Wire-to-Wire Splicing

DuraSeal Heat-Shrinkable, Environmentally Sealed, Nylon-Insulated Crimp Splices

Product Facts
- Protects splices from water, condensation, salt, and corrosion
- Provides strain relief
- Protects against vibration in rugged environments
- Completely insulates and protects electrical connections
- Has adhesive lining for protection that is more reliable than conventional splices
- UL, CUL, and Lloyd’s listed

 Specifications/Approvals

<table>
<thead>
<tr>
<th>Series</th>
<th>Agency</th>
<th>Raychem</th>
</tr>
</thead>
<tbody>
<tr>
<td>D-406</td>
<td>UL and CUL listed 91J4, File E87681</td>
<td>RB-107</td>
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Applications
- Automotive/truck wiring repair and maintenance.
- Automotive accessory installations.
- OEM automotive/truck/RV wire harness fabrication.
- Marine electronics.
- Fleet maintenance.
- Commercial wiring (pumps/pools/spas).
- Appliances.

Product Dimensions
Butt Splices

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Butt Splice Dimensions</th>
<th>Color</th>
<th>Conductor</th>
<th>Wire Dimensions</th>
</tr>
</thead>
</table>

Available in:
- Americas
- Europe
- Asia Pacific

Variants: Wire-to-Wire Splicing

Dimensions are in millimeters and inches unless otherwise specified. Values in brackets are U.S. equivalents. Dimensions are shown for reference purposes only. Specifications subject to change.
**Electrical Interconnect Products**

**Catalog 1654025 Dimensions are in millimeters Dimensions are shown for USA: 1-800-522-6752 South America: 55-11-3611-1514 Canada: 1-905-470-4425 Mexico: 01-800-733-8926 Plastic Interconnect Products Japan: 81-44-900-5102**

**Revised 12-04 and inches unless otherwise specified. Values in brackets are U.S. equivalents.**

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**Wire-to-Wire Splicing**

**DuraSeal Heat-Shrinkable, Environmentally Sealed, Nylon-Insulated Crimp Splices (Continued)**

<table>
<thead>
<tr>
<th>Wire Size AWG</th>
<th>mm²</th>
<th>Part No.</th>
<th>Color</th>
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<tbody>
<tr>
<td>22–18</td>
<td>0.38–0.95</td>
<td>D-406-0001</td>
<td>Red</td>
</tr>
<tr>
<td>16–14</td>
<td>1.2–2.5</td>
<td>D-406-0002</td>
<td>Blue</td>
</tr>
<tr>
<td>12–10</td>
<td>3–6</td>
<td>D-406-0003</td>
<td>Yellow</td>
</tr>
</tbody>
</table>

**Specifications**

**Table:**

- **Dimensions:**
  - Operating temperature: -55°C to 125°C [-67°F to 257°F]
  - Shrink ratio: Approximately 2:1
  - Cut-through resistance: 31 kg [70 lb]
  - Wire pullout after crimping and recovery: red: 11.3 kg [25 lb]; blue: 22.7 kg [50 lb]; yellow: 27.2 kg [60 lb]
  - Not flame-retardant
  - No cracking after heat aging for 168 h at 160°C [320°F]
- **Chemical properties:** Solvent resistance: isopropyl alcohol, trichloroethylene, gasoline, battery acid, diesel fuel, motor oil, antifreeze, brake fluid, 5% salt water
- **Electrical properties:**
  - Dielectric strength: 2500 Vac
  - Insulation resistance: 1000 megohms at 100 Vdc

**Installation Requirements**

- **For proper installation of these devices, the correct crimp tool and a heating tool with a reflector attachment must be used. The Raychem AD-1522 crimp tool and HL1802E heating tool are recommended.**
- **You will find ordering information for these tools in Section 10.**
- **Refer to Raychem installation procedure RPIP 821-00 for detailed instructions.**

**Installation**

1. **Select splice of appropriate size. Strip wire 7.5 mm (5/16 in). Insert into crimp barrel.**

2. **Crimp using Raychem AD-1522 crimp tool for preinsulated crimps.**

3. **Heat cramped splice with heat gun until tubing recovers and adhesive flows.**

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**Product Selection Process**

1. Determine wire size.
2. Select part number.

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**Product Characteristics (Typical)**

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**Product Selection Process**

1. Determine wire size.
2. Select part number.