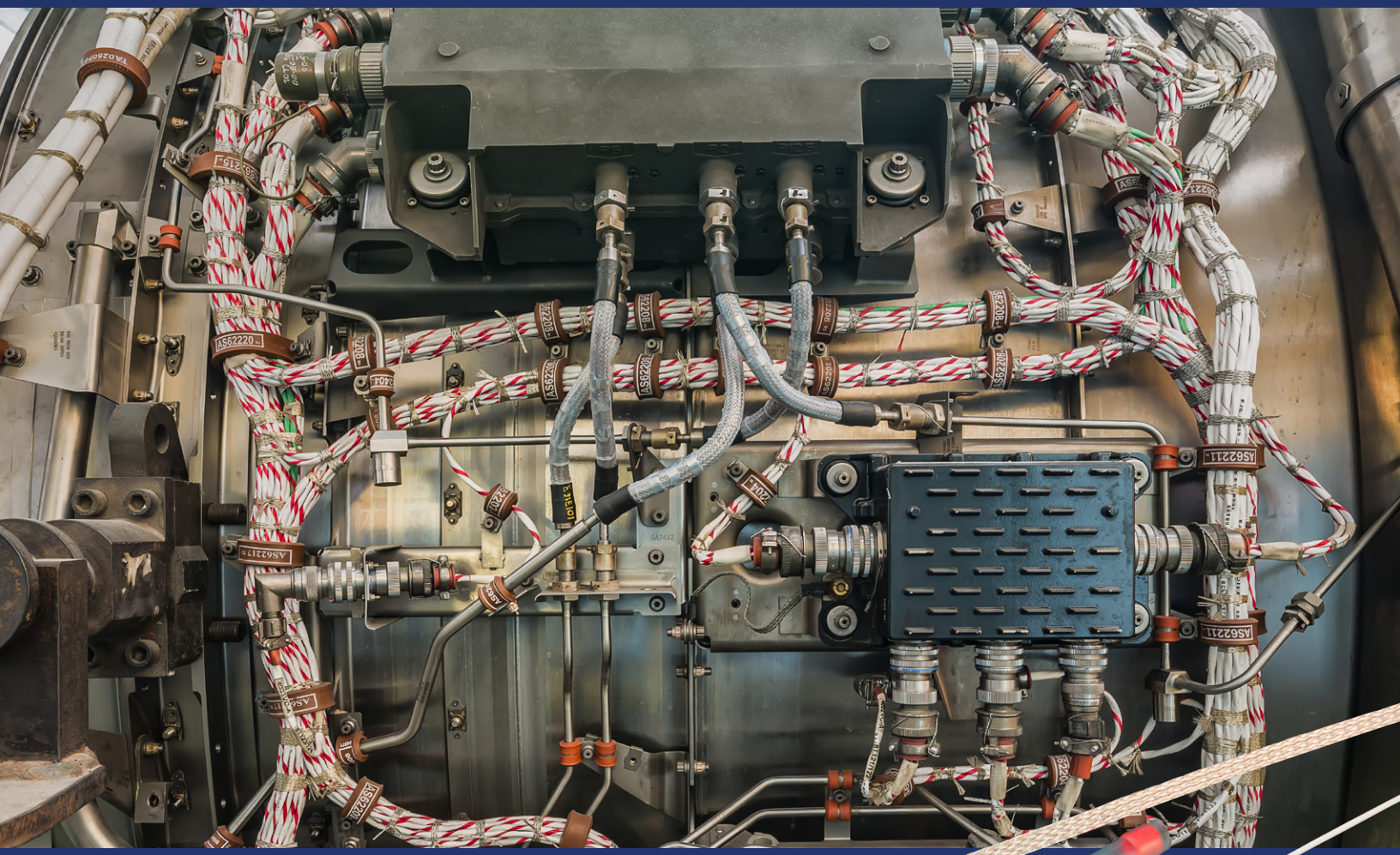
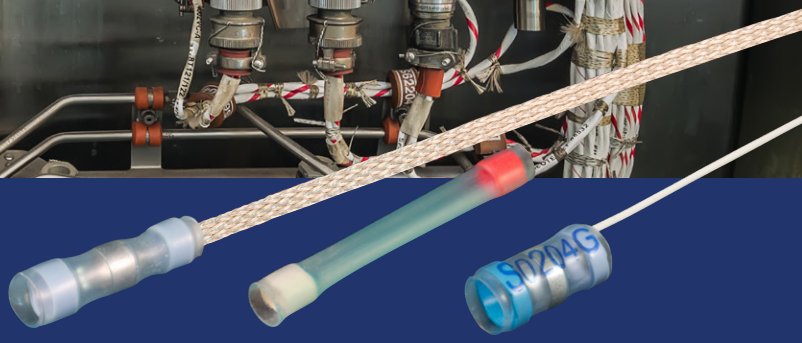
MISSION-CRITICAL
INTERCONNECT SOLUTIONS

Glenair®





AS83519/1 AND /2 TYPE

Heat Shrink Termination (HST) Sleeves and In-Line Splices

Lightweight ArmorLite and A-A-59569 Ground Leads
In-Stock Availability · No MOQs · Made in USA

JUNE 2026

A GLENAIR SIGNATURE

High-Rel Cable Assembly

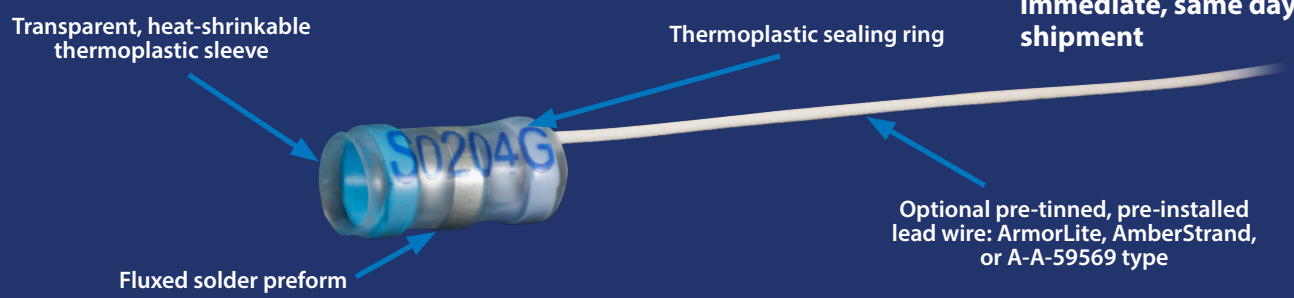
CRITICAL COMPONENT

HST Heat Shrink Termination

Heat Shrink Termination Sleeves and Splices– AS83519 and AS81824 type plus Glenair ArmorLite™ configurations

Reliable termination of EMI/RFI shielding (to ground) in wire harness applications is universally accomplished with AS83519/1 and /2 type heat shrink termination (HST) sleeves. These devices, supplied in five different sizes—with or without pre-installed ground lead wires—provide environmental encapsulation and insulation of the shield termination site. Lead-wire-equipped versions allow for easy and reliable grounding to connector shells, backshells, or ground posts. Transparent heat shrink tubing allows for easy inspection and supplies additional strength and strain-relief. The preflux solder preform delivers a fast and controlled solder joint each and every time. For weight saving applications, select Glenair signature series HSTs with lightweight ArmorLite or AmberStrand braided lead wires.

- **Heat shrink termination sleeves, with and without lead wire**
- **Ultra-fast recovery for reduced assembly time**
- **Pre-installed, pre-tinned braid version available**
- **Mil-qualified 81824/1 in-line-splices**
- **High availability: all Glenair HSTs made in USA and in-stock for immediate, same day shipment**

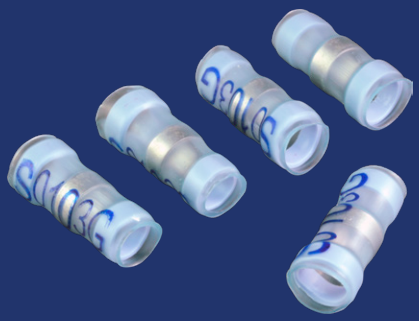


AS83519 AND AS81824 TYPES

Heat Shrink Termination (HST) Sleeves

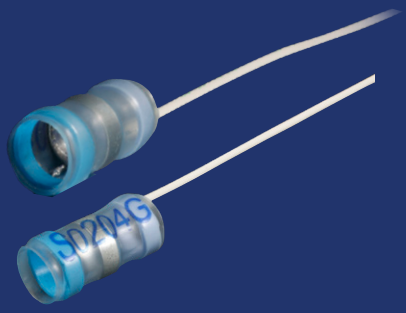
For fast and reliable termination of EMI cable shielding-to-ground. Lightweight ArmorLite™ configurations available.

AS83519/1 TYPE HEAT SHRINK TERMINATION (HST) SLEEVES, NO LEAD WIRE



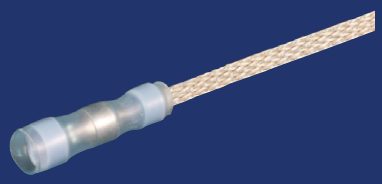
Designed to meet SAE AS83519 performance requirements, Glenair Heat Shrink Termination (HST) shield-to-ground termination sleeves are fabricated from transparent cross-linked polyvinylidene fluoride tubing to deliver optimal environmental shield termination in aerospace and defense applications. Each HST device is equipped with a pre-fluxed solder preform and thermally stabilized thermoplastic sealing rings that encapsulate and protect the shield-to-ground termination. Tested to perform from -55°C to 150°C.

AS83519/2 TYPE HEAT SHRINK TERMINATION (HST) SLEEVES, PRE-INSTALLED LEAD WIRE



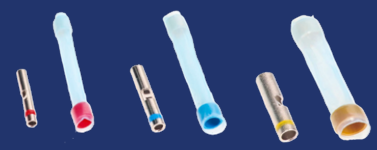
Designed to meet SAE AS83519 performance requirements, Glenair Heat Shrink Termination (HST) shield to ground termination sleeves with pre-installed shield ground wire are fabricated from transparent cross-linked polyvinylidene fluoride tubing to deliver optimal environmental shield termination in aerospace and defense applications. Each HST device is equipped with a pre-fluxed solder preform and thermally-stabilized thermoplastic sealing rings that encapsulate and protect the shield-to-ground termination. Tested to perform from -55°C to 150°C. Pre-installed shield ground wire facilitates easy grounding.

AS83519/3 TYPE HEAT SHRINK TERMINATION (HST) SLEEVES, PRE-INSTALLED BRAID, PRE-TINNED ON BOTH ENDS



Designed to meet SAE AS83519 performance requirements, Glenair Heat Shrink Termination (HST) shield to ground termination sleeves with pre-installed braid are fabricated from transparent cross-linked polyvinylidene fluoride tubing to deliver optimal environmental shield termination in aerospace and defense applications. Each HST device is equipped with a pre-fluxed solder preform and thermally-stabilized thermoplastic sealing rings that encapsulate and protect the shield-to-ground termination. Tested to perform from -55°C to 150°C. Pre-tinned, braided ground lead materials available in standard A-A-59569 tin-, nickel-, and silver-copper braid, or Glenair signature lightweight AmberStrand and ArmorLite.

MIL-QUALIFIED AND GLENAIR SIGNATURE IN-LINE SPLICES IAW AS81824/1 AND /6



Engineered to meet stringent MIL-DTL-81824/1 and /6 performance standards, Glenair in-line splices deliver consistent electrical integrity and long-term environmental sealing under extreme conditions. The compact two-piece design utilizes a solder-free crimp splice and sealing sleeve to ensure fast, repeatable installation with minimal tooling. Ideal for use in sealed harness assemblies, Glenair in-line splices are vibration-resistant, moisture-proof, and compatible with standard AS22759 wire types.

AS83519/1 Type HST Sleeve

077-010 • Without Lead Wire

Designed to meet SAE AS83519 performance requirements, Glenair Heat Shrink Termination (HST) shield-to-ground termination sleeves are fabricated from radiation cross-linked translucent blue PVDF tubing. Each HST device is equipped with a pre-fluxed solder preform and thermally-stabilized thermoplastic sealing rings that encapsulate and protect the shield-to-ground termination.

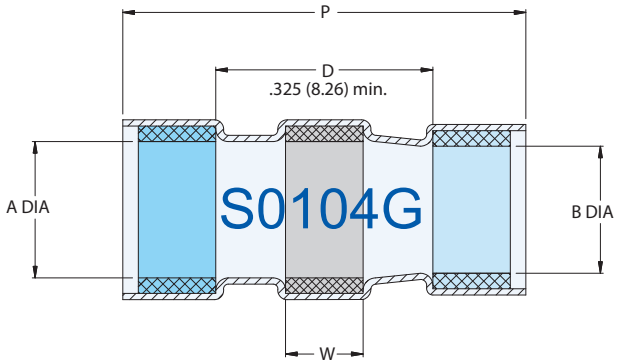
HOW TO ORDER

Sample Part Number	077	-010	03	T
Product Series	HST Sleeve			
Basic No.	**-010** Without lead wire			
Size	**01**, **02**, **03**, **04**, **05** (See Table)			
Thermal Indicator	**T** = With thermal indicator **Omit** for none			

MATERIAL AND PERFORMANCE NOTES

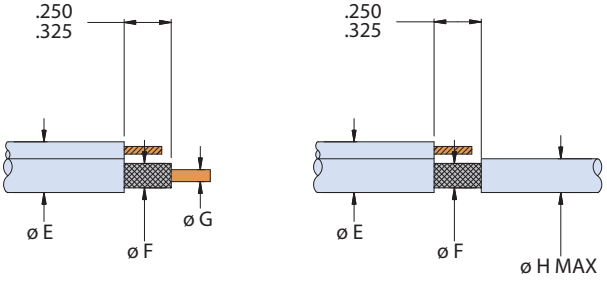
- Insulation sleeve: heat-shrinkable, translucent blue PVDF
- Radiation crosslinked per AS23053/8
- Solder: Sn63 per IPC-J-STD-006
- Flux: ROL1 per IPC-J-STD-004
- Sealing ring: thermally stabilized thermoplastic, color blue
- Temperature rating: -55°C to +150°C
- Cable jacket rating: 125°C min
- Shield plating: tin or silver

HST SIZE AND DIMENSIONS



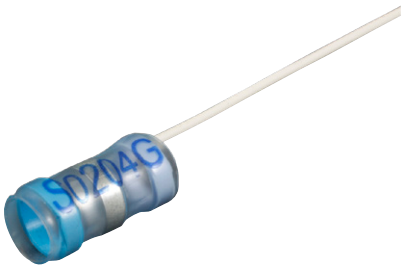
Size	ØA Min	ØB Min	P±.07	W Ref	ØE Max	ØF Min	ØG Min	ØH Max	Mil P/N Ref	Marking Code
01	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)	M83519/1-1	S0101G
02	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)	M83519/1-2	S0102G
03	.200 (5.08)	.170 (4.32)	.65 (16.5)	.095 (2.42)	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)	M83519/1-3	S0103G
04	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)	M83519/1-4	S0104G
05	.300 (7.62)	.275 (6.99)	.75 (19.0)	.125 (3.18)	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)	M83519/1-5	S0105G

WIRE PREPARATION DIAGRAMS



AS83519/2 Type HST Sleeve

077-020 • With Pre-Installed Lead Wire



Designed to meet SAE AS83519 performance requirements, Glenair Heat Shrink Termination (HST) shield to ground termination sleeves with pre-installed lead wire are fabricated from radiation cross-linked translucent blue PVDF tubing. Each HST device is equipped with a pre-fluxed solder preform and thermally-stabilized thermoplastic sealing rings that encapsulate and protect the shield-to-ground termination.

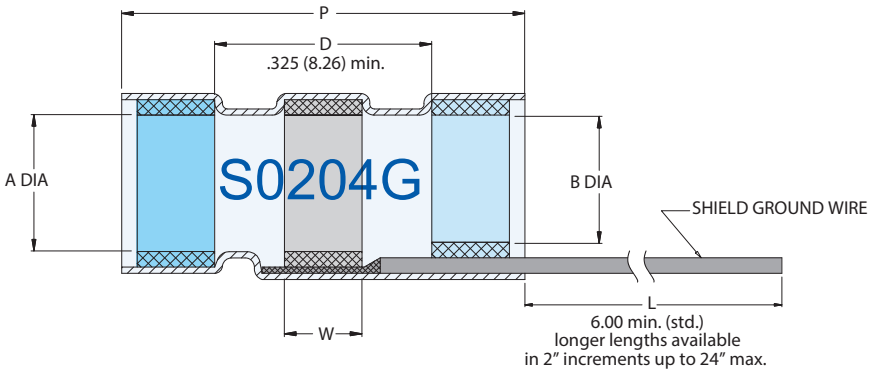
MATERIAL AND PERFORMANCE NOTES

- Insulation sleeve: heat-shrinkable, translucent blue PVDF
- Radiation crosslinked per AS23053/8
- Solder: Sn63 per IPC-J-STD-006
- Flux: ROL1 per IPC-J-STD-004
- Sealing ring: thermally stabilized thermoplastic, color blue
- Temperature rating: -55°C to +150°C
- Cable jacket rating: 125°C min
- Shield plating: tin or silver
- Contact Glenair for other wire sizes and options

HOW TO ORDER

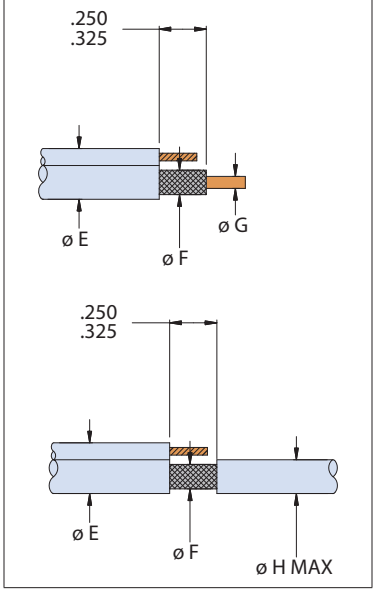
Sample Part Number	077	-020	02	T	-12
Product Series	HST Sleeve				
Basic No.	**-020** With pre-installed lead wire				
Size	**01** – **20** (See Table)				
Thermal Indicator	**T** = With thermal indicator **Omit** for none				
Wire Length	In Inches. **Omit** for standard 6 in. Longer wire available in 2" increments, 24" max.				

HST SIZE AND DIMENSIONS



Size	ØA Min	ØB Min	P±.07	W Ref	Lead Wire GS22759-32	Marking Code	ØE Max	ØF Min	ØG Min	ØH Max	M83519/2 P/N Ref.
01	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	-20-90	S0201G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)	-1
02	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)	-20-90	S0202G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)	-2
03	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)	-20-90	S0203G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)	-3
04	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)	-20-90	S0204G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)	-4
05	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)	-20-90	S0205G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)	-5
06	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	-22-90	S0206G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)	-6
07	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)	-22-90	S0207G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)	-7
08	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)	-22-90	S0208G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)	-8
09	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)	-22-90	S0209G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)	-9
10	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)	-22-90	S0210G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)	-10
11	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	-24-90	S0211G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)	-11
12	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)	-24-90	S0212G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)	-12
13	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)	-24-90	S0213G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)	-13
14	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)	-24-90	S0214G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)	-14
15	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)	-24-90	S02015G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)	-15
16	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	-26-90	S0216G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)	-16
17	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)	-26-90	S0217G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)	-17
18	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)	-26-90	S0218G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)	-18
19	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)	-26-90	S0219G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)	-19
20	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)	-26-90	S0220G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)	-20

WIRE PREPARATION DIAGRAMS



AS83519/3 Type HST Sleeve

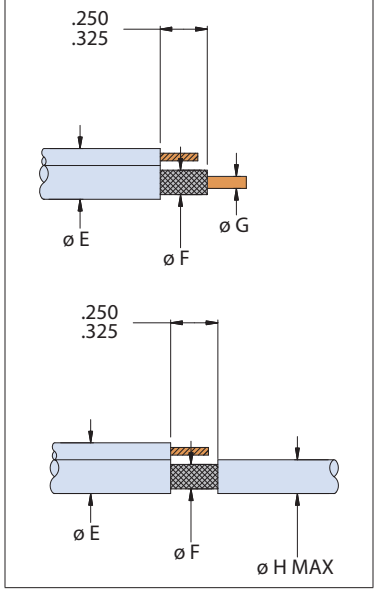
077-030 • Pre-Installed Braid, Pre-Tinned on Both Ends

Designed to meet SAE AS83519 performance requirements, Glenair Heat Shrink Termination (HST) shield to ground termination sleeves with pre-installed braid are fabricated from radiation cross-linked translucent blue PVDF tubing. Each HST device is equipped with a pre-fluxed solder preform and thermally-stabilized thermoplastic sealing rings that encapsulate and protect the shield-to-ground termination. Pre-tinned, braided ground lead materials available in standard A-A-59569 tin-, nickel-, and silver-copper braid, or Glenair signature AmberStrand and ArmorLite.

