

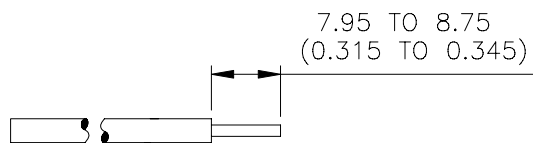
**Installation Procedure for
Miniseal D-436 Series**

1.0 Scope:

This document outlines the procedure to be followed to obtain immersion resistant multiple wire butt splices using Tyco Electronics multi-wire butt splice Sealing Sleeve.

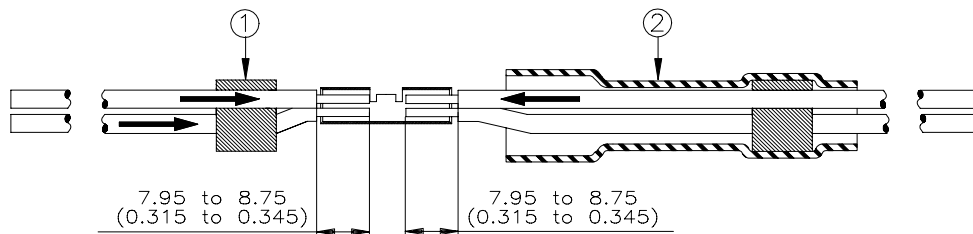
2.0 Procedure:

A) Prepare the wire as shown:



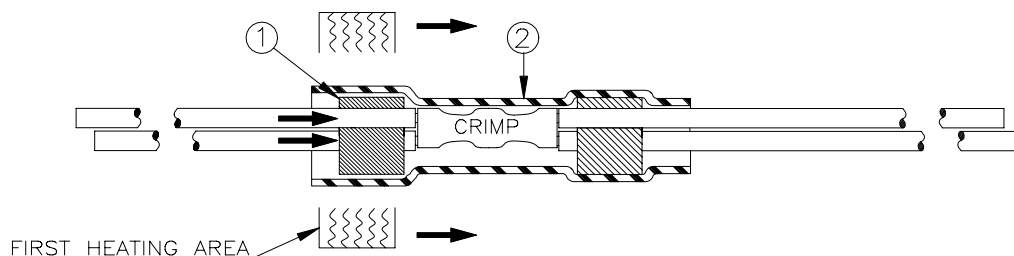
B) Pass the wires to be attached through the 5 holes of the insert

- (1). Insert the wires into the barrel and crimp the barrel using a Tyco Electronics AD-1377 crimp tool. Pass the wires to be attached to the other barrel through the 5 holes of the assembly
- (2). Insert the wires into the barrel and crimp the barrel using a Tyco Electronics AD-1377 crimp tool. Care must be taken that the wires remain untwisted between the splicer and the multi-wire seals or the sealing sleeve cannot be positioned properly.



C) Position the insert

- (1) as close as possible to the crimp. Hold this piece in position by squeezing the wires directly behind it, and slide the assembly
- (2) so that the insert (1) is as far as inside the sleeve as possible.



- D) Apply heat, using a recommended heat source (see table below), first to the insert end (1) and then the other. Heat should be applied until insert melts and flows axially along the wires.

Heat Gun	Reflector	Setting
HL1910E	PR-25D and HL1802E-ADAPT	6 on dial ⁽¹⁾
HL2010E		700°F on LCD ⁽¹⁾
CV-1981	PR-25D	7.5-8, Vent Open ⁽¹⁾

¹ These values are for reference only and may change based on other variables (i.e. reflector type, sleeve's relative distance to the reflector, etc.)

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