



Glencair®

AS83519/1 AND /2 TYPE

HEAT SHRINK TERMINATION (HST) SLEEVES

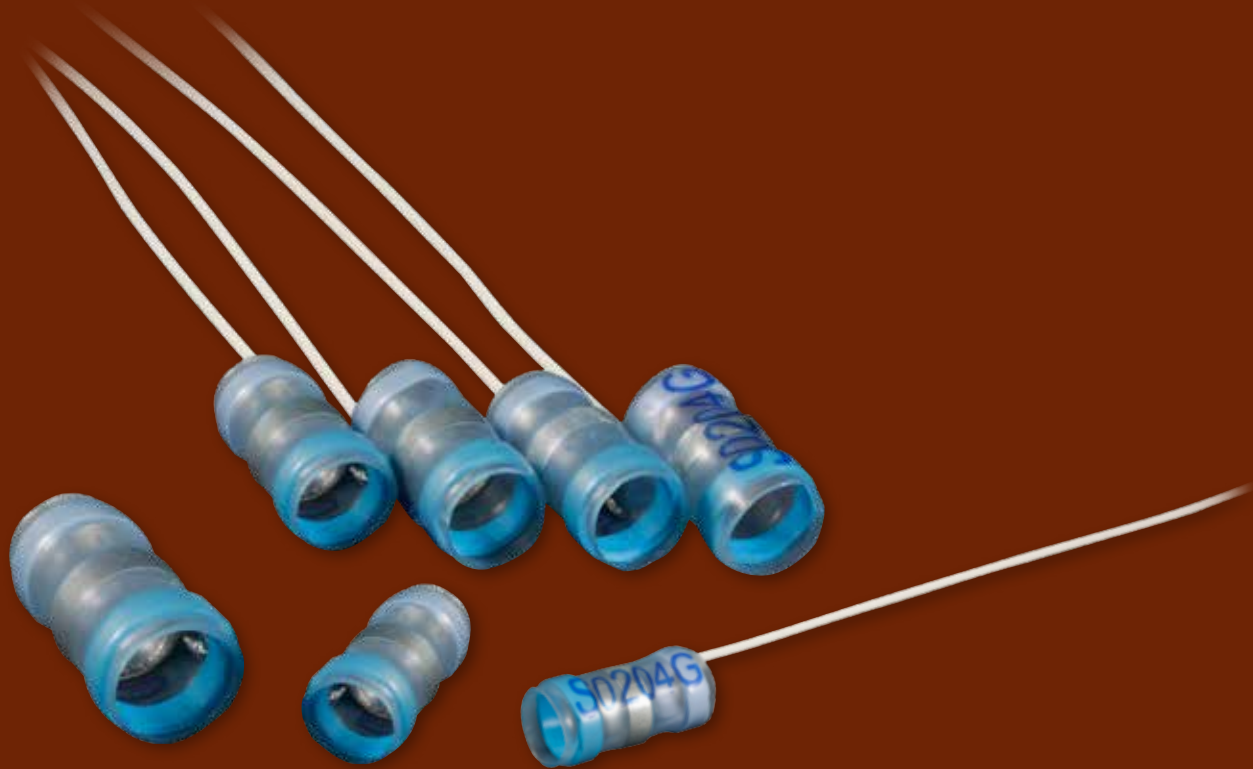
FOR EMI SHIELD TO GROUND TERMINATION

JANUARY 2013

AS83519/1 AND /2 TYPE

HEAT SHRINK TERMINATION (HST) SLEEVES

5 SIZES WITH AND WITHOUT WIRE LEADS



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. 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. Best of all, these HST devices are made in the USA and stocked for immediate same-day shipment.



**AS83519/1 and /2 Type
Heat Shrink Termination (HST) Sleeves
Table of Contents and Product Selection Guide**



AS83519/1 and /2
Type HST Sleeves

HEAT SHRINK TERMINATION SLEEVES PRODUCT SELECTION GUIDE

**077-010
AS83519/1 Type HST Sleeve
No Lead Wire**



**077-020
AS83519/2 Type HST Sleeve
Pre-Installed Lead Wire**



**GS83519/1
AS83519/1 Type HST Sleeve
No Lead Wire**

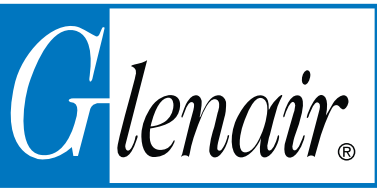


**GS83519/2
AS83519/2 Type HST Sleeve
Pre-Installed Lead Wire**

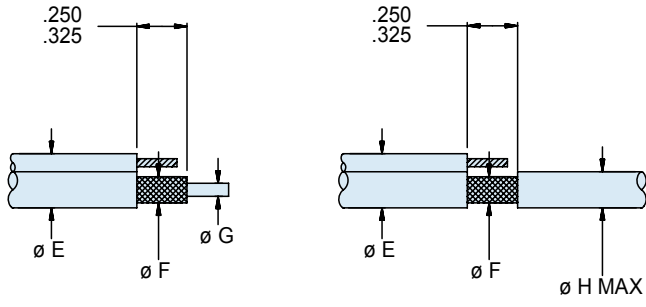
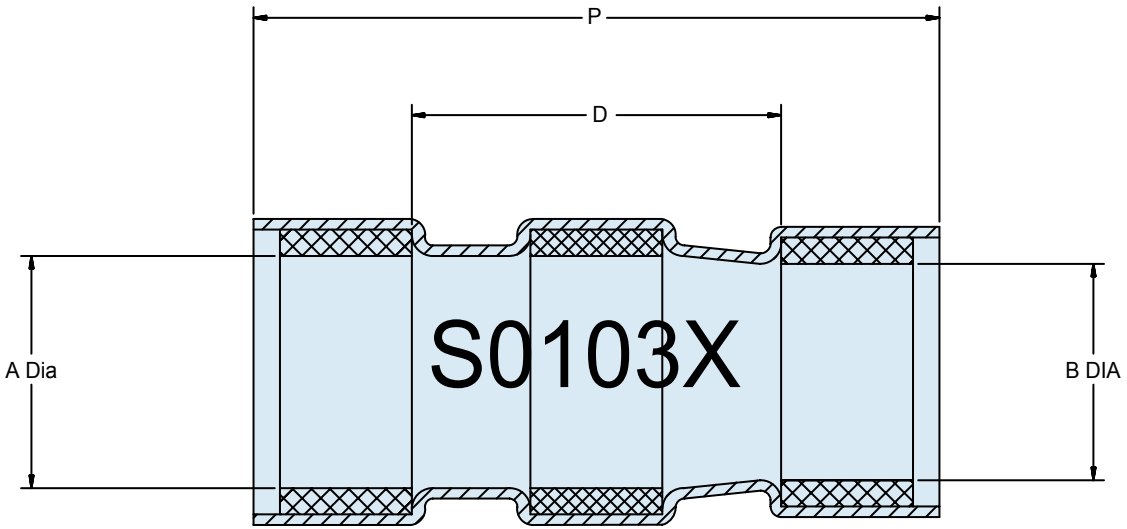
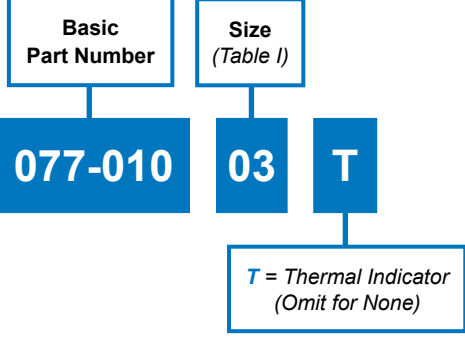