MATERIAL AND PERFORMANCE NOTES

- Insulation sleeve: heat-shrinkable, translucent blue PVDF
- Radiation crosslinked per AS23053/8
- Solder: Sn63 per IPC-J-STD-006
- Flux: ROL1 per IPC-J-STD-004
- Sealing ring: thermally stabilized thermoplastic, color blue
- Temperature rating: -55°C to +150°C
- Cable jacket rating: 125°C min
- Braided shield ground lead
- Contact Glenair for other braid sizes and options

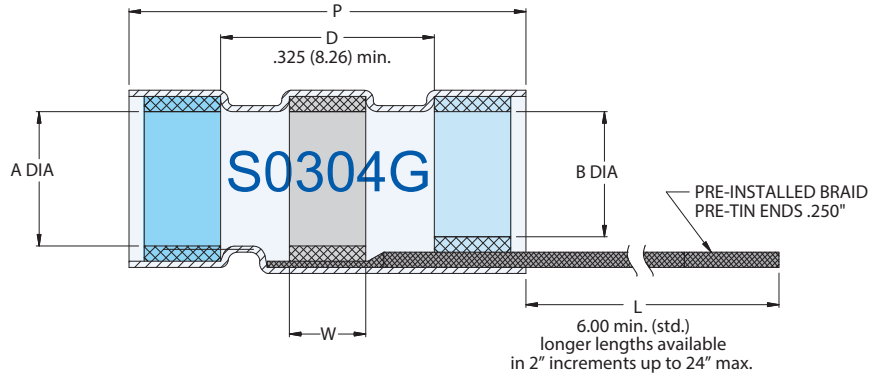
WIRE PREPARATION DIAGRAMS



HOW TO ORDER

Sample Part Number	077	-030	03	T	-12
Product Series	HST Sleeve				
Basic No.	**-030** With pre-installed braid, pre-tinned				
Size / Braid Material	**01** – **60** (See Table)				
Thermal Indicator	**T** = With thermal indicator **Omit** for none				
Braid Length	In Inches. **Omit** for standard 6 in. Longer braid available in 2" increments, 24" max.				

HST SIZE AND DIMENSIONS



HST SIZE AND DIMENSIONS: ARMORLITE BRAID 103-051

Size	ØA Min	ØB Min	P±.07	W Ref	ArmorLite Braid P/N	Marking Code	ØE Max	ØF Min	ØG Min	ØH Max
31	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	103-051-004	S0331G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)
32	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)		S0332G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)
33	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)		S0333G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)
34	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)		S0334G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)
35	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)		S0335G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)
36	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	103-051-002	S0336G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)
37	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)		S0337G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)
38	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)		S0338G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)
39	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)		S0339G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)
40	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)		S0340G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)

AS83519/3 Type HST Sleeve

077-030 • Pre-Installed Braid, Pre-Tinned on Both Ends

HST SIZE AND DIMENSIONS: TIN-COPPER BRAID 36AWG PER A-A-59569										
Size	ØA Min	ØB Min	P±.07	W Ref	Tin-Copper Braid P/N	Marking Code	ØE Max	ØF Min	ØG Min	ØH Max
01	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	101-004-062-36 CMA 1200 Construction: 24X2/36	S0301G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)
02	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)		S030G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)
03	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)		S0303G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)
04	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)		S0304G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)
05	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)		S0305G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)
06	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	101-004-031-36 CMA 600 Construction: 24X1/36	S0306G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)
07	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)		S0307G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)
08	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)		S0308G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)
09	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)		S0309G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)
10	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)		S0310G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)

HST SIZE AND DIMENSIONS: AMBERSTRAND BRAID 103-027										
Size	ØA Min	ØB Min	P±.07	W Ref	AmberStrand Braid P/N	Marking Code	ØE Max	ØF Min	ØG Min	ØH Max
21	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	103-027-004	S0321G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)
22	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)		S0322G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)
23	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)		S0323G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)
24	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)		S0324G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)
25	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)		S0325G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)
26	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	103-027-002	S0326G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)
27	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)		S0327G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)
28	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)		S0328G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)
29	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)		S0329G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)
30	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)		S0330G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)

HST SIZE AND DIMENSIONS: SILVER-COPPER BRAID PER A-A-59569										
Size	ØA Min	ØB Min	P±.07	W Ref	Silver-Copper Braid P/N	Marking Code	ØE Max	ØF Min	ØG Min	ØH Max
41	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	101-004-062-36S CMA 1200 Construction: 24X2/36	S0341G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)
42	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)		S0342G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)
43	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)		S0343G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)
44	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)		S0344G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)
45	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)		S0345G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)
46	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	101-004-031-36S CMA 600 Construction: 24X1/36	S0346G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)
47	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)		S0347G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)
48	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)		S0348G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)
49	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)		S0349G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)
50	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)		S0350G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)

HST SIZE AND DIMENSIONS: NICKEL-COPPER BRAID PER A-A-59569										
Size	ØA Min	ØB Min	P±.07	W Ref	Silver-Copper Braid P/N	Marking Code	ØE Max	ØF Min	ØG Min	ØH Max
51	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	101-004-062-36N CMA 1200 Construction: 24X2/36	S0351G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)
52	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)		S0352G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)
53	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)		S0353G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)
54	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)		S0354G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)
55	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)		S0355G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)
56	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	101-004-031-36N CMA 600 Construction: 24X1/36	S0356G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)
57	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)		S0357G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)
58	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)		S0358G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)
59	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)		S0359G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)
60	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)		S0360G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)

AS83519/1 Type HST Sleeve

GS83519/1 • Without Lead Wire

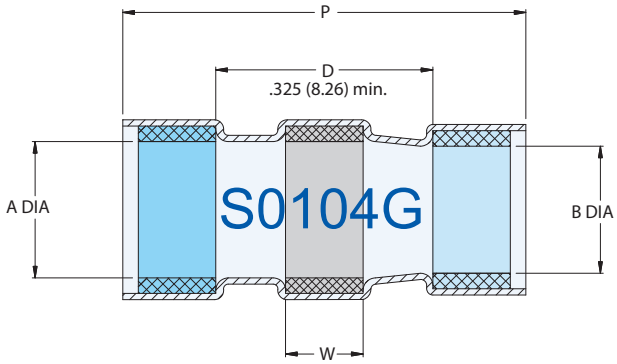
Designed to meet SAE AS83519 performance requirements, Glenair Heat Shrink Termination (HST) shield-to-ground termination sleeves are fabricated from radiation cross-linked translucent blue PVDF tubing. Each HST device is equipped with a pre-fluxed solder preform and thermally-stabilized thermoplastic sealing rings that encapsulate and protect the shield-to-ground termination.

HOW TO ORDER			
Sample Part Number	**GS83519**	**/1**	**3**
Product Series	HST Sleeve		
Basic No.	**/1** Without lead wire		
Size	**1**, **2**, **3**, **4**, **5** (See Table)		

MATERIAL AND PERFORMANCE NOTES

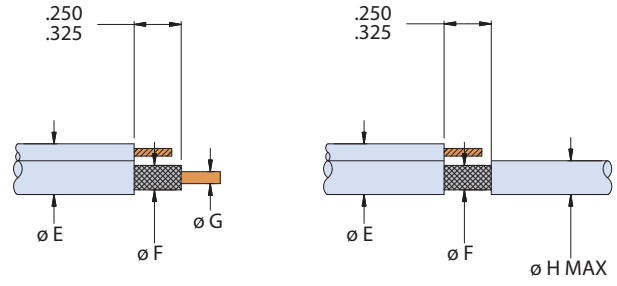
- Insulation sleeve: heat-shrinkable, translucent blue PVDF
- Radiation crosslinked per AS23053/8
- Solder: Sn63 per IPC-J-STD-006
- Flux: ROL1 per IPC-J-STD-004
- Sealing ring: thermally stabilized thermoplastic, color blue
- Temperature rating: -55°C to +150°C
- Cable jacket rating: 125°C min
- Shield plating: tin or silver

