

M81824/1 • 070-001
MIL-Qualified Splice
In-Line, Insulated, Environmental

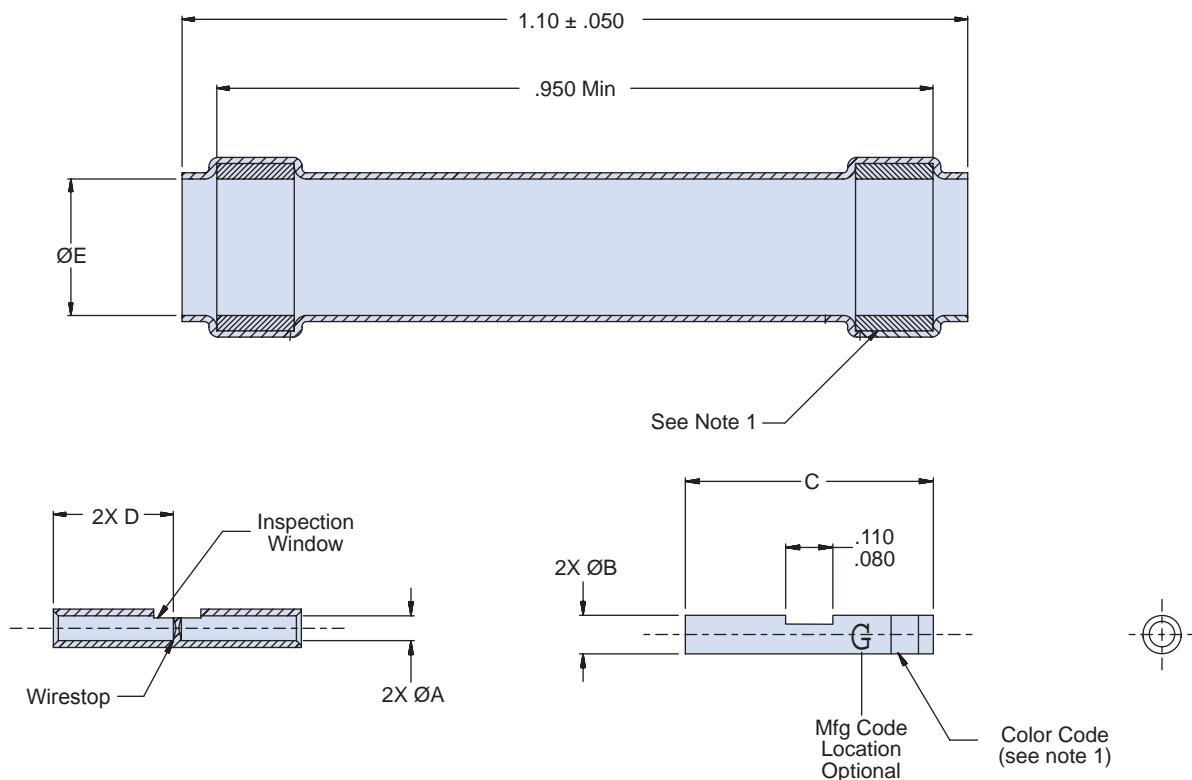


Misc. Backshells
and Accessories

**Product
Series**

Size
(Table I, Page G-18)

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APPLICATION NOTES

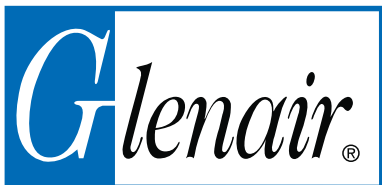
1. For complete dimensions see the applicable Military Specification.
2. One seal ring must be color coded per Table I. Splice to have matching circumferential color stripe.
3. Metric dimensions (mm) are in parentheses.
4. Material and Finish:
 Splice – Copper UNS C10100 ASTM F68 or ASTM B187.
 Finish – 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.

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

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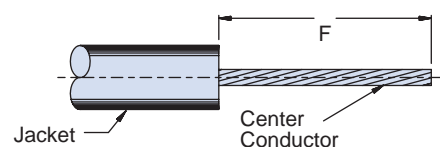
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Table I									
Size	Wire Range	A Dia	B Dia	C	D	E Dia		Mil Ref	Color Code (note 1)
						Min (Free State)	After Recovery Ref		
01	20–26 AWG	.050 (1.27)	.080 (2.03)	.510 (12.95)	.245 (6.22)	.085 (2.2)	.025 (0.6)	M81824/1-1	Red
		.045 (1.14)	.075 (1.90)	.490 (12.45)	.225 (5.72)				
02	16–20 AWG	.069 (1.75)	.106 (2.69)	.585 (14.86)	.280 (7.11)	.110 (2.8)	.025 (0.6)	M81824/1-2	Blue
		.064 (1.63)	.101 (2.57)	.565 (14.35)	.260 (6.60)				
03	12–16 AWG	.102 (2.59)	.153 (3.89)	.585 (14.86)	.280 (7.11)	.170 (4.3)	.025 (0.6)	M81824/1-3	Yellow
		.097 (2.46)	.147 (3.74)	.565 (14.35)	.260 (6.60)				

ASSEMBLY INSTRUCTIONS

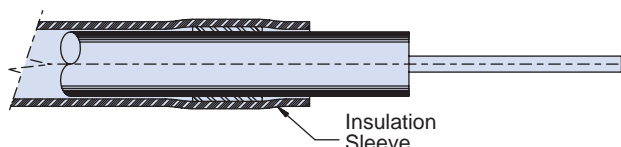
Step A

- 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.



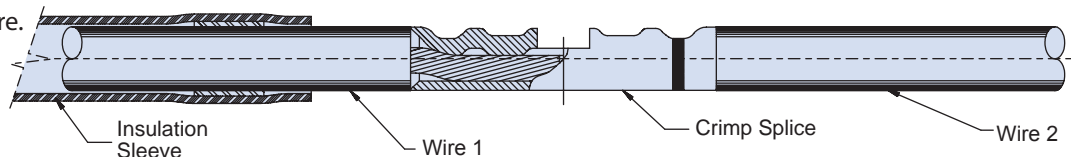
Step B

- 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.

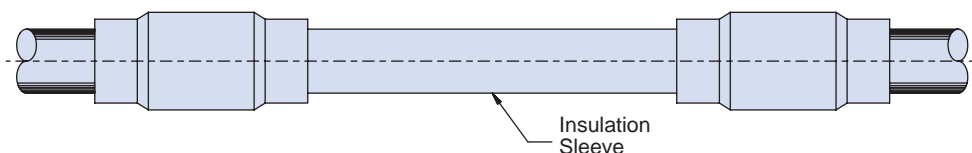


Table II			
Part No.	Wire Range	F	Crimp Tool Data
070-00101	20, 22, 24, 26	.24	Crimp Tool: M22520/5-01 Crimp Dies: M22520/5-102, -103 OR Crimp Tool: M22520/10-01 Crimp Dies: M22520/10-103, -104 OR Crimp Tool: M22520/37-01 Crimp Dies: None
070-00102	16, 18, 20	.28	
070-00103	12, 14, 16	.28	

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