**M81824/1-1
Mil-Qualified Splice
In-Line, Insulated, Environmental**





077-010
AS83519/1 Type Heat Shrink Termination (HST) Sleeves
No Lead Wire



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

077-010
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 special transparent cross-linked polyvinylidene fluoride tubing to deliver optimal environmental shield termination in aerospace and defense industry applications. Each HST device is equipped with a pre-fluxed solder preform and thermally stabilized thermoplastic sealing rings that encapsulated and protect the shield-to-ground termination. Glenair HST devices are tested to perform from -55°C to 125°C IAW SAE AS83519.

TABLE I: Dimensions, Marking Code and Military Reference Number

Size	A Dia Min	B Dia Min	P ± .07 (1.8)	D Min	W Ref	E Dia Max	F Dia Min	G Dia Min	H Dia Max	Military Ref No Lead Wire	Marking Code (See Note 1)
01	.105 (2.67)	.075 (1.91)	.65 (16.5)	.325 (8.26)	.095 (2.42)	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)	M83519/1-1	S0101X
02	.145 (3.68)	.105 (2.67)	.65 (16.5)	.325 (8.26)	.095 (2.42)	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)	M83519/1-2	S0102X
03	.200 (5.08)	.170 (4.32)	.65 (16.5)	.325 (8.26)	.125 (3.18)	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)	M83519/1-3	S0103X
04	.255 (6.48)	.235 (5.97)	.75 (19.0)	.325 (8.26)	.125 (3.18)	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)	M83519/1-4	S0104X
05	.300 (7.62)	.275 (7.0)	.75 (19.0)	.325 (8.26)	.125 (3.18)	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)	M83519/1-5	S0105X

Notes

- Code number option to be located on sleeve (Example: S0103X)

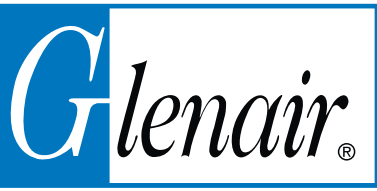
Material/Finish:

- Insulation sleeve - Heat-shrinkable, radiation crosslinked, modified polyvinylidene fluoride per MIL-I-23053/8. Color - Transparent blue.
- Meltable sealing ring - Thermally stabilized thermoplastic, color blue.
- Solder preform - Alloy Sn63 per QQ-S-571 with thermochromic indicator using ROL1 type RMA flux.

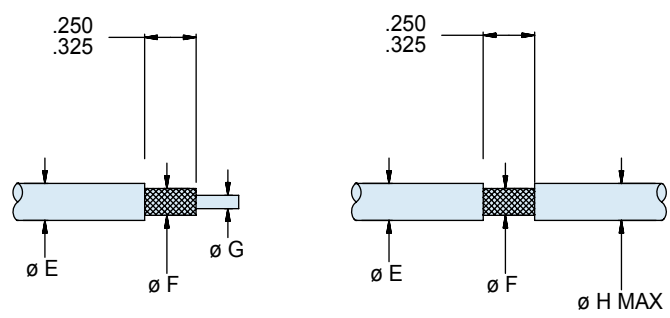
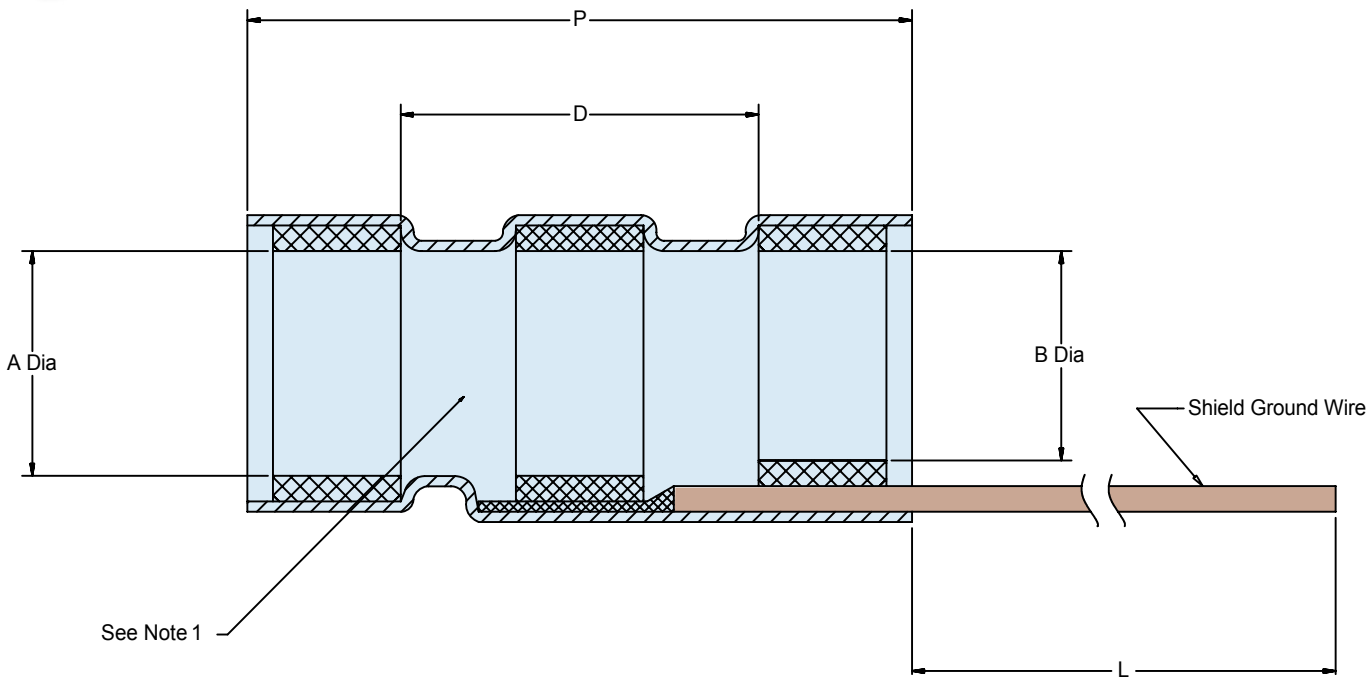
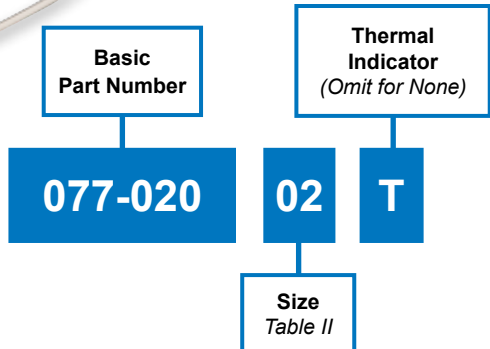
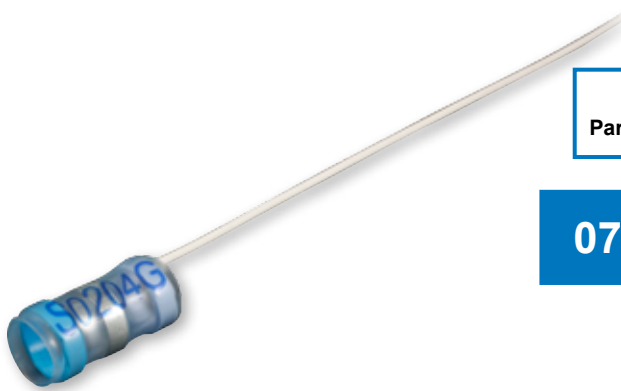
Application

- Temperature rating: -55°C to +150°C. Cable jacket rating: 125°C min.
- Shield plating: Tin or silver
- For best results prepare cable as shown

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



077-020
AS83519/2 Type Heat Shrink Termination (HST) Sleeves
Pre-Installed Lead Wire



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

077-020
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 are fabricated from special transparent cross-linked polyvinylidene fluoride tubing to deliver optimal environmental shield termination in aerospace and defense industry applications. Each HST device is equipped with a pre-fluxed solder preform and thermally stabilized thermoplastic sealing rings that encapsulated and protect the shield-to-ground termination. Glenair HST devices are tested to perform from -55°C to 125°C IAW SAE AS83519. Please contact the factory for alternative ground lead materials including lightweight AmberStrand and ArmorLite.

TABLE I: Dimensions, Marking Code and Military Reference Number

Size	A Dia Min	B Dia Min	P ± .07 (1.8)	D Min	W Ref	L Min	Lead Wire AS22759/32	Marking Code	E Dia Max	F Dia Min	G Dia Min	H Dia Max	MIL Number Ref W Lead Wire
01	.105 (2.67)	.075 (1.91)	.65 (16.5)	.325 (8.26)	.095 (2.42)	6.00 (152.4)	-20-90	S0201G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)	M83519/2-1
02	.145 (3.68)	.105 (2.67)	.65 (16.5)	.325 (8.26)	.095 (2.42)	6.00 (152.4)	-20-90	S0202G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)	M83519/2-2
03	.200 (5.08)	.170 (4.32)	.65 (16.5)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	-20-90	S0203G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)	M83519/2-3
04	.255 (6.48)	.235 (5.97)	.75 (19.0)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	-20-90	S0204G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)	M83519/2-4
05	.300 (7.62)	.275 (7.0)	.75 (19.0)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	-20-90	S0205G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)	M83519/2-5
06	.105 (2.67)	.075 (1.91)	.65 (16.5)	.325 (8.26)	.095 (2.42)	6.00 (152.4)	-22-90	S0206G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)	M83519/2-6
07	.145 (3.68)	.105 (2.67)	.65 (16.5)	.325 (8.26)	.095 (2.42)	6.00 (152.4)	-22-90	S0207G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)	M83519/2-7
08	.200 (5.08)	.170 (4.32)	.65 (16.5)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	-22-90	S0208G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)	M83519/2-8
09	.255 (6.48)	.235 (5.97)	.75 (19.0)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	-22-90	S0209G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)	M83519/2-9
10	.300 (7.62)	.275 (7.0)	.75 (19.0)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	-22-90	S02010G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)	M83519/2-10
11	.105 (2.67)	.075 (1.91)	.65 (16.5)	.325 (8.26)	.095 (2.42)	6.00 (152.4)	-24-90	S02011G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)	M83519/2-11
12	.145 (3.68)	.105 (2.67)	.65 (16.5)	.325 (8.26)	.095 (2.42)	6.00 (152.4)	-24-90	S02012G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)	M83519/2-12
13	.200 (5.08)	.170 (4.32)	.65 (16.5)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	-24-90	S02013G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)	M83519/2-13
14	.255 (6.48)	.235 (5.97)	.75 (19.0)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	-24-90	S02014G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)	M83519/2-14
15	.300 (7.62)	.275 (7.0)	.75 (19.0)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	-24-90	S02015G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)	M83519/2-15
16	.105 (2.67)	.075 (1.91)	.65 (16.5)	.325 (8.26)	.095 (2.42)	6.00 (152.4)	-26-90	S02016G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)	M83519/2-16
17	.145 (3.68)	.105 (2.67)	.65 (16.5)	.325 (8.26)	.095 (2.42)	6.00 (152.4)	-26-90	S02017G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)	M83519/2-17
18	.200 (5.08)	.170 (4.32)	.65 (16.5)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	-26-90	S02018G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)	M83519/2-18
19	.255 (6.48)	.235 (5.97)	.75 (19.0)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	-26-90	S02019G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)	M83519/2-19
20	.300 (7.62)	.275 (7.0)	.75 (19.0)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	-26-90	S02020G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)	M83519/2-20

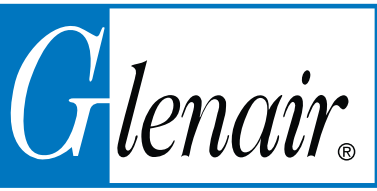
Material/Finish:

- Insulation sleeve - Heat-shrinkable, radiation crosslinked, modified polyvinylidene fluoride per MIL-I-23053/8. Color - Transparent blue.
- Meltable sealing ring - Thermally stabilized thermoplastic, color blue.
- Solder preform - Alloy Sn63 per ANSI0-J-STF-004.
- Optional thermo indicator - Color to colorless.
- -90 = Wire color is white with black stripes. Consult factory for additional colors.

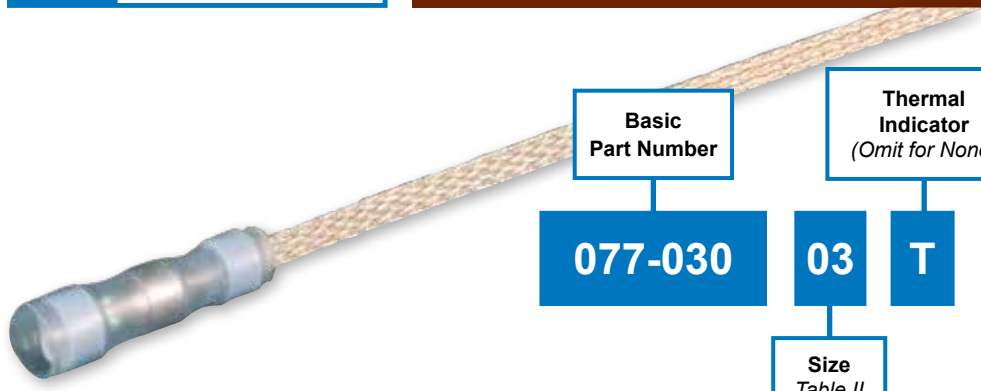
Application

- Temperature rating: -55°C to +150°C. Cable jacket rating: 125°C min.
- Shield plating: Tin or silver.
- For best results prepare cable as shown (See Page 4).

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



077-030
AS83519/2 Type Heat Shrink Termination (HST) Sleeves
Pre-Installed Braid Pre-Tinned on Both Ends



Basic
Part Number

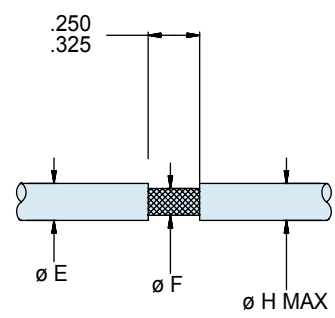
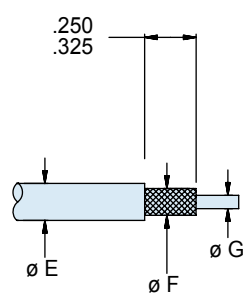
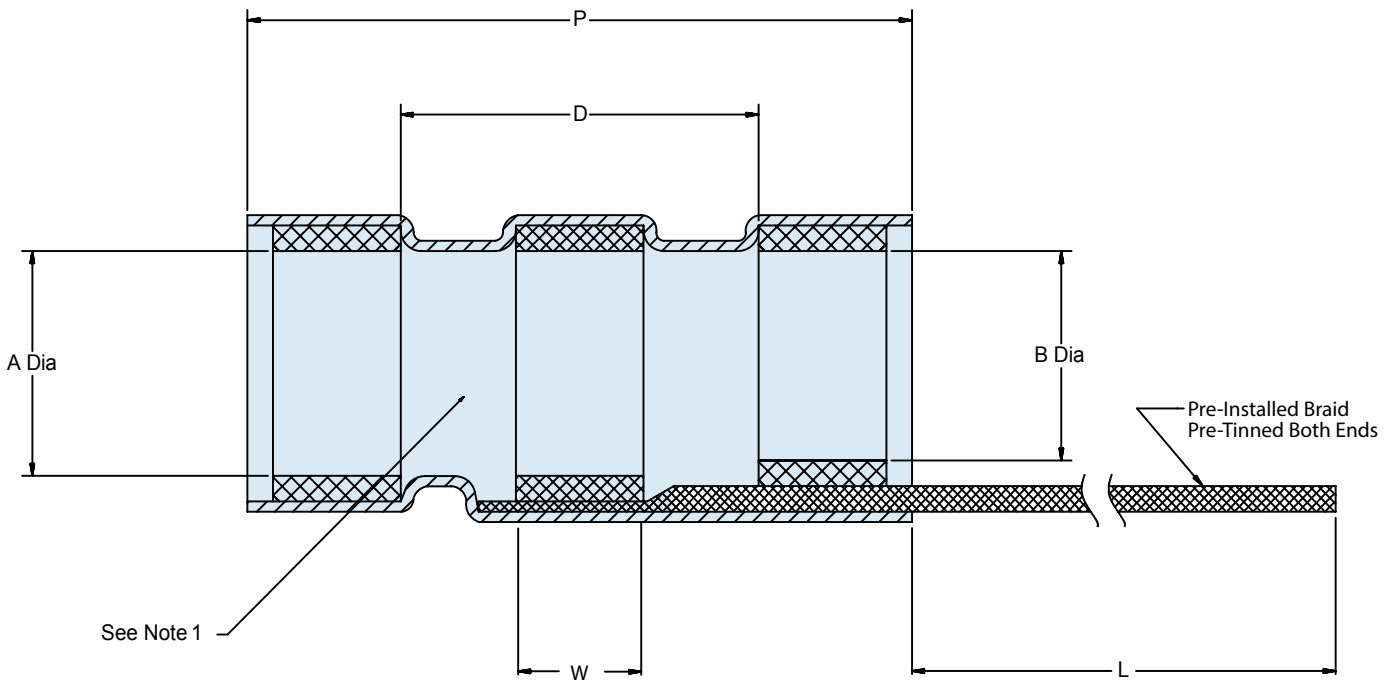
077-030

