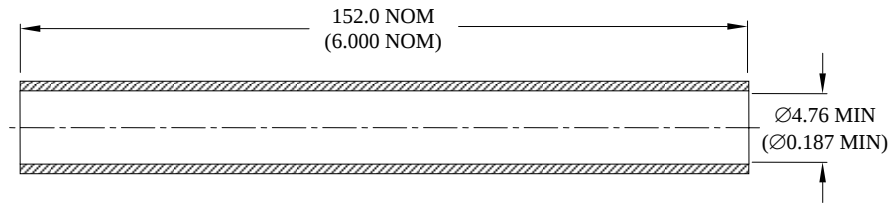
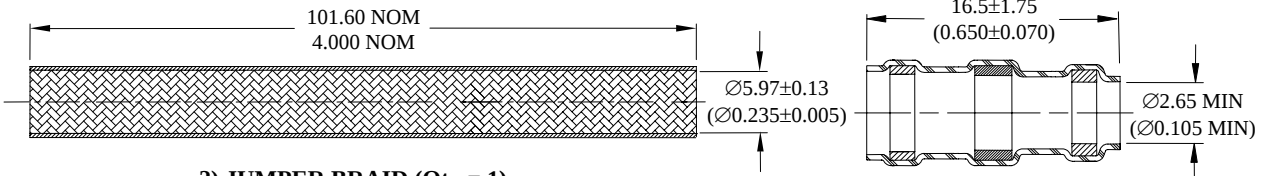


## CUSTOMER DRAWING

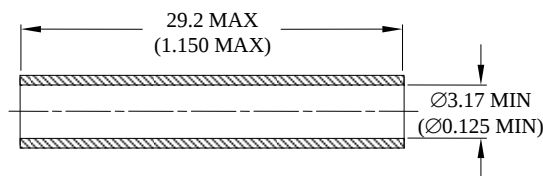


**1) OUTER INSULATION SLEEVE (Qty = 1)**

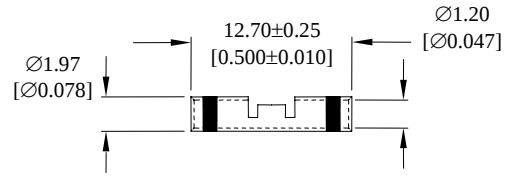


**2) JUMPER BRAID (Qty = 1)**

**3) SOLDER SLEEVE, Qty.: 2**



**4. INSULATION SLEEVE, Qty: 2**



**5) CRIMP SPLICE, Qty.: 2**

### MATERIALS

1. OUTER INSULATION SLEEVE: Heat-shrinkable, high temperature, low out gassing, Tyco Electronics RT-220. Color: White.
2. JUMPER BRAID: Silver-plated copper alloy.
3. SOLDER SLEEVE: Qty.: 2  
INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.  
SOLDER PREFORM WITH FLUX:  
SOLDER: TYPE Sn63 per ANSI / J-STD-006.  
FLUX: TYPE ROL1 per ANSI / J-STD-004.
- MELTABLE RINGS: Environment resistant modified thermoplastic fluoroelelastomer. Color: light blue.
4. INNER INSULATION SLEEVE: Heat-shrinkable, high temperature, low out gassing, Tyco Electronics RT-220. Color: White.
5. CRIMP SPLICE: Gold-plated copper. Color Code: Red.  
Base Metal: Copper Alloy 101 or 102 per ASTM B-75.  
Plating: Gold-plated per MIL-G-45204B.

### APPLICATION

1. These Cable Splice kits may be used to obtain an insulated twisted double cable splice. Both conductors and shield shall be tin or silver-plated, conductor gauge AWG 26-20. Cables jacket shall be rated for not less than 135°C.
2. Temperature rating: -65°C to + 150°C.
3. Install using Tyco Electronics approved hot-air heaters or equivalent. Use Tyco Electronics Raychem AD-1377 crimp tool (or equivalent tool) to install crimp ferrules.

|                                                                                                             |                                                         |                                                                                                                                                             |                                                                                                           |                                |                         |
|-------------------------------------------------------------------------------------------------------------|---------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------|--------------------------------|-------------------------|
|  <b>Tyco Electronics</b> |                                                         | Tyco Electronics<br>300 Constitution Dr<br>Menlo Park, CA<br>94025, U.S.A.                                                                                  | <b>TITLE:</b><br>SHIELDED CABLE SPLICE, FLEXIBLE,<br>SILVER-PLATED BRAID,<br>GOLD-PLATED CRIMP, 150 DEG C |                                |                         |
| Unless otherwise specified dimensions are in millimeters.<br>[Inches dimensions are shown in brackets]      |                                                         | <b>Raychem<br/>Devices</b>                                                                                                                                  | <b>DOCUMENT NO.:</b><br>D-150-0348                                                                        |                                |                         |
| <b>TOLERANCES:</b><br>0.00 N/A<br>0.0 N/A<br>0 N/A                                                          | <b>ANGLES:</b> N/A<br><br><b>ROUGHNESS</b><br>IN MICRON | Tyco Electronics reserves the right to<br>amend this drawing at any time. Users<br>should evaluate the suitability of the<br>product for their application. | <b>REV:</b><br>C                                                                                          | <b>DATE:</b><br>April 10, 2009 |                         |
| <b>DRAWN BY:</b><br>AREY                                                                                    | <b>CAGE CODE:</b><br>06090                              |                                                                                                                                                             | <b>SCALE:</b><br>NTS                                                                                      | <b>SIZE:</b><br>A              | <b>SHEET:</b><br>1 of 2 |

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## CUSTOMER DRAWING

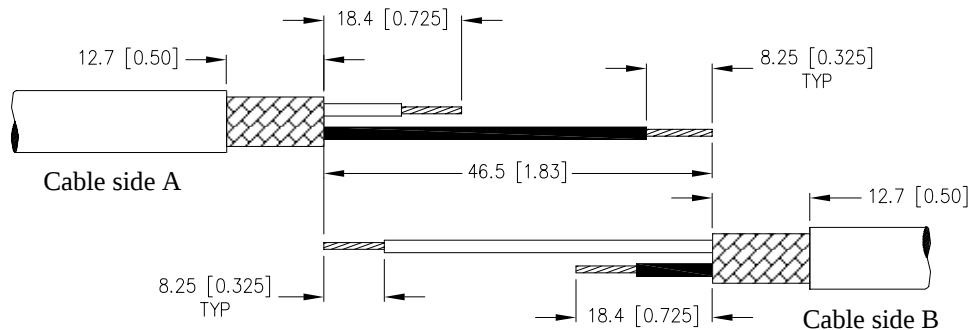
### INSTALLATION PROCEDURE

1. Cable preparation. See figure below.

Tolerances: All lengths  $\pm 0.50$  (0.020)

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

- Remove cable jacket and shield: 46.50 (1.830)
- Cut one of the primaries: 18.40 (0.725) from cable jacket.
- Strip primaries: 8.25 (0.325)
- Remove cable jacket to exposed braid: 12.70 (0.500)



2. Application Equipment

- AD-1377 crimp tool or equivalent.
- Steinel HