

## Sealed Crimp Termination Sleeves For Single And Multiple Lead, Environmentally Sealed Crimp Splices

- Continuous operation from -55°C to +175°C
- Sealed Crimp Splices protect the splice against galvanic action, corrosion, time degradation and environmental exposure.
- Splices consist of a seamless, annealed, tin plated, copper tubing barrel and a heat-shrinkable polyvinylidene fluoride sleeve which has thermoplastic sealing inserts.
- After crimping the barrel on the splice, the sleeve is slipped over the barrel and heat is applied. The sleeve shrinks and the thermoplastic inserts melt to form a tight-fitting, environmentally sealed crimp connection.
- Sealed Crimp Splice Termination Sleeves meet or exceed the requirements of MIL-S-81824/1.



Raychem	Sumitomo	Color Code	1:1 Splice Gauge Size
D436-36	H-CR-436-36	Red	20-26
D436-37	H-CR-436-37	Blue	16-22
D436-38	H-CR-436-38	Yellow	12-18

### Crimp Tool

P/N GMT232



P/N 3137CT Sargent Crimp Tool



## Environment Resistant Without Ground Leads MIL-S-83519/1

For Silver or Tin Plated Shield Termination Applications on Wire with Insulation Material Rated at 125°C and Above.

For continuous operation from -55°C to +150°C. These Termination Sleeves consist of a heat-shrinkable, transparent, polyvinylidene fluoride sleeve with an inner, pre-fluxed solder performing and two thermoplastic sealing inserts. In addition, these sleeves incorporate a thermal-indicator to assist in termination technique.

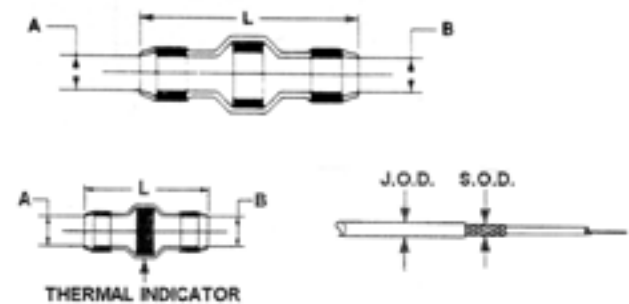


All MIL-Spec termination sleeves have a permanent identification number marked on the part. When heat is applied, the solder melts and flows to provide a superior connection between the ground lead and the shield. At the same time, the two thermoplastic sealing inserts melt and the outer sleeve shrinks to provide an environmentally protected termination.

### Selection and Ordering Data

P/N	As Supplied			Combined Diameters	
	A	B	L	Jacket O.D. Maximum	Shield O.D. Minimum
M83519/1-1	.105	.075	.650	.105	.050
M83519/1-2	.145	.105	.650	.145	.070
M83519/1-3	.200	.170	.650	.200	.100
M83519/1-4	.255	.235	.750	.255	.125
M83519/1-5	.300	.275	.750	.300	.160

Termination Sleeves meet or exceed the requirements of MIL-S-83519. The Solder Preform is Sn63, conforming to QQ-S-571. Flux is SRMAP.



## Environment Resistant With Pre-installed Ground Leads MIL-S-83519/2

For Silver or Tin Plated Shield Termination Applications on Wire with Insulation Material Rated at 125°C and Above.

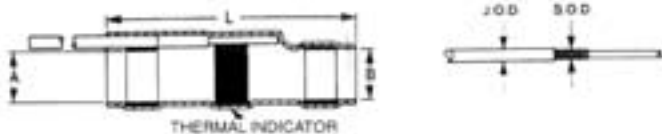
For continuous operation from -55°C to +150°C. These Termination Sleeves consist of a heat-shrinkable, transparent, polyvinylidene fluoride sleeve with an inner, pre-fluxed solder preform, two thermoplastic sealing inserts and a pre-installed ground lead, providing for quick, easy installation. In addition, these sleeves incorporate a thermal indicator to assist in termination technique. All MIL-Spec termination sleeves have a permanent identification number marked on the part. When heat is applied, the solder melts and flows to provide a superior connection between the ground lead and the shield. At the same time, the two thermoplastic sealing inserts melt and the outer sleeve shrinks to provide an environmentally protected termination.



### Selection and Ordering Data

P/N	As Supplied			Combined Diameters		
	A	B	L	Jacket O.D. Maximum	Shield O.D. Minimum	Ground Lead Gauge
M83519/2-1	.075	.105	.650	.105	.035	20
M83519/2-2	.105	.145	.650	.145	.055	20
M83519/2-3	.170	.200	.650	.200	.085	20
M83519/2-4	.235	.255	.750	.255	.130	20
M83519/2-5	.275	.300	.750	.300	.170	20
M83519/2-6	.075	.105	.650	.105	.035	22
M83519/2-7	.105	.145	.650	.145	.055	22
M83519/2-8	.170	.200	.650	.200	.085	22
M83519/2-9	.235	.255	.750	.255	.130	22
M83519/2-10	.275	.300	.750	.300	.170	22
M83519/2-11	.075	.105	.650	.105	.035	24
M83519/2-12	.105	.145	.650	.145	.055	24
M83519/2-13	.170	.200	.650	.200	.085	24
M83519/2-14	.235	.255	.750	.255	.130	24
M83519/2-15	.275	.300	.750	.300	.170	24
M83519/2-16	.075	.105	.650	.105	.035	26
M83519/2-17	.105	.145	.650	.145	.055	26
M83519/2-18	.170	.200	.650	.200	.085	26
M83519/2-19	.235	.255	.750	.255	.130	26
M83519/2-20	.275	.300	.750	.300	.170	26

Termination Sleeves meet or exceed the requirements of MIL-S-83519. The Solder Preform is Sn63, conforming to QQ-S-571. Flux is SRMAP.