Thermal
Indicator
(Omit for None)

03

T

Size
Table II



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

077-030
AS83519/2 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 are fabricated from special transparent cross-linked polyvinylidene fluoride tubing to deliver optimal environmental shield termination in aerospace and defense industry applications. Each HST device is equipped with a pre-fluxed solder preform and thermally stabilized thermoplastic sealing rings that encapsulated and protect the shield-to-ground termination. Glenair HST devices are tested to perform from -55°C to 125°C IAW SAE AS83519. Please contact the factory for alternative ground lead materials including lightweight AmberStrand and ArmorLite.

TABLE I: Dimensions, Marking Code and Braid Information

Size	A Dia Min	B Dia Min	P ± .07 (1.8)	D Min	W Ref	L Min	Tin Copper Braid 36 AWG Ref 101-004	Marking Code	E Dia Max	F Dia Min	G Dia Min	H Dia Max
01	.105 (2.67)	.075 (1.91)	.65 (16.5)	.325 (8.26)	.095 (2.42)	6.00 (152.4)	101-004-062-36	S0301G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)
02	.145 (3.68)	.105 (2.67)	.65 (16.5)	.325 (8.26)	.095 (2.42)	6.00 (152.4)	101-004-062-36	S0302G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)
03	.200 (5.08)	.170 (4.32)	.65 (16.5)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	101-004-062-36	S0303G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)
04	.255 (6.48)	.235 (5.97)	.75 (19.0)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	101-004-062-36	S0304G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)
05	.300 (7.62)	.275 (7.0)	.75 (19.0)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	101-004-062-36	S0305G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)
06	.105 (2.67)	.075 (1.91)	.65 (16.5)	.325 (8.26)	.095 (2.42)	6.00 (152.4)	101-004-031-36	S0306G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)
07	.145 (3.68)	.105 (2.67)	.65 (16.5)	.325 (8.26)	.095 (2.42)	6.00 (152.4)	101-004-031-36	S0307G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)
08	.200 (5.08)	.170 (4.32)	.65 (16.5)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	101-004-031-36	S0308G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)
09	.255 (6.48)	.235 (5.97)	.75 (19.0)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	101-004-031-36	S0309G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)
10	.300 (7.62)	.275 (7.0)	.75 (19.0)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	101-004-031-36	S0310G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)

TABLE II: Dimensions, Marking Code and Braid Information

Size	A Dia Min	B Dia Min	P ± .07 (1.8)	D Min	W Ref	L Min	Tin Copper Braid 36 AWG Ref 101-004	Marking Code	E Dia Max	F Dia Min	G Dia Min	H Dia Max
11	.105 (2.67)	.075 (1.91)	.65 (16.5)	.325 (8.26)	.095 (2.42)	6.00 (152.4)	101-004-062-36N	S0311G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)
12	.145 (3.68)	.105 (2.67)	.65 (16.5)	.325 (8.26)	.095 (2.42)	6.00 (152.4)	101-004-062-36N	S0312G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)
13	.200 (5.08)	.170 (4.32)	.65 (16.5)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	101-004-062-36N	S0313G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)
14	.255 (6.48)	.235 (5.97)	.75 (19.0)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	101-004-062-36N	S0314G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)
15	.300 (7.62)	.275 (7.0)	.75 (19.0)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	101-004-062-36N	S0315G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)
16	.105 (2.67)	.075 (1.91)	.65 (16.5)	.325 (8.26)	.095 (2.42)	6.00 (152.4)	101-004-031-36N	S0316G	.105 (2.65)	.035 (0.90)	.020 (0.50)	.075 (1.90)
17	.145 (3.68)	.105 (2.67)	.65 (16.5)	.325 (8.26)	.095 (2.42)	6.00 (152.4)	101-004-031-36N	S0317G	.145 (3.68)	.055 (1.40)	.030 (0.72)	.105 (2.65)
18	.200 (5.08)	.170 (4.32)	.65 (16.5)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	101-004-031-36N	S0318G	.200 (5.08)	.085 (2.15)	.050 (1.25)	.170 (4.30)
19	.255 (6.48)	.235 (5.97)	.75 (19.0)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	101-004-031-36N	S0319G	.255 (6.45)	.130 (3.30)	.070 (1.80)	.235 (5.95)
20	.300 (7.62)	.275 (7.0)	.75 (19.0)	.325 (8.26)	.125 (3.18)	6.00 (152.4)	101-004-031-36N	S0320G	.300 (7.60)	.170 (4.30)	.100 (2.50)	.275 (7.00)

Material/Finish:

- Insulation sleeve - Heat-shrinkable, radiation crosslinked, modified polyvinylidene fluoride per MIL-I-23053/8. Color - Transparent blue.
- Melttable sealing ring - Thermally stabilized thermoplastic, color blue.
- Solder preform - Alloy Sn63 per ANSI-J-STD-004.
- Flux - ROM1 per ANSI-J-STD-004 (to be used on nickel plated shields only).
- Optional thermo indicator - Color to colorless.
- -90 = Wire color is white with black stripes. Consult factory for additional colors.

Application:

- Temperature rating, Table I -55°C to +150°C, Cable jacket rating - 125° Min.
- Temperature rating, Table II -55°C to +175°C, Cable jacket rating - 150° Min.
- Shield plating, Table I - Tin or silver.
- Shield plating, Table II - Nickel.
- For best results prepare cable as shown (See Page 6).
- Braid Length - 6 inches, standard. Lengths in 8, 12, 18 and 24-inches available.

