

IN-LINE SPLICE Assembly Instructions

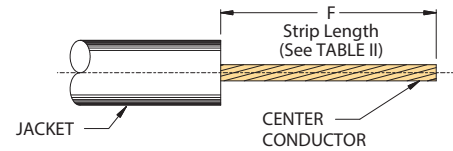


070-001 · 070-003 · 070-004 · GS81824/1

ASSEMBLY INSTRUCTIONS

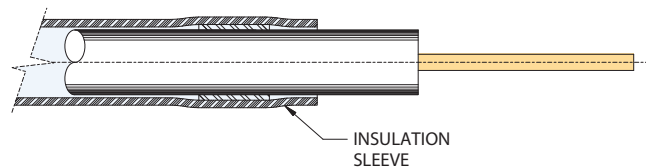
Step A

- 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.



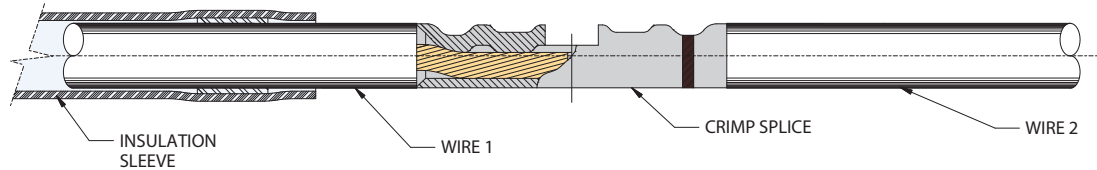
Step B

- 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.

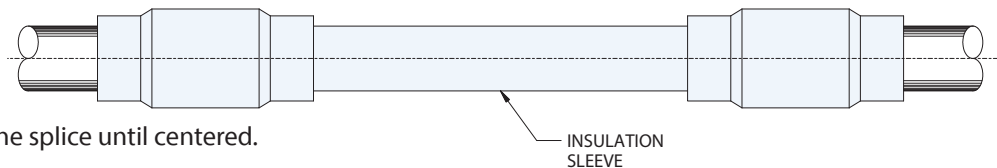


TABLE II: CRIMP TOOLS AND DIES, "F" STRIP LENGTH DIMENSION

Part No.	Wire Range	F	Crimp Tool Data
070-00101 070-003-1 070-004-1	20, 22, 24, 26	.24	Crimp Tool: M22520/5-01 Crimp Dies: M22520/5-102, -103 OR
070-00102 070-003-2 070-004-2	16, 18, 20	.28	Crimp Tool: M22520/10-01 Crimp Dies: M22520/10-103, -104 OR
070-00103 070-003-3 070-004-3	12, 14, 16	.28	Crimp Tool: M22520/37-01 Crimp Dies: None