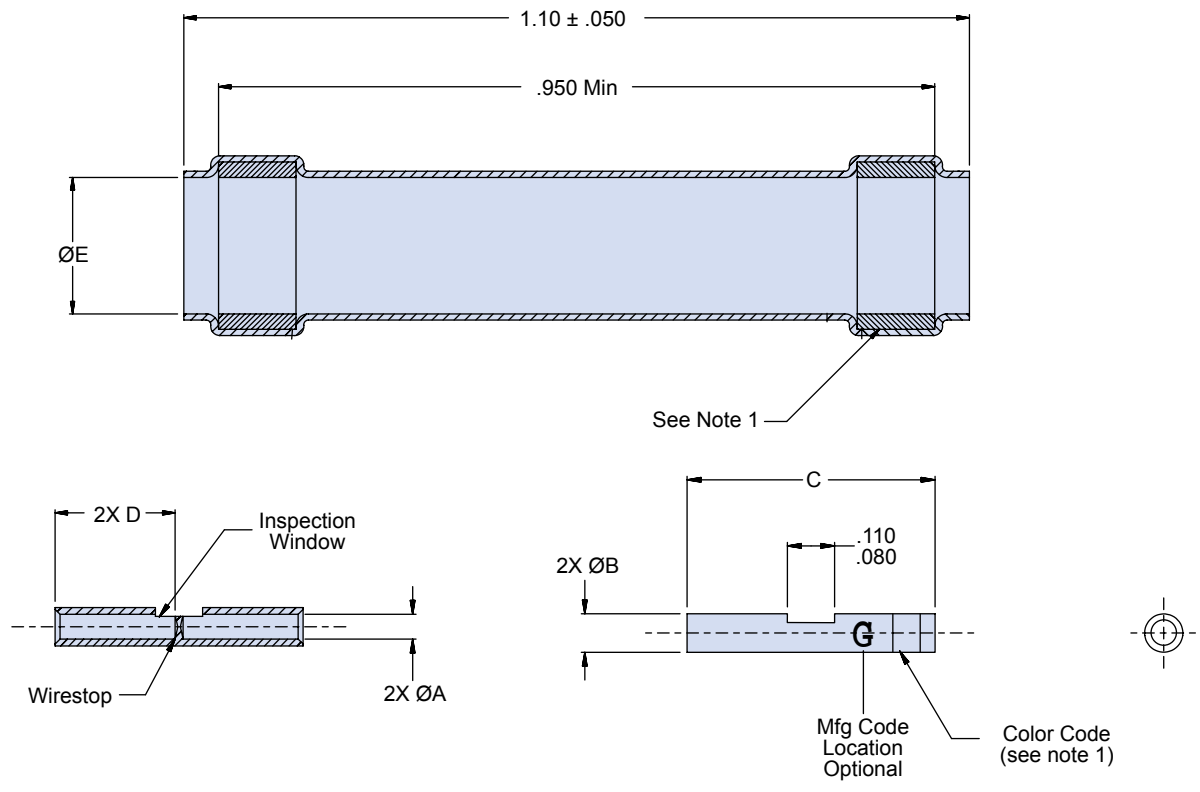
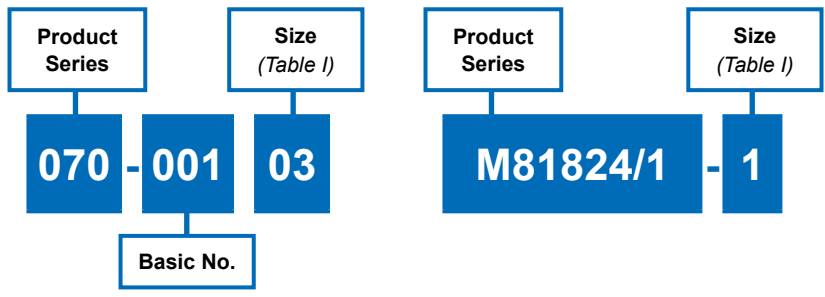


**M81824/1 • 070-001**  
**Mil-Qualified Splice**  
**In-Line, Insulated, Environmental**

MIL-QUALIFIED IN-LINE SPLICE

How To Order



**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.

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



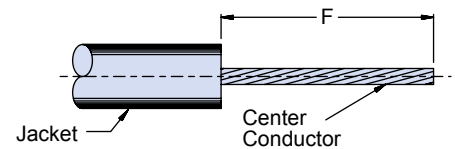
AS8319/1 and/2  
Type IIIA Splices

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**

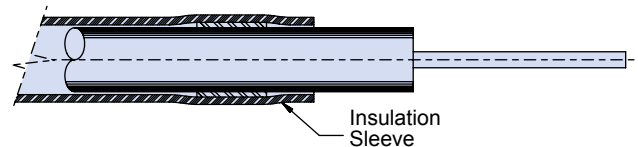
**Step A**

- 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.



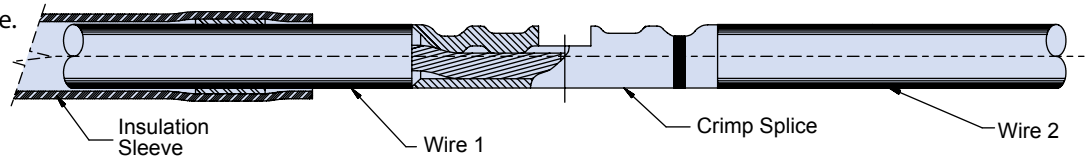
**Step B**

- 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.

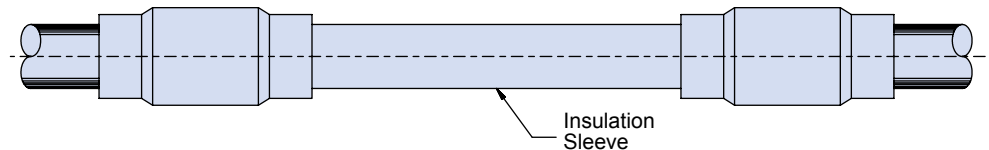


Table II			
Part No.	Wire Range	F	Crimp Tool Data
070-00101	20, 22, 24, 26	.24	Crimp Tool: M22520/5-01 Crimp Dies: M22520/5-102, -103 OR
070-00102	16, 18, 20	.28	Crimp Tool: M22520/10-01 Crimp Dies: M22520/10-103, -104 OR
070-00103	12, 14, 16	.28	Crimp Tool: M22520/37-01 Crimp Dies: None

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