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

GS83519/1
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 special transparent cross-linked polyvinylidene fluoride tubing to deliver optimal environmental shield termination in aerospace and defense industry applications. Each HST device is equipped with a pre-fluxed solder preform and thermally stabilized thermoplastic sealing rings that encapsulated and protect the shield-to-ground termination. Glenair HST devices are tested to perform from -55°C to 125°C IAW SAE AS83519.

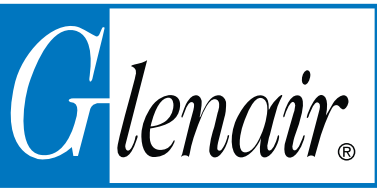
TABLE I: Dimensions, Marking Code and Military Reference Number

Size	A Dia Min	B Dia Min	P ± .07 (1.8)	D Min	Military Ref No Lead Wire	Marking Code (See Note 1)
01	.105 (2.67)	.075 (1.91)	.65 (16.5)	.325 (8.26)	M83519/1-1	S0101X
02	.145 (3.68)	.105 (2.67)	.65 (16.5)	.325 (8.26)	M83519/1-2	S0102X
03	.200 (5.08)	.170 (4.32)	.65 (16.5)	.325 (8.26)	M83519/1-3	S0103X
04	.255 (6.48)	.235 (5.97)	.75 (19.0)	.325 (8.26)	M83519/1-4	S0104X
05	.300 (7.62)	.275 (7.0)	.75 (19.0)	.325 (8.26)	M83519/1-5	S0105X

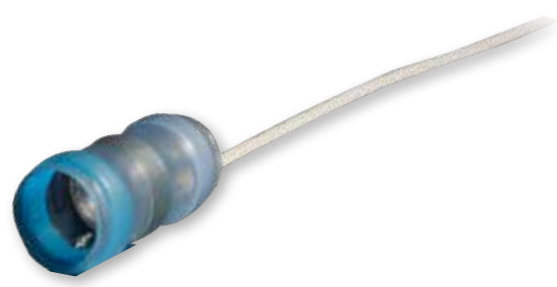
Material/Finish:

- Insulation sleeve - Heat-shrinkable, radiation crosslinked, modified polyvinylidene fluoride per MIL-I-23053/8. Color - Transparent blue.
- Meltable sealing ring - Thermally stabilized thermoplastic, color blue.
- Solder preform - Alloy Sn63 per QQ-S-571 with thermochromic indicator using ROL1 type RMA flux.

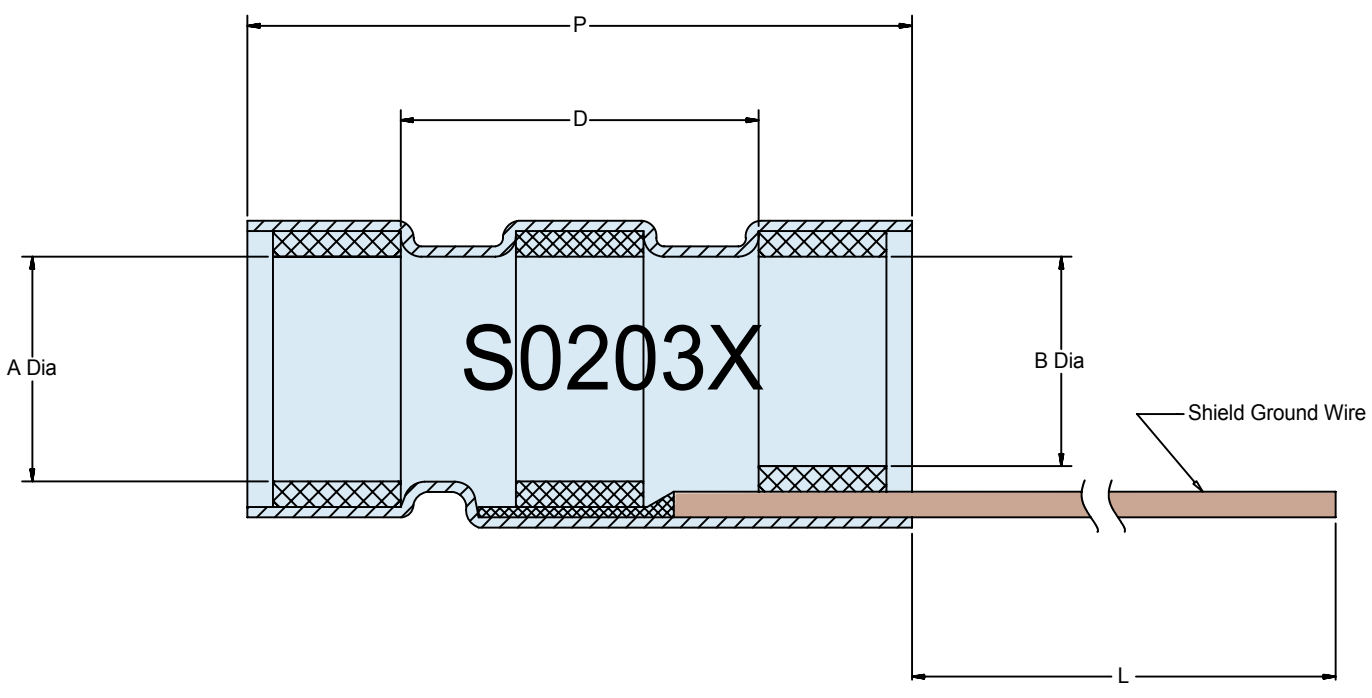
Dimensions in Inches (millimeters) are subject to change without notice.