HST SIZE AND DIMENSIONS



Size	ØA Min	ØB Min	P±.07	W Ref	ØE Max	ØF Min	ØG Min	ØH Max	Mil P/N Ref	Marking Code
1	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)	M83519/1-1	S0101G
2	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)	M83519/1-2	S0102G
3	.200 (5.08)	.170 (4.32)	.65 (16.5)	.095 (2.42)	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)	M83519/1-3	S0103G
4	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)	M83519/1-4	S0104G
5	.300 (7.62)	.275 (6.99)	.75 (19.0)	.125 (3.18)	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)	M83519/1-5	S0105G

WIRE PREPARATION DIAGRAMS



AS83519/2 Type HST Sleeve

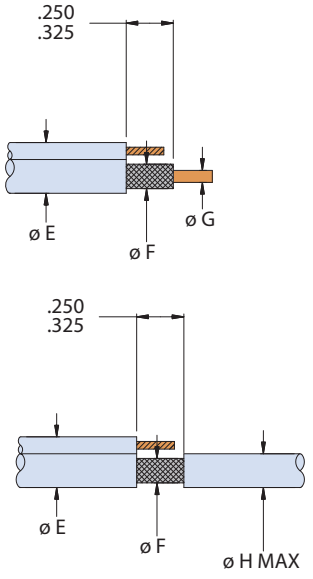
GS83519/2 • With Pre-Installed Lead Wire

Designed to meet SAE AS83519 performance requirements, Glenair Heat Shrink Termination (HST) shield to ground termination sleeves with pre-installed lead wire are fabricated from radiation cross-linked translucent blue PVDF tubing. Each HST device is equipped with a pre-fluxed solder preform and thermally-stabilized thermoplastic sealing rings that encapsulate and protect the shield-to-ground termination.

MATERIAL AND PERFORMANCE NOTES

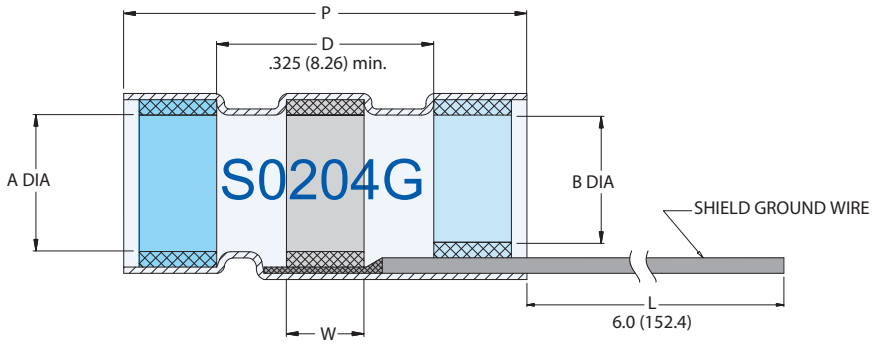
- Insulation sleeve: heat-shrinkable, translucent blue PVDF
- Radiation crosslinked per AS23053/8
- Solder: Sn63 per IPC-J-STD-006
- Flux: ROL1 per IPC-J-STD-004
- Sealing ring: thermally stabilized thermoplastic, color blue
- Temperature rating: -55°C to +150°C
- Cable jacket rating: 125°C min
- Shield plating: tin or silver

WIRE PREPARATION DIAGRAMS



HOW TO ORDER			
Sample Part Number	**GS83519**	**/2**	**3**
Product Series	HST Sleeve		
Basic No.	**/2** With pre-installed lead wire		
Size	**0** – **20** (See Table)		

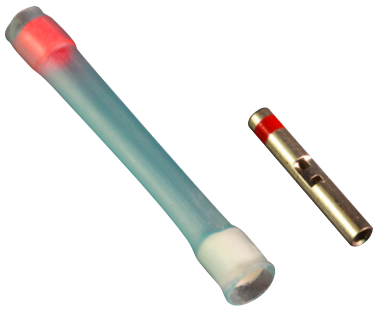
HST SIZE AND DIMENSIONS



Size	ØA Min	ØB Min	P±.07	W Ref	Lead Wire GS22759-32	Marking Code	ØE Max	ØF Min	ØG Min	ØH Max	M83519/2 P/N Ref.
1	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	-20-90	S0201G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)	-1
2	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)	-20-90	S0202G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)	-2
3	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)	-20-90	S0203G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)	-3
4	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)	-20-90	S0204G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)	-4
5	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)	-20-90	S0205G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)	-5
6	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	-22-90	S0206G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)	-6
7	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)	-22-90	S0207G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)	-7
8	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)	-22-90	S0208G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)	-8
9	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)	-22-90	S0209G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)	-9
10	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)	-22-90	S0210G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)	-10
11	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	-24-90	S0211G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)	-11
12	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)	-24-90	S0212G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)	-12
13	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)	-24-90	S0213G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)	-13
14	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)	-24-90	S0214G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)	-14
15	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)	-24-90	S0215G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)	-15
16	.105 (2.67)	.075 (1.91)	.65 (16.5)	.095 (2.42)	-26-90	S0216G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)	-16
17	.145 (3.68)	.105 (2.67)	.65 (16.5)	.095 (2.42)	-26-90	S0217G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)	-17
18	.200 (5.08)	.170 (4.32)	.65 (16.5)	.125 (3.18)	-26-90	S0218G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)	-18
19	.255 (6.48)	.235 (5.97)	.75 (19.0)	.125 (3.18)	-26-90	S0219G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)	-19
20	.300 (7.62	.275 (7.0)	.75 (19.0)	.125 (3.18)	-26-90	S0220G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)	-20

