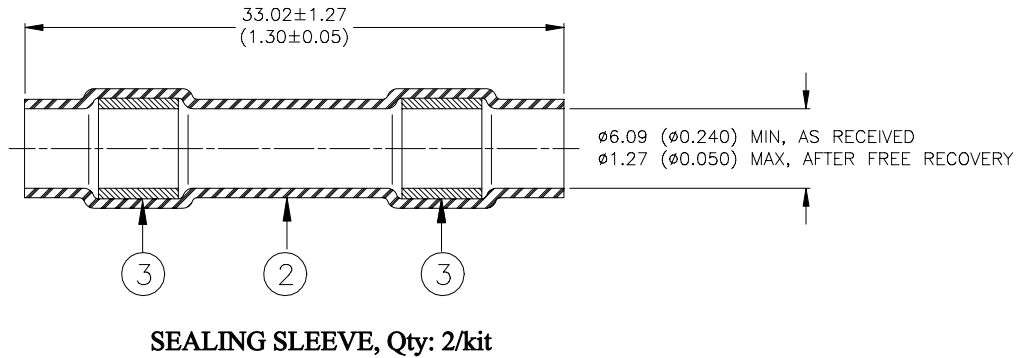
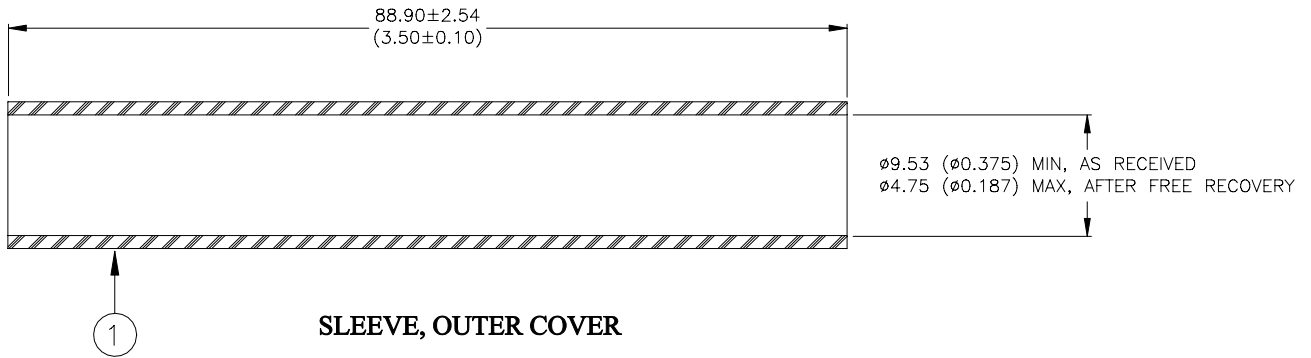


# SPECIFICATION CONTROL DRAWING



## MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, flexible fluoro-elastomer, color-black.
2. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
3. MELTABLE INSERT: Fluorocarbon-based thermoplastic.
4. CRIMP SPLICER:
  - AMP 1-322325-1 (Gray color)      Splice for Chromel wire
  - AMP 1-322325-0 (Green color)      Splice for Alumel wire

<b>Raychem Interconnect</b> <small>a division of Tyco Electronics</small> 300 Constitution Drive Menlo Park, CA 94025, USA		<b>THERMOFIT DEVICES</b>		TITLE : <p style="text-align: center;"><b>(22 – 16 GAUGE) IN-LINE SPLICE SEALING SYSTEM, CHROMEL-ALUMEL THERMOCOUPLE</b></p>			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS. INCHES DIMENSIONS ARE BETWEEN BRACKETS.				DOCUMENT NO.: <b>D-436-0133</b>			
TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A	ANGLES: N/A  ROUGHNESS IN MICRON	Raychem reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.		DCR NUMBER: <p style="text-align: center;">D001281</p>	REPLACES: <p style="text-align: center;">N/A</p>		
DRAWN BY: <p style="text-align: center;">M. FORONDA</p>	DATE: <p style="text-align: center;">14-Nov.-00</p>	PROD. REV. <p style="text-align: center;">A</p>	DOC ISSUE: <p style="text-align: center;">1</p>	SCALE: <p style="text-align: center;">None</p>	SIZE: <p style="text-align: center;">A</p>	SHEET: <p style="text-align: center;">1 of 2</p>	

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## SPECIFICATION CONTROL DRAWING

### APPLICATION

1. This assembly is designed to provide a sealed splice in Alumel-Chromel thermocouple cable conforming to MIL-W-5846/1E-2/20-(AC). It need to be used only in areas where the splice is expected to be exposed to temperature changes.
2. Parts are to be installed as outlined below.

### ASSEMBLY PROCEDURE

1. Strip  $2.10 \pm 0.1$  inch of jacket from the end of the cables to be spliced.
2. Cut the Alumel conductor of one cable and the Chromel conductor of the second at a point  $0.90 \pm 0.05$  inch from the cable jacket.
3. Strip all conductors  $0.40 \pm 0.05$  inch.
4. Place the Outer cover Sleeve over away from the splice area.
5. Place one Sealing Sleeve on the longer lead of each cable.
6. Crimp the conductors into the correct splice (color coded to match conductors). Use AMP Tool #46673 to make crimp.
7. Center the Sealing Sleeves over the splices and heat, using a convection heater, until the sleeve recovers and the sealing inserts melt and flow along the wire.
8. Center the Outer cover Sleeve over the assembly and heat until it recovers tightly onto the assembly.

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