1. Products:

DuraSeal Splice:	
DS-XX-XX DS-MIXT-XX	D-406-XXXX

DuraSeal Terminal:		
DB-X-XX DF-X-XX	DP-X-XX DR-X-XX	B-106-XX DS-MIXT-XX

2. Application Equipment:

- Crimping tool: AD-1522
- Hot air gun:

Heat Gun	Reflector	Setting
HL1910E	PR-25 or PR-25D and HL1802E-ADAPT	6 on dial (1)
HL2010E		700°F on LCD (1)
CV-1981	PR-25D	7 (1)

3. Wire Preparation:

- Strip the stranded wire as shown.

Configuration		Product: Red Wire Range	Red Strip Length L (±0.5)	Blue Wire Range	Blue Strip Length L (±0.5)	Yellow Wire Range	Yellow Strip Length L (±0.5)	
Terminal		0.5 < Sc < 1.0	L_C = 6	1.5 < Sc < 2.5	L_C = 6	3.0 < Sc < 6.0	L_C = 6	see Fig. 1
Splice 1 to 1		0.5 < Sc < 1.0	L_C = 7.5	1.5 < Sc < 2.5	L_C = 7	3.0 < Sc < 6.0	L_C = 8	see Fig. 2
Splice 2 to 1	øA < øB	1.5< øA+øB <3.7 and 1.5< øC <3.7	L_A = 10 L_B = 7	2.0< øA+øB <4.3 and 2.0< øC <4.3	L_A = 10 L_B = 7	3.0< øA+øB <6.4 and 3.0< øC <6.4	L_A = 11 L_B = 8	see Fig. 3
		0.5< S_A+S_B < 1.0 and 0.5< S_C <1.0		1.5< S_A+S_B< 2.5 and 1.5< S_C <2.5		3.0< S_A+S_B < 6.0 and 3.0< S_C <6.0		
	øA = øB	1.5< øA+øB <3.7 and 1.5< øC <3.7	L_A = 10 L_B = 10	2.0< øA+øB <4.3 and 2.0< øC <4.3	L_A = 10 L_B = 10	3.0< øA+øB <6.4 and 3.0< øC <6.4	L_A = 11 L_B = 11	see Fig. 4
		0.5< S_A+S_B <1.0 and 0.5 <S_C <1.0		1.5< S_A+S_B <2.5 and 1.5< S_C <2.5		3.0< S_A+S_B <6.0 and 3.0< S_C <6.0		

øA = diameter (mm) of the insulation of wire A.
Sc = cross section area (mm^2) of wire C.

Fig. 1.

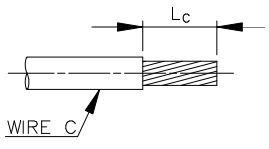


Fig. 2.

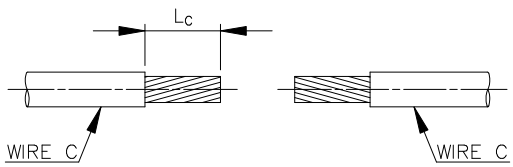


Fig. 3.

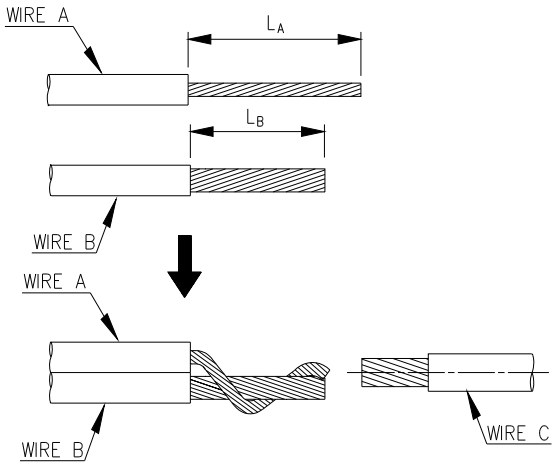
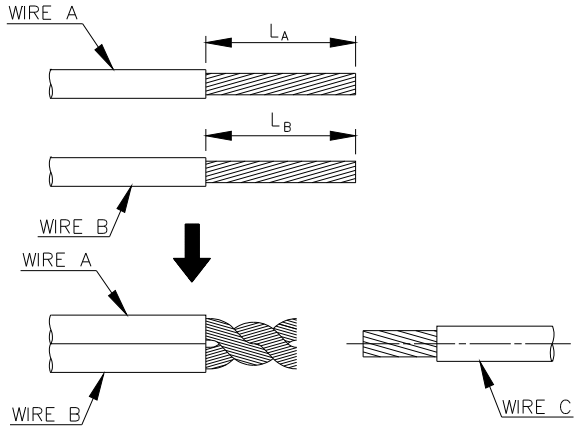


Fig. 4.



