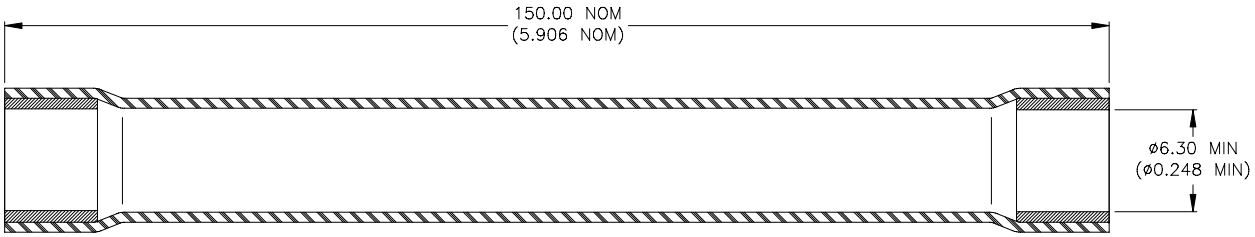
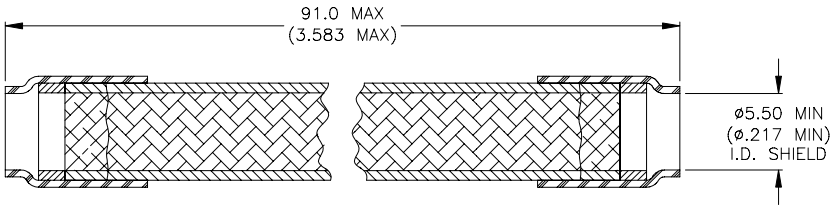
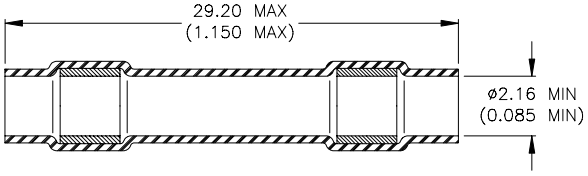
SPECIFICATION CONTROL DRAWING



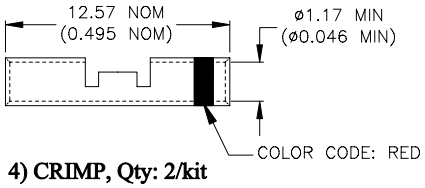
1) OUTER SEALING SLEEVE, Qty: 1/kit



2) FLEXIBLE SOLDERSHIELD, Qty: 1/kit



3) SEALING SLEEVE, Qty: 2/kit



4) CRIMP, Qty: 2/kit

MATERIALS

1. OUTER SEALING SLEEVE: High temperature stabilized cross-linked elastomer. Color: black.
   SEALING INSERTS: Stabilized modified elastomer-fluoropolymer thermoplastic.
2. SOLDERSHIELD:
   INSULATION SLEEVES: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
   SHIELD: Solder impregnated, flux coated tin-plated copper wire braid.
   SOLDER: TYPE Sn63 per ANSI / J-STD-006.
   FLUX: TYPE ROM1 per ANSI / J-STD-004.
3. SEALING SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride. Qty: 2/kit
   MELTABLE RINGS: Fluorocarbon-based thermoplastic.
4. CRIMP SPLICE: Tin-plated copper alloy. Color code: red. Qty: 2/kit
   BASE METAL: Copper Alloy 101 or 102 per ASTM B-75.
   PLATING: Tin-plated per ASTM B 545, Type 1.

