



# Installation Procedure for Duraseal Splices and Terminals

RPIP-684-00  
Revision J  
20-March-26

## Devices Installation Procedure

### 1. Products:

#### DuraSeal Splice:

DS-XX-XX	D-406-XXXX
DS-MIXT-XX	

#### DuraSeal Terminal:

DB-X-XX	DP-X-XX	B-106-XXXX
DF-X-XX	DR-X-XX	DS-MIXT-XX

### 2. Application Equipment:

- Crimping tool: AD-1522

- Hot air gun:

Heat Gun	Reflector	Setting
HL1910E	PR-25 or PR-25D and HL1802E- ADAPT	6 on dial <sup>(1)</sup>
HL2010E		700°F on LCD <sup>(1)</sup>
CV-1981	PR-25D	7 <sup>(1)</sup>

### 3. Wire Preparation:

- Strip the stranded wire as shown.

Configuration		Product						
		Red		Blue		Yellow		
		Wire Range 22-18 AWG	Strip Length L (±0.5)	Wire Range 16-14 AWG	Strip Length L (±0.5)	Wire Range 12-10 AWG	Strip Length L (±0.5)	
Terminal		$0.5 < S_C < 1.0$	$L_C = 7.0$	$1.5 < S_C < 2.5$	$L_C = 7.0$	$3.0 < S_C < 6.0$	$L_C = 7.0$	see Fig. 1
Splice 1 to 1		$0.5 < S_C < 1.0$	$L_C = 8.0$	$1.5 < S_C < 2.5$	$L_C = 8.0$	$3.0 < S_C < 6.0$	$L_C = 8.5$	see Fig. 2
Splice 2 to 1	$\phi A < \phi B$	$1.5 < \phi A + \phi B < 3.7$ and $1.5 < \phi C < 3.7$	$L_A = 10$ $L_B = 8.0$	$2.0 < \phi A + \phi B < 4.3$ and $2.0 < \phi C < 4.3$	$L_A = 10$ $L_B = 8.0$	$3.0 < \phi A + \phi B < 6.4$ and $3.0 < \phi C < 6.4$	$L_A = 11$ $L_B = 8.5$	see Fig. 3
		$0.5 < S_A + S_B < 1.0$ and $0.5 < S_C < 1.0$		$1.5 < S_A + S_B < 2.5$ and $1.5 < S_C < 2.5$		$3.0 < S_A + S_B < 6.0$ and $3.0 < S_C < 6.0$		
	$\phi A = \phi B$	$1.5 < \phi A + \phi B < 3.7$ and $1.5 < \phi C < 3.7$	$L_A = 10$ $L_B = 10$	$2.0 < \phi A + \phi B < 4.3$ and $2.0 < \phi C < 4.3$	$L_A = 10$ $L_B = 10$	$3.0 < \phi A + \phi B < 6.4$ and $3.0 < \phi C < 6.4$	$L_A = 11$ $L_B = 11$	
		$0.5 < S_A + S_B < 1.0$ and $0.5 < S_C < 1.0$		$1.5 < S_A + S_B < 2.5$ and $1.5 < S_C < 2.5$		$3.0 < S_A + S_B < 6.0$ and $3.0 < S_C < 6.0$		

$\phi A$  = diameter (mm) of the insulation of wire A.

$S_C$  = cross section area (mm<sup>2</sup>) of wire C.

Fig. 1.

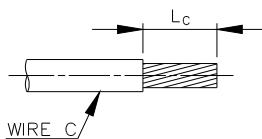
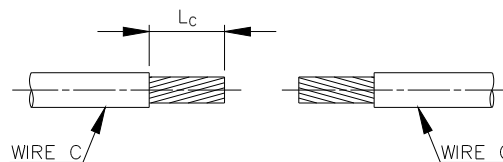


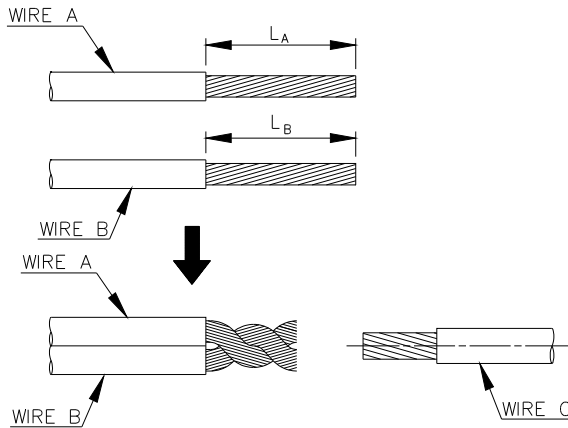
Fig. 2.



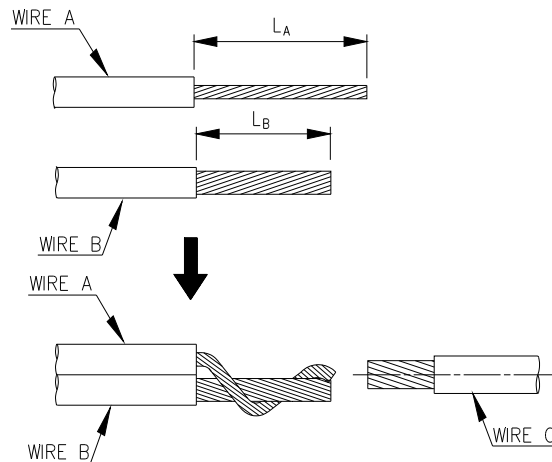
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are in between brackets]

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**Fig. 3.**



**Fig. 4.**



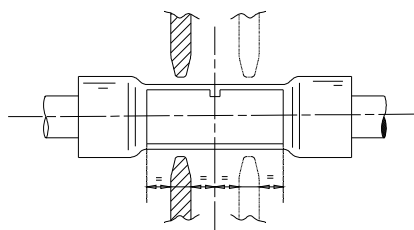
**WARNING**

- *IR tools are not recommended for use with black wire or cable insulations and must not be used for Tyco Electronics/Raychem 99T uncross-linked wires.*
- *Hot Air guns shall be set to a temperature as low as 300 deg C (570 deg F) to avoid thermal damage on uncross-linked wires, such as Tyco Electronics/Raychem 99T.*
- *Tyco Electronics recommends controlling temperature of application equipment such as hot air guns regularly.*

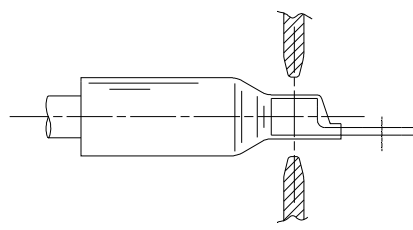
**4. Installation Procedure:**

- Select the correct DuraSeal crimp.
- Match its color with the color of the cavity of the crimp tool.
- Get the jaws in touch with the tubing.

DuraSeal Splice



DuraSeal Terminal



- Insert the stripped wire until it butts inside the DuraSeal crimp.
- Crimp the wire in place.
- Repeat the operation symmetrically for the DuraSeal splice.

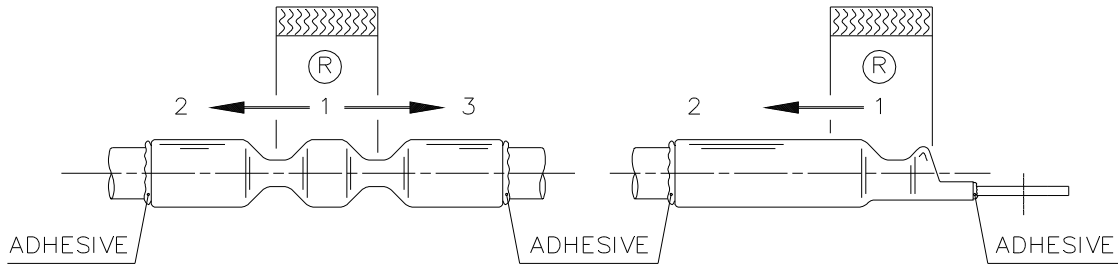
## Devices Installation Procedure

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- Allow the hot air gun to warm up.
- Position the DuraSeal crimp in the reflector (R).
- Apply heat to shrink the sleeve until the adhesive melt and flow around the extremities of sleeve.

### DuraSeal Splice

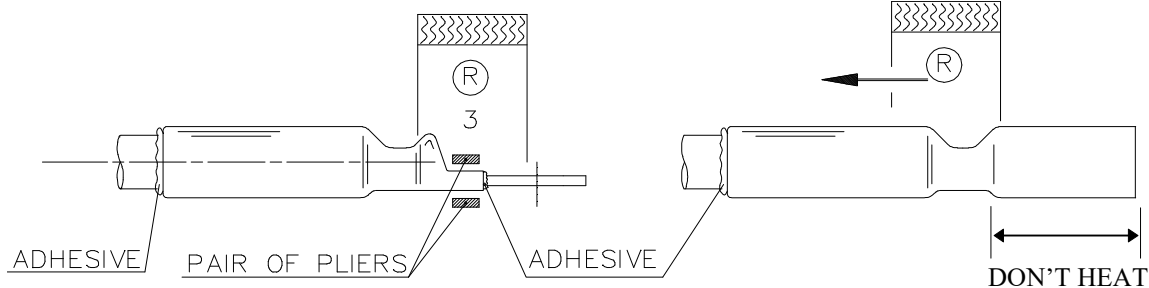
### DuraSeal Terminal



**Note:** For DuraSeal terminals, in order to achieve maximum sealing (except for DuraSeal push-on) heat the terminal at 3 and press the flat part with a pair of pliers until the assembly cools.

### Ring Terminal

### Push-on Terminal



**Note:** Do not heat the terminal for the push-on terminal.

Do not bend the splice or the terminal assemblies until they have completely cooled.

## 5. **Inspection of Assembly:**

### Check:

- Wire insulation is positioned inside the DuraSeal sleeve.
- Adhesive has flowed to form a fillet around the ends of the sleeve.
- Sleeve is completely shrunk on to the wire insulation.
- Sleeve is not cut, split or discolored.
- Wire insulation has no signs of mechanical damage or overheating.

Unless otherwise specified dimensions are in millimeters. [Inches dimensions are in between brackets]

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## Acceptable termination



<sup>1</sup> These values are for reference only and may change based on other variables (i.e. reflector type, sleeve's relative distance to the reflector, etc.)



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DISCLAIMER

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