GS83519/2 AS83519/1 Type Heat Shrink Termination (HST) Sleeves Pre-Installed Lead Wire



Product Series	Size (Table I)
GS83519/2	- 03



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

GS83519/2
AS83519/1 Type Heat Shrink Termination (HST) Sleeves
Pre-Installed Lead Wire



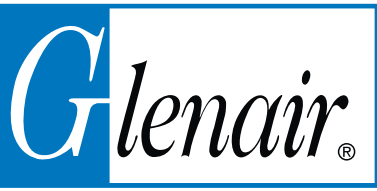
TABLE I: Dimensions, Military Reference Number, Lead Wire and Marking Code

Size	A Dia Min	B Dia Min	P ± .07 (1.8)	D Min	L Min	Military Ref with Lead Wire	Lead Wire	Marking Code (See Note 1)
01	.105 (2.67)	.075 (1.91)	.65 (16.5)	.325 (8.26)	6.00 (152.4)	M83519/2-1	AS22759/32-20-90	S0201X
02	.145 (3.68)	.105 (2.67)	.65 (16.5)	.325 (8.26)	6.00 (152.4)	M83519/2-2	AS22759/32-20-90	S0202X
03	.200 (5.08)	.170 (4.32)	.65 (16.5)	.325 (8.26)	6.00 (152.4)	M83519/2-3	AS22759/32-20-90	S0203X
04	.255 (6.48)	.235 (5.97)	.75 (19.0)	.325 (8.26)	6.00 (152.4)	M83519/2-4	AS22759/32-20-90	S0204X
05	.300 (7.62)	.275 (7.0)	.75 (19.0)	.325 (8.26)	6.00 (152.4)	M83519/2-5	AS22759/32-20-90	S0205X
6	.105 (2.67)	.075 (1.91)	.65 (16.5)	.325 (8.26)	6.00 (152.4)	M83519/2-6	AS22759/32-22-90	S0206X
7	.145 (3.68)	.105 (2.67)	.65 (16.5)	.325 (8.26)	6.00 (152.4)	M83519/2-7	AS22759/32-22-90	S0207X
8	.200 (5.08)	.170 (4.32)	.65 (16.5)	.325 (8.26)	6.00 (152.4)	M83519/2-8	AS22759/32-22-90	S0208X
9	.255 (6.48)	.235 (5.97)	.75 (19.0)	.325 (8.26)	6.00 (152.4)	M83519/2-9	AS22759/32-22-90	S0209X
10	.300 (7.62)	.275 (7.0)	.75 (19.0)	.325 (8.26)	6.00 (152.4)	M83519/2-10	AS22759/32-22-90	S02010X
11	.105 (2.67)	.075 (1.91)	.65 (16.5)	.325 (8.26)	6.00 (152.4)	M83519/2-11	AS22759/32-24-90	S02011X
12	.145 (3.68)	.105 (2.67)	.65 (16.5)	.325 (8.26)	6.00 (152.4)	M83519/2-12	AS22759/32-24-90	S02012X
13	.200 (5.08)	.170 (4.32)	.65 (16.5)	.325 (8.26)	6.00 (152.4)	M83519/2-13	AS22759/32-24-90	S02013X
14	.255 (6.48)	.235 (5.97)	.75 (19.0)	.325 (8.26)	6.00 (152.4)	M83519/2-14	AS22759/32-24-90	S02014X
15	.300 (7.62)	.275 (7.0)	.75 (19.0)	.325 (8.26)	6.00 (152.4)	M83519/2-15	AS22759/32-24-90	S02015X
16	.105 (2.67)	.075 (1.91)	.65 (16.5)	.325 (8.26)	6.00 (152.4)	M83519/2-16	AS22759/32-26-90	S02016X
17	.145 (3.68)	.105 (2.67)	.65 (16.5)	.325 (8.26)	6.00 (152.4)	M83519/2-17	AS22759/32-26-90	S02017X
18	.200 (5.08)	.170 (4.32)	.65 (16.5)	.325 (8.26)	6.00 (152.4)	M83519/2-18	AS22759/32-26-90	S02018X
19	.255 (6.48)	.235 (5.97)	.75 (19.0)	.325 (8.26)	6.00 (152.4)	M83519/2-19	AS22759/32-26-90	S02019X
20	.300 (7.62)	.275 (7.0)	.75 (19.0)	.325 (8.26)	6.00 (152.4)	M83519/2-20	AS22759/32-26-90	S02020X

Material/Finish:

- Insulation sleeve - Heat-shrinkable, radiation crosslinked, modified polyvinylidene fluoride per MIL-I-23053/8. Color - Transparent blue.
- Melttable sealing ring - Thermally stabilized thermoplastic, color blue.
- Solder preform - Alloy Sn63 per QQ-S-571 with thermal indicator using ROL1 type RMA flux.

