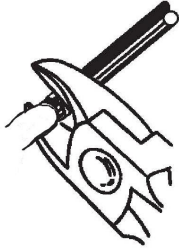


Splicing with Heat Shrink Sealed Splices

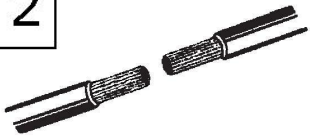
1



Cut off splice.

(Minimize wire length loss)

2



Strip insulation.

5mm (3/16") length for 10 through 20 Gauge

10mm (3/8") for 22 Gauge

CAUTION: Do not cut strands

PREFERRED: Locate new splice 40mm (1.5") minimum from an outlet or another splice.

3

Determine proper sleeve for wire gauge.

Position stripped wire ends into sleeve until wire hits the stop.

4

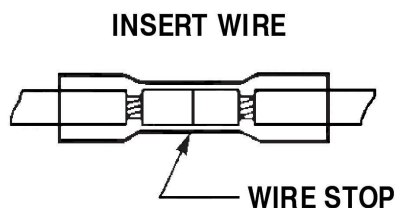
Squeeze tool handles until ratchet automatically opens.

Determine the correct splice nest per sealed splice color and wire size.

5

Gently apply pressure to handles until crimpers slightly secure the splice sleeve barrel. Note: Must be crimped in two stages—left and right.

6



Position stripped wire ends into sleeve until wire hits the stop.

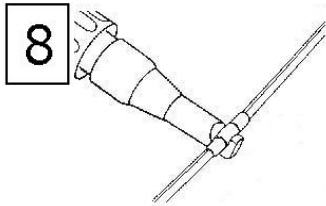
Squeeze tool handles until ratchet automatically opens.

7 CRIMP CONNECTOR

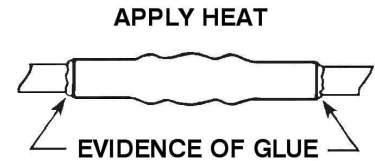


Note: Must be crimped in two stages—left and right.

Gently tug on the wires to make sure they are secure before applying heat to sleeve



Apply heat from center to outside of sleeve until evidence of glue is visible on both sides of the tube.



In some extreme high temperature applications, (That is, under hood, near exhaust systems, etc.) heat shrink tube (J-138125-TUBE) must be placed over the completed crimp and seal splice to preserve the integrity of the splice seal.

9 Electrically check for continuity.

This manual shows only the minimum required information based on general use and production conditions.

Use this manual for reference only.

ENGLISH (SAE)/METRIC GAUGE CONVERSION TABLE

Metric Size (sq. mm.)	English (SAE) Size (Gauge)
0.22	24
0.35	22
0.5	20
0.8	18
1	16
2	14
3	12
5	10
8	8
13	6
19	4