M81824/1 Mil-Qualified Splice

070-001 • In-Line, Insulated, Environmental. Tin-Plated Copper,

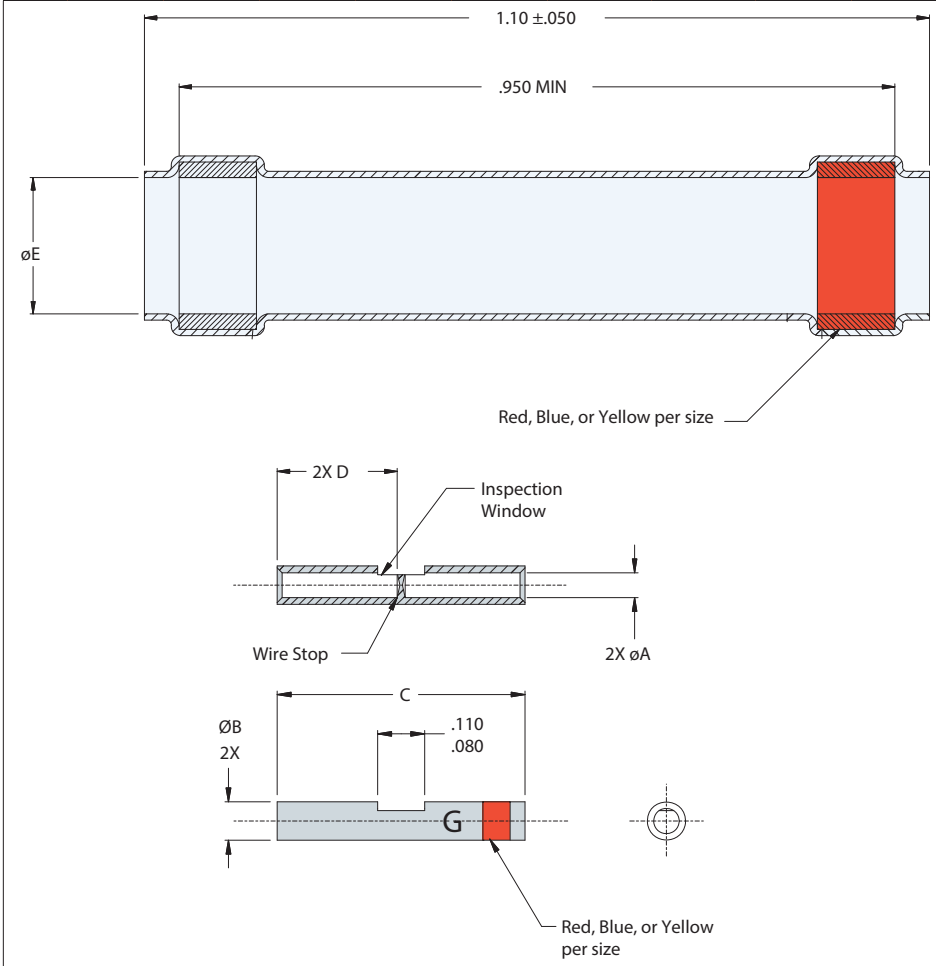


HOW TO ORDER			
Sample Part Number	**070**	**-001**	**03**
Product Series	In-Line Splice		
Basic No.	**-001**		
Size	**01**, **02**, **03** (See Table)		

MATERIAL AND PERFORMANCE NOTES

- Splice: Copper, tin-plate over nickel
- Sealing material: thermoplastic, thermally stabilized
- Shrink Sleeve: transparent, heat-shrinkable, crosslinked PVDF, per AMS-DTL-23053/8
- Temperature rating: -55°C to +150°C
- Wire rating: 150°C min
- Color coded seal ring per size dash no. Splice to have matching color stripe.

SHRINK SLEEVE AND SPLICE SIZE AND DIMENSIONS



Size	Wire Range AWG	ØA	ØB	C	D	ØE Min (Free State)	ØE After Recovery Ref	Mil P/N Ref	Color Code
01	20, 22, 24, 26	.050 (1.27) .045 (1.14)	.080 (2.03) .075 (1.90)	.510 (12.95) .490 (12.45)	.245 (6.22) .225 (5.72)	.085 (2.2)	.025 (0.6)	M81824/1-1	Red
02	16, 18, 20	.069 (1.75) .064 (1.63)	.106 (2.69) .101 (2.57)	.585 (14.86) .565 (14.35)	.280 (7.11) .260 (6.60)	.110 (2.8)	.025 (0.6)	M81824/1-2	Blue
03	12, 14, 16	.102 (2.59) .097 (2.46)	.153 (3.89) .147 (3.74)	.585 (14.86) .565 (14.35)	.280 (7.11) .260 (6.60)	.170 (4.3)	.025 (0.6)	M81824/1-3	Yellow

M81824/1 Type Splice

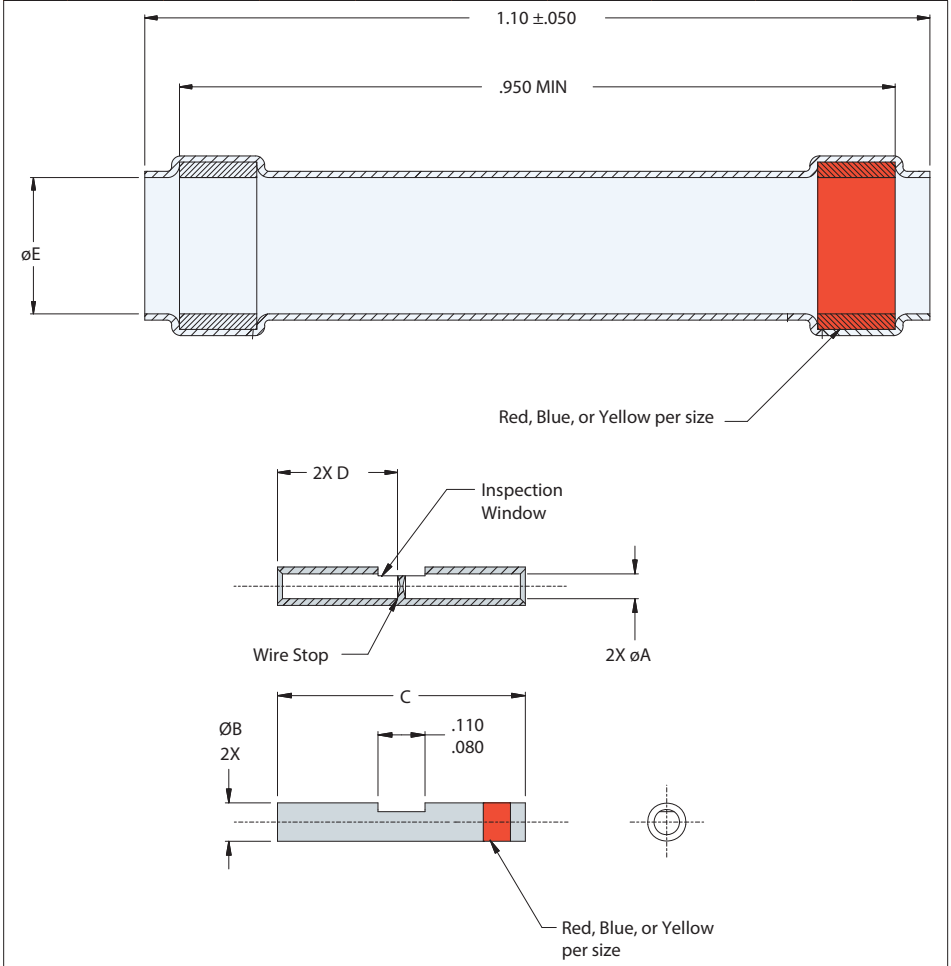
070-003 • In-Line, Insulated, Environmental. Tin-Plated Copper

HOW TO ORDER			
Sample Part Number	**070**	**-003**	**-1**
Product Series	In-Line Splice		
Basic No.	**-003** AS81824/1 Type, Tin-Plated Copper splice		
Size	**-1**, **-2**, **-3** (See Table)		

MATERIAL AND PERFORMANCE NOTES

- Splice: Copper, tin-plate over nickel
- Sealing material: thermoplastic, thermally stabilized
- Shrink Sleeve: transparent, heat-shrinkable, crosslinked PVDF, per AMS-DTL-23053/8
- Temperature rating: -55°C to +150°C
- Wire rating: 150°C min
- Color coded seal ring per size dash no. Splice to have matching color stripe.