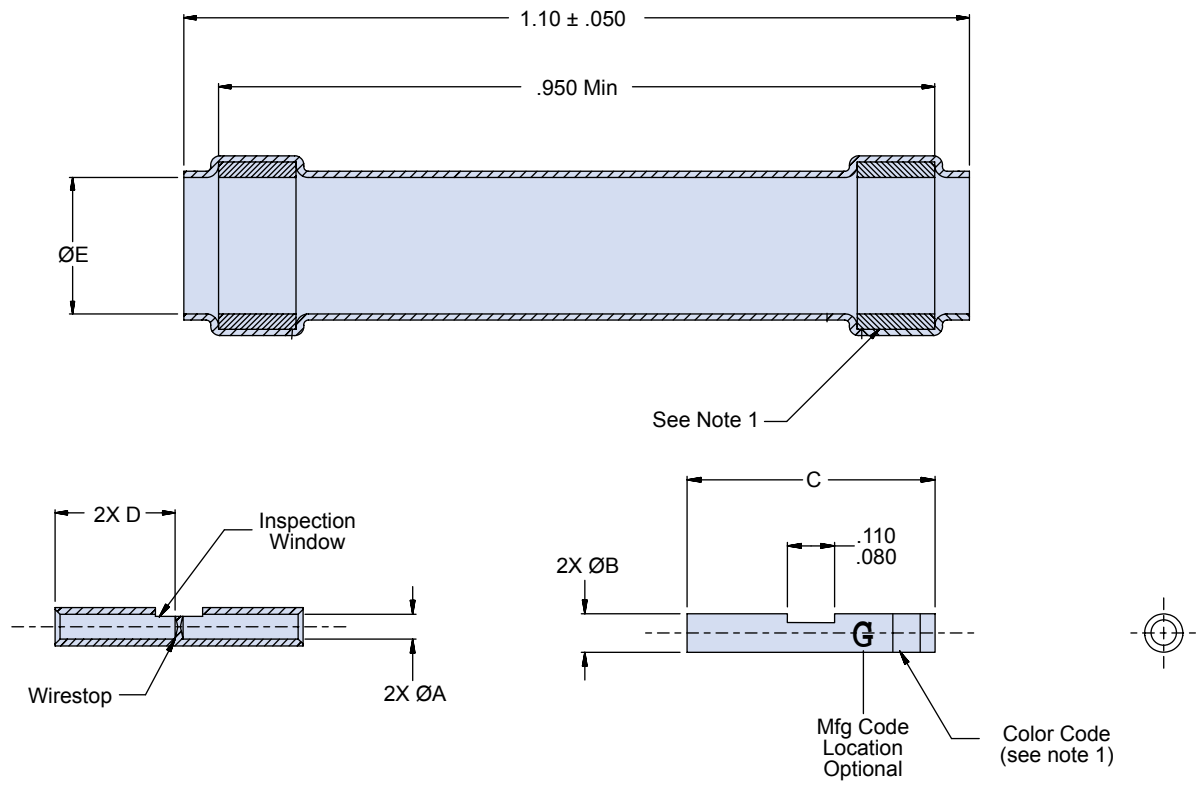
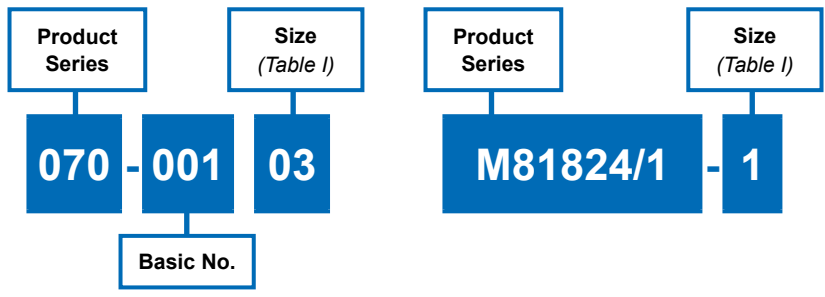
Dimensions in Inches (millimeters) are subject to change without notice.



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



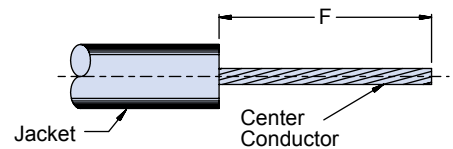
AS8319/1 and/2
Type IIIA Splices

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

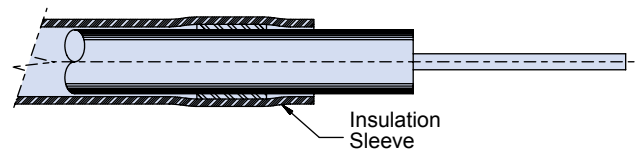
Step A

- 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.



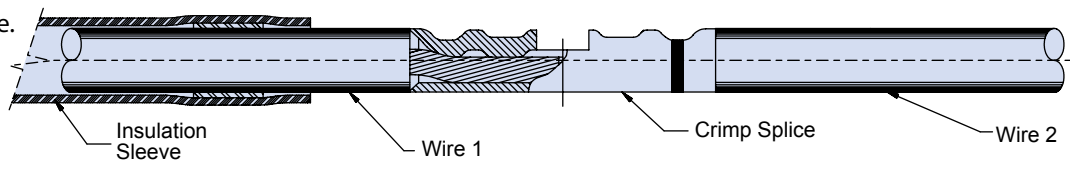
Step B

- Slide Insulation Sleeve onto one of the wires



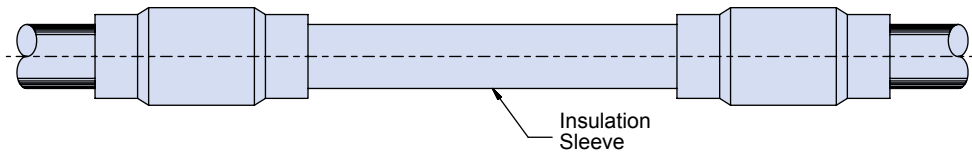
Step C

- 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.



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.



Out of This World
**INTERCONNECT
SOLUTIONS**

Glenair, Inc.

1211 Air Way • Glendale, California • 91201-2497
Telephone: 818-247-6000 • Fax: 818-500-9912 • sales@glenair.com
www.glenair.com

**Glenair Power
Products Group**

860 N. Main Street Extension
Wallingford, CT
06492

Telephone:
203-741-1115
Facsimile:
203-741-0053
sales@glenair.com

Glenair UK Ltd

40 Lower Oakham Way
Oakham Business Park
P.O. Box 37, Mansfield
Notts, NG18 5BY England

Telephone:
+44-1623-638100
Facsimile:
+44-1623-638111
sales@glenair.co.uk

Glenair Microway Systems

7000 North Lawndale Avenue
Lincolnwood, IL
60712

Telephone:
847-679-8833
Facsimile:
847-679-8849

Glenair Nordic AB

Gustav III : S Boulevard 46
S - 169 27 Solna
Sweden

Telephone:
+46-8-50550000
Facsimile:
+46-8-50550001
sales@glenair.se

Glenair Electric GmbH

Schaberweg 28
D. 61348 Bad Homburg
Germany

Telephone:
06172 / 68 16 0
Facsimile:
06172 / 68 16 90
germany@glenair.com

Glenair Iberica

C/ La Vega, 16
45612 Velada
Spain

Telephone:
+34-925-89-29-88
Facsimile:
+34-925-89-29-87
sales@glenair.es

Glenair Italia S.p.A.

Via Del Lavoro, 7
40057 Quarto Inferiore –
Granarolo dell'Emilia
Bologna, Italy

Telephone:
+39-051-782811
Facsimile:
+39-051-782259
info@glenair.it

Glenair France SARL

7, Avenue Parmentier
Immeuble Central Parc #2
31200 Toulouse
France

Telephone:
+33-5-34-40-97-40
Facsimile:
+33-5-61-47-86-10
sales@glenair.fr