APPLICATION

1. This kit is designed to provide an environment-resistant in-line splice in cables having tin-plated shields, 26, 24 or 22 AWG tin-plated primaries and a temperature rating of at least 125°C.
2. Temperature range: -55°C to +150°C.

tyco Electronics	Tyco Electronics Corporation 300 Constitution Drive, Menlo Park, CA. 94025, U.S.A.	Raychem	TITLE: SOLDERSHIELD SPLICE KIT, SINGLE SHIELDED CABLE, MINI-SEAL CRIMP PRIMARY SPLICE				
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]			DOCUMENT NO.: **D-150-0321**				
TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A	ANGLES: N/A ROUGHNESS IN MICRON	Tyco Electronics reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.	REV.: A	DATE: 16-Dec-05	APPROVED: LR		
PREPARED BY: MF	DCR NUMBER: D050482	REPLACES: D020346	CAGE CODE : 06090	SCALE: ---	SIZE: A	SHEET: 1 of 2	

SPECIFICATION CONTROL DRAWING

INSTALLATION PROCEDURE

1. Cable preparation. See figure below.

Tolerances: All lengths ± 0.50 [0.020]

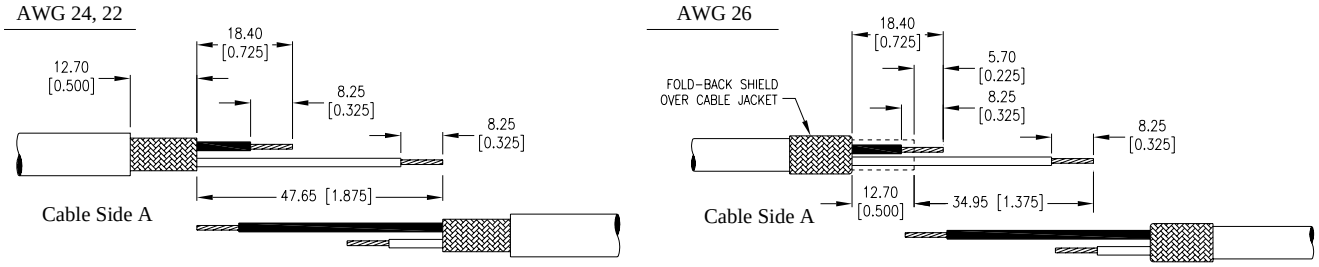
a) Remove cable jacket and shield: AWG 24, 22= 47.65 [1.875]; AWG 26= 34.95 [1.375]

b) Cut 1 primary on each cable: AWG 24, 22= 18.40 [0.725]; AWG 26= 5.70 [0.225] from cable jacket.

Note: The short primary on cable side A is to be connected to the long primary on cable side B.

c) Remove cable jacket: 12.70 [0.500]. For AWG 26 cable, fold-back shield over cable jacket to increase O.D.

d) Strip primaries: 8.25 [0.325].



2. Application Equipment

a) AD-1377 crimp tool or equivalent.

b) Steinel HL1802E Heat Gun with a soldersleeve reflector. (Setting of 13 – 14)

3. Assembly Procedure

a) Place the outer Sealing Sleeve on one end of the assembly.

b) Place the Flexible Soldershield splice onto the other cable assembly.

c) Primary Conductor Splice:

1) Place a Sealing Sleeve onto the longer lead of each cable.
2) Crimp primaries into opposite ends of the crimp splices using a calibrated Raychem AD-1377 crimp tool or equivalent.
3) Center the sealing sleeves over the splices.
4) Apply heat to the center of the sleeve until it recovers, and then heat ends until sealing rings melt and flow along wires.

d) Inspection:

1) Conductors must be visible at point where they enter the crimp barrel.
2) Both indentations of a crimp must be on the crimp barrel.
3) Sealing sleeve inserts must have flowed along wire insulation.
4) Sleeve must not have discolored to the degree that the crimp barrel cannot be inspected.
5) Sleeve must not be cut or split.

e) Shield Splice:

1) Center the Flexible Soldershield over the splice and the exposed cable shields. Pull on each end of the braid, so it is fully extended.
2) Heat each of the pre-tinned ends using Steinel HL-1802E with 5/8" SolderSleeve reflector, until the solder rings melt and flow onto the cable braid.
3) Inspect.
4) Slide the outer Sealing Sleeve and position it on center of the splice.
5) Heat using using CV-1981 with PR25A reflector (setting 6, vane open) or Steinel HL-1802E with 5/8" SolderSleeve reflector.
6) Heat beginning at the center until the tubing shrinks then move slowly towards the ends.
7) Heat ends until the sealing inserts are seen to melt and appear at both ends

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

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