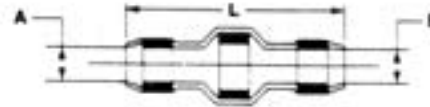
Install Supplies

Termination Sleeves

## NAS SERIES 1745 Without Ground Wire

For Silver, Tin or Nickel Plated Shield Termination Applications on Wire with Insulation Material Rated at 105°C and Above

For continuous operation from -55°C to +150°C. These Termination Sleeves consist of a heat-shrinkable, polyvinylidene fluoride sleeve with an inner, prefluxed solder perform and two thermoplastic sealing inserts.



When heat is applied, the solder perform melts and flows to form a superior electrical connection between the ground lead and the shield. At the same time, the two thermoplastic sealing inserts melt and the outer sleeve shrinks to provide an environmentally protected termination.

Sumitomo	Raychem	NAS P/N	As Supplied			Shield Type	Sleeve Color	Insert Color(s)	Solder* Type	Flux* Type
			A	B	L					
L-C-1	D142-83	NAS1745-13	0.075	0.095	0.625	Sn/Ag	Clear	1 Clear/1 Blue	2	3
L-C-2	D142-50	NAS1745-14	0.110	0.125	0.625	Sn/Ag	Clear	1 Clear/1 Blue	2	3
L-C-3	D142-51	NAS1745-15	0.180	0.200	0.625	Sn/Ag	Clear	1 Clear/1 Blue	2	3
L-C-4	D142-56	NAS1745-23	0.235	0.255	0.750	Sn/Ag	Clear	2 Blue	2	3
L-C-5	D142-52	NAS1745-16	0.280	0.300	0.750	Sn/Ag	Clear	1 Clear/1 Blue	2	3
L-C-6	D142-65	NAS1745-24	0.440	0.480	1.100	Sn/Ag	Clear	1 Clear/1 Blue	2	3

\*Solder Type: (1) SN63 (2) 18.2% Cd, 51.2% SN, 30.6% Pb  
Flux Type: (1) SRMAP (2) SRAP (3) RMA

## M83519 Shield Termination, Solder Style, Insulated Heat-Shrinkable, Environment Resistant

### Part Number Cross Reference

Government Designation	Pre-Installed Lead Wire	Applied Max Cable Dia (in)	Manufacturer's Designation		
			Sumitomo	Raychem	3M/ECC
M83519/1-1	None	0.075	H-M-1 S0101S	S0101R	S0101E
M83519/1-2	None	0.105	H-M-2 S0102S	S0102R	S0102E
M83519/1-3	None	0.170	H-M-3 S0103S	S0103R	S0103E
M83519/1-4	None	0.235	H-M-4 S0104S	S0104R	S0104E
M83519/1-5	None	0.275	H-M-5 S0105S	S0105R	S0105E
M83519/2-1	M22759/32-20	0.075	H-ML-1 S0201S	S0201R	S0201E
M83519/2-2	(AWG20)	0.105	H-ML-2 S0202S	S0202R	S0202E
M83519/2-3	"	0.170	H-ML-3 S0203S	S0203R	S0203E
M83519/2-4	"	0.235	H-ML-4 S0204S	S0204R	S0204E
M83519/2-5	"	0.275	H-ML-5 S0205S	S0205R	S0205E
M83519/2-6	M22759/32-22	0.075	H-ML-6 S0206S	S0206R	S0206E
M83519/2-7	(AWG22)	0.105	H-ML-7 S0207S	S0207R	S0207E
M83519/2-8	"	0.170	H-ML-8 S0208S	S0208R	S0208E
M83519/2-9	"	0.235	H-ML-9 S0209S	S0209R	S0209E
M83519/2-10	"	0.275	H-ML-10 S0210S	S0210R	S0210E
M83519/2-11	M22759/32-24	0.075	H-ML-11 S0211S	S0211R	S0211E
M83519/2-12	(AWG24)	0.105	H-ML-12 S0212S	S0212R	S0212E
M83519/2-13	"	0.170	H-ML-13 S0213S	S0213R	S0213E
M83519/2-14	"	0.235	H-ML-14 S0214S	S0214R	S0214E
M83519/2-15	"	0.275	H-ML-15 S0215S	S0215R	S0215E
M83519/2-16	M22759/32-26	0.075	H-ML-16 S0216S	S0216R	S0216E
M83519/2-17	9AWG260	0.105	H-ML-17 S0217S	S0217R	S0217E
M83519/2-18	"	0.170	H-ML-18 S0218S	S0218R	S0218E
M83519/2-19	"	0.235	H-ML-19 S0219S	S0219R	S0219E
M83519/2-20	"	0.275	H-ML-20 S0220S	S0220R	S0220E