SHRINK SLEEVE AND SPLICE SIZE AND DIMENSIONS



Size	Wire Range AWG	ØA	ØB	C	D	ØE Min (Free State)	ØE After Recovery Ref	Mil P/N Ref	Color Code
1	20, 22, 24, 26	0.053 (1.35) 0.045 (1.14)	0.080 (2.03) 0.075 (1.91)	.510 (12.95) .490 (12.45)	.245 (6.22) .225 (5.72)	.085 (2.2)	.025 (0.6)	M81824/1-1	Red
2	16, 18, 20	0.070 (1.78) 0.063 (1.60)	0.107 (2.72) 0.100 (2.54)	.585 (14.86) .565 (14.35)	.280 (7.11) .260 (6.60)	.110 (2.8)	.025 (0.6)	M81824/1-2	Blue
3	12, 14, 16	0.103 (2.62) 0.095 (2.41)	0.155 (3.94) 0.146 (3.71)	.585 (14.86) .565 (14.35)	.280 (7.11) .260 (6.60)	.170 (4.3)	.025 (0.6)	M81824/1-3	Yellow

M81824/6 Type Splice

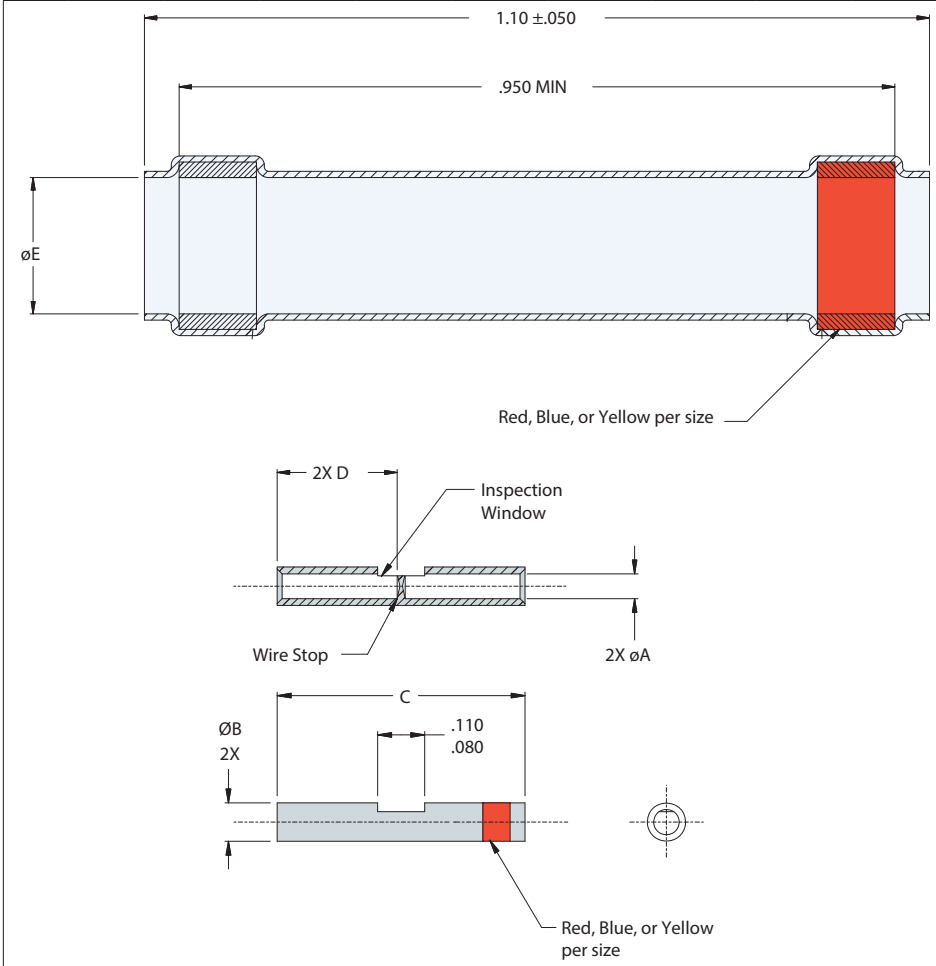
070-004 • In-Line, Insulated, Environmental. Nickel-Plated Copper

HOW TO ORDER			
Sample Part Number	**070**	**-004**	**-2**
Product Series	In-Line Splice		
Basic No.	**-004** AS81824/6 Type, Nickel-Plated Copper splice		
Size	**-1**, **-2**, **-3** (See Table)		

MATERIAL AND PERFORMANCE NOTES

- Splice: Copper, nickel-plate
- Sealing material: thermoplastic, thermally stabilized
- Shrink Sleeve: transparent, heat-shrinkable, crosslinked PVDF, per AMS-DTL-23053/8
- Temperature rating: -55°C to +175°C
- Wire rating: 175°C min
- Color coded seal ring per size dash no. Splice to have matching color stripe.

SHRINK SLEEVE AND SPLICE SIZE AND DIMENSIONS



Size	Wire Range AWG	ØA	ØB	C	D	ØE Min (Free State)	ØE After Recovery Ref	Mil P/N Ref	Color Code
1	20, 22, 24, 26	0.053 (1.35) 0.045 (1.14)	0.080 (2.03) 0.075 (1.91)	.510 (12.95) .490 (12.45)	.245 (6.22) .225 (5.72)	.085 (2.2)	.025 (0.6)	M81824/1-1	Red
2	16, 18, 20	0.070 (1.78) 0.063 (1.60)	0.107 (2.72) 0.100 (2.54)	.585 (14.86) .565 (14.35)	.280 (7.11) .260 (6.60)	.110 (2.8)	.025 (0.6)	M81824/1-2	Blue
3	12, 14, 16	0.103 (2.62) 0.095 (2.41)	0.155 (3.94) 0.146 (3.71)	.585 (14.86) .565 (14.35)	.280 (7.11) .260 (6.60)	.170 (4.3)	.025 (0.6)	M81824/1-3	Yellow

GS81824/1 Splice

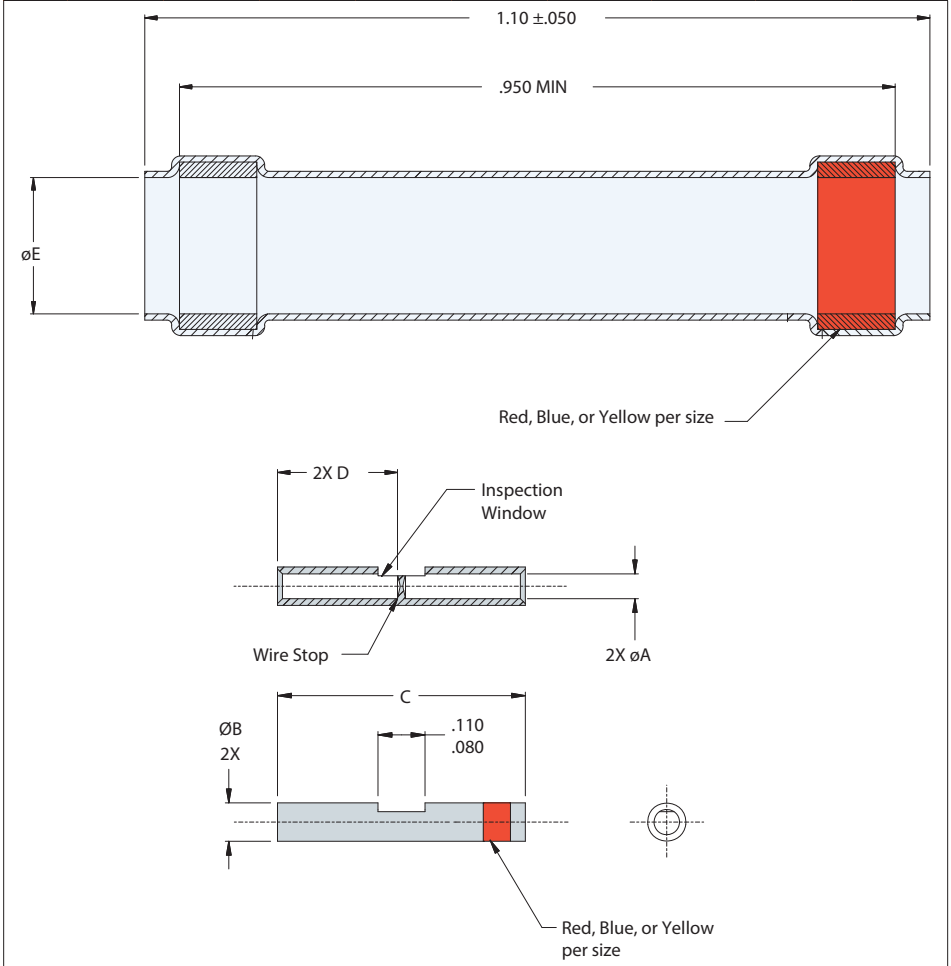
GS81824/1 • In-Line, Insulated, Environmental. Tin-Plated Copper

HOW TO ORDER			
Sample Part Number	**GS81824**	**/1**	**-3**
Product Series	In-Line Splice		
Basic No.	**/1** AS81824/1 Type, Tin-Plated Copper splice		
Size	**-1**, **-2**, **-3** (See Table)		

MATERIAL AND PERFORMANCE NOTES

- Splice: Copper, tin-plate
- Sealing material: thermoplastic, thermally stabilized
- Shrink Sleeve: transparent, heat-shrinkable, crosslinked PVDF, per AMS-DTL-23053/8
- Temperature rating: -55°C to +150°C
- Cable jacket rating: 150°C min
- Color coded seal ring per size dash no. Splice to have matching color stripe.

SHRINK SLEEVE AND SPLICE SIZE AND DIMENSIONS



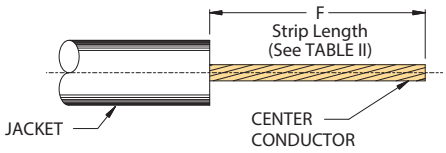
Size	Wire Range AWG	ØA	ØB	C	D	ØE Min (Free State)	ØE After Recovery Ref	Mil P/N Ref	Color Code
1	20, 22, 24, 26	0.053 (1.35) 0.045 (1.14)	0.080 (2.03) 0.075 (1.91)	.510 (12.95) .490 (12.45)	.245 (6.22) .225 (5.72)	.085 (2.2)	.025 (0.6)	M81824/1-1	Red
2	16, 18, 20	0.070 (1.78) 0.063 (1.60)	0.107 (2.72) 0.100 (2.54)	.585 (14.86) .565 (14.35)	.280 (7.11) .260 (6.60)	.110 (2.8)	.025 (0.6)	M81824/1-2	Blue
3	12, 14, 16	0.103 (2.62) 0.095 (2.41)	0.155 (3.94) 0.146 (3.71)	.585 (14.86) .565 (14.35)	.280 (7.11) .260 (6.60)	.170 (4.3)	.025 (0.6)	M81824/1-3	Yellow

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

ASSEMBLY INSTRUCTIONS

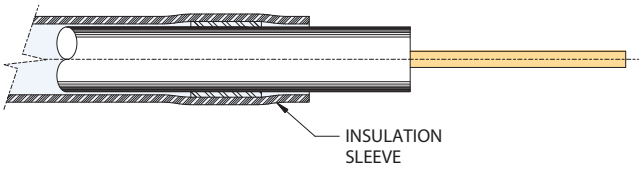
Step A

1. 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.



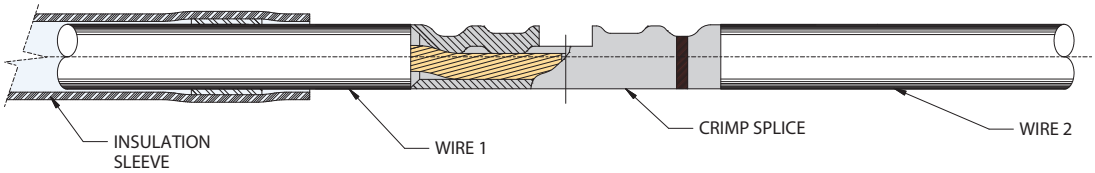
Step B

1. Slide Insulation Sleeve onto one of the wires



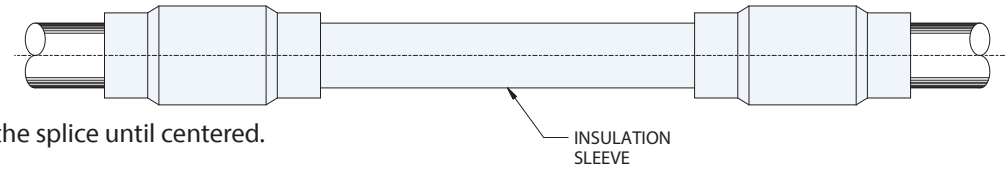
Step C

1. Insert one wire into barrel of crimp splice and crimp using crimp tool and dies listed in Table II.
2. Repeat for second wire.



Step D

1. Slide Insulation Sleeve over the splice until centered.



2. 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 Crimp Tool: M22520/10-01 Crimp Dies: M22520/10-103, -104 OR Crimp Tool: M22520/37-01 Crimp Dies: None
070-00102 070-003-2 070-004-2	16, 18, 20	.28	
070-00103 070-003-3 070-004-3	12, 14, 16	.28	

ENVIRONMENTAL

Full-Nelson Heat-Shrink Boots, Adapters, and Molded Shapes

Abrasion protection · environmental sealing · splicing · strain relief

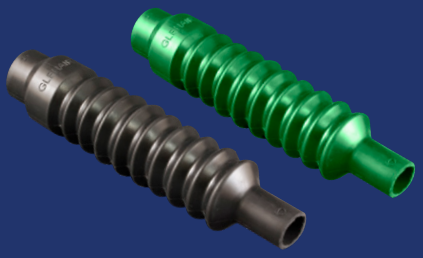
COMPLETE RANGE OF ENVIRONMENTAL HEAT-SHRINK BOOTS AND MOLDED SHAPES

Standard lipped or lipless boots

Long tail and high-ratio configurations

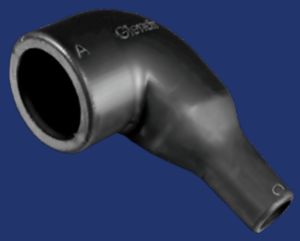
90° and 45° angle boots

SuperFly, Mighty Mouse, and D-subminiature configurations



Convoluted accordion boots

Y, T, and multibranch transitions



Space-grade shrink boots: low-outgassing fluoropolymer alloy material

SELECTED ENVIRONMENTAL SHRINK BOOT COLOR OPTIONS

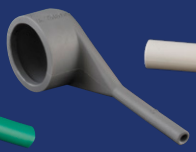
Olive drab 45° boot

Desert Tan widebody Y transition

Right-angle adapter, purple

4–1 widebody transition, yellow

Long-tail boot, green



High-ratio right-angle adapter, grey

Low-profile 3–1 adapter, white

SHRINK BOOT ADAPTERS SELECTION GUIDE

Series 310 shrink boot adapters

Series 311 EMI/RFI lamp-base thread/boot adapters

Series 319 shield sock/boot adapters

Series 440 band/boot adapters

SAE-AS85049 QPL shrink boot adapters

Composite thermoplastic band/boot adapters

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