



# M81824/1 • 070-001

## Mil-Qualified Splice

### In-Line, Insulated, Environmental

#### MIL-QUALIFIED IN-LINE SPLICE

#### How To Order

Product Series

Size  
(Table I)

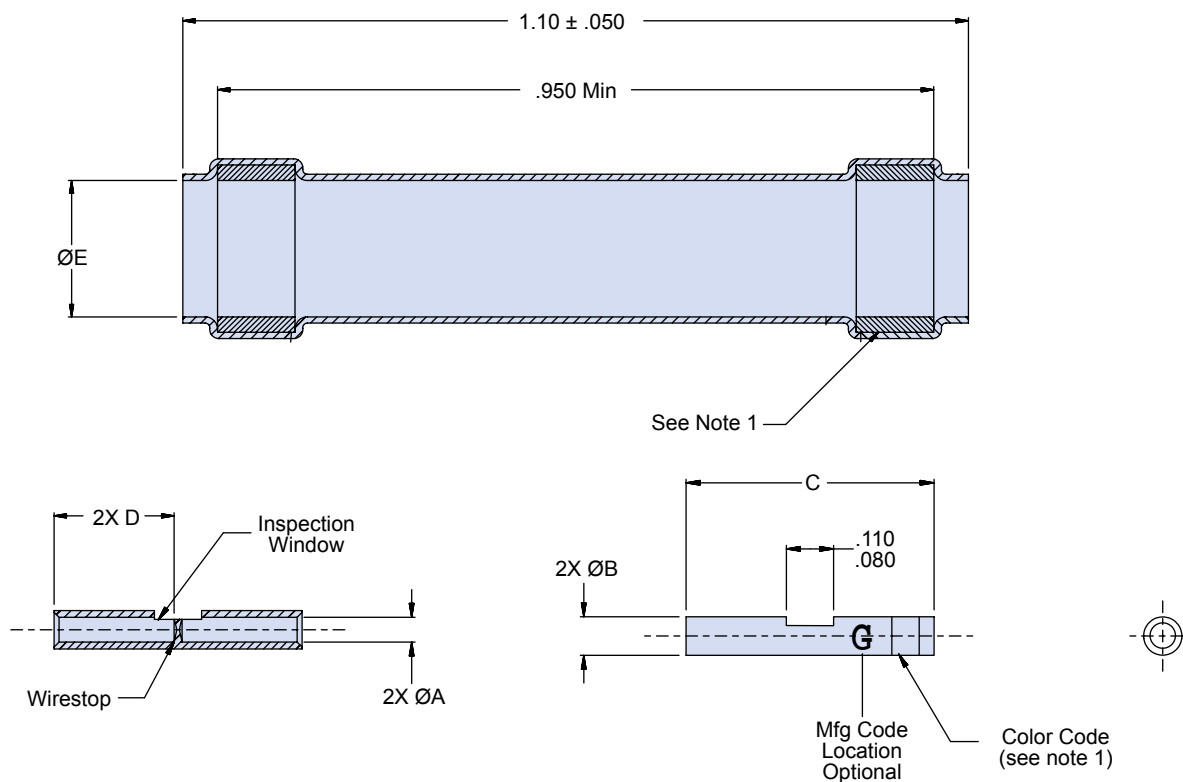
Product Series

Size  
(Table I)

070 - 001 03

M81824/1 - 1

Basic No.



#### 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.

Dimensions in Inches (millimeters) are subject to change without notice.

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**Mil-Qualified Splice**  
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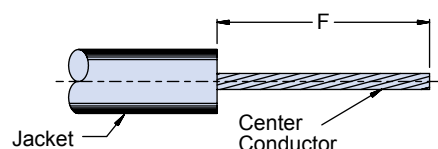
AS83519/1 and/2  
Type IIIA Splices

| 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)<br>.045 (1.14) | .080 (2.03)<br>.075 (1.90) | .510 (12.95)<br>.490 (12.45) | .245 (6.22)<br>.225 (5.72) | .085 (2.2)       | .025 (0.6)         | M81824/1-1 | Red                 |
| 02      | 16-20 AWG  | .069 (1.75)<br>.064 (1.63) | .106 (2.69)<br>.101 (2.57) | .585 (14.86)<br>.565 (14.35) | .280 (7.11)<br>.260 (6.60) | .110 (2.8)       | .025 (0.6)         | M81824/1-2 | Blue                |
| 03      | 12-16 AWG  | .102 (2.59)<br>.097 (2.46) | .153 (3.89)<br>.147 (3.74) | .585 (14.86)<br>.565 (14.35) | .280 (7.11)<br>.260 (6.60) | .170 (4.3)       | .025 (0.6)         | M81824/1-3 | Yellow              |

## ASSEMBLY INSTRUCTIONS

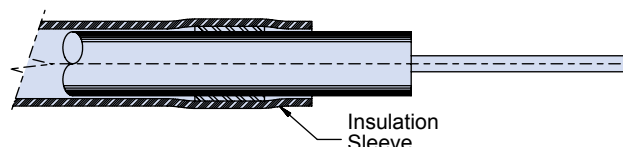
### Step A

- 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.



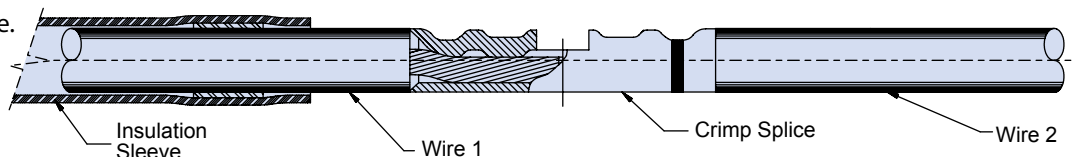
### Step B

- Slide Insulation Sleeve onto one of the wires



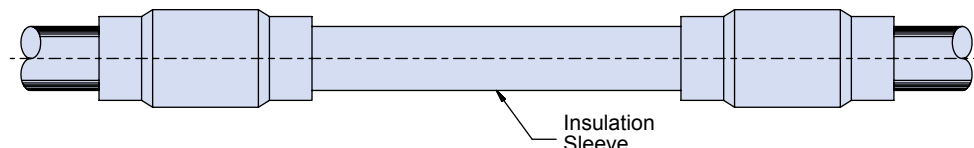
### Step C

- 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<br>Crimp Dies: M22520/5-102, -103<br>OR   |
| 070-00102 | 16, 18, 20     | .28 | Crimp Tool: M22520/10-01<br>Crimp Dies: M22520/10-103, -104<br>OR |
| 070-00103 | 12, 14, 16     | .28 | Crimp Tool: M22520/37-01<br>Crimp Dies: None                      |

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