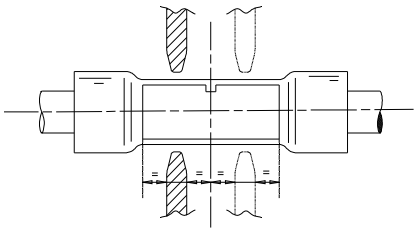
WARNING

- *IR tools are not recommended for use with black wire or cable insulations, and must not be used for Tyco Electronics/Raychem 99T uncross-linked wires.*
- *Hot Air guns shall be set to a temperature as low as 300 deg C (570 deg F) to avoid thermal damage on uncross-linked wires, such as Tyco Electronics/Raychem 99T.*
- *Tyco Electronics recommends controlling temperature of application equipment such as hot air guns regularly.*

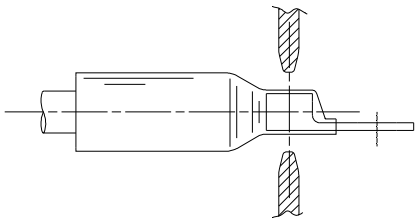
4. Installation Procedure:

- Select the correct DuraSeal crimp.
- Match its color with the color of the cavity of the crimp tool.
- Get the jaws in touch with the tubing.

DuraSeal Splice



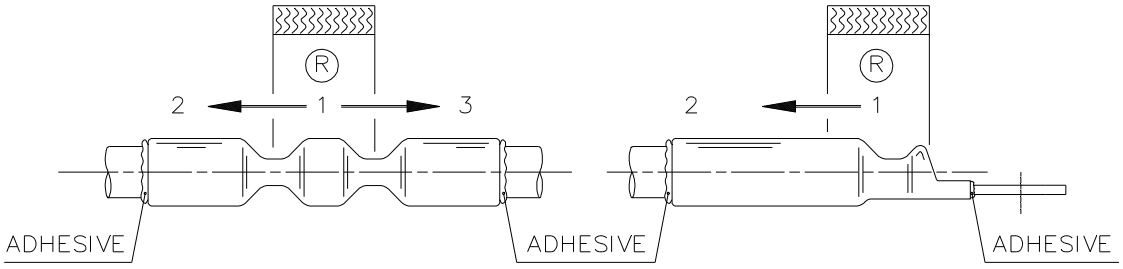
DuraSeal Terminal



- Insert the stripped wire until it butts inside the DuraSeal crimp.
- Crimp the wire in place.
- Repeat the operation symmetrically for the DuraSeal splice.
- Allow the hot air gun to warm up.
- Position the DuraSeal crimp in the reflector (R).
- Apply heat to shrink the sleeve until the adhesive melt and flow around the extremities of sleeve.

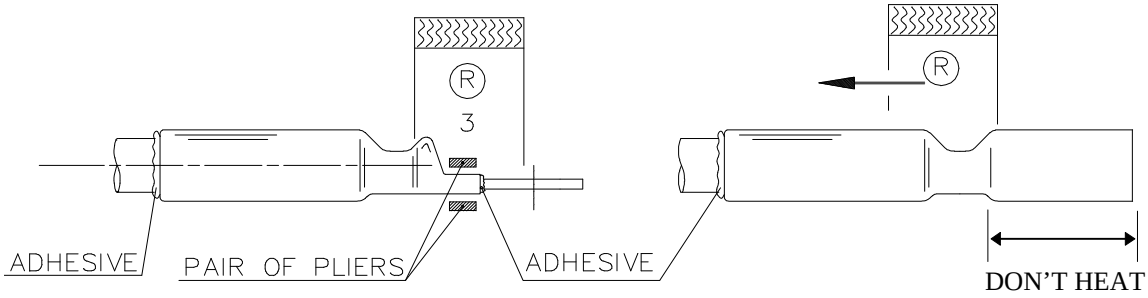
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are in between brackets]

DuraSeal Splice DuraSeal Terminal



Note: For DuraSeal terminals, in order to achieve maximum sealing (except for DuraSeal push- on) heat the terminal at 3 and press the flat part with a pair of pliers until the assembly cools.

Ring Terminal Push-on Terminal



Note: Do not heat the terminal for the push-on terminal.
Do not bend the splice or the terminal assemblies until then have completely cooled.

5. Inspection of Assembly:

Check:

- Wire insulation is positioned inside the DuraSeal sleeve.
- Adhesive has flowed to form a fillet around the ends of the sleeve.
- Sleeve is completely shrunk on to the wire insulation.
- Sleeve is not cut, split or discolored.
- Wire insulation has no signs of mechanical damage or overheating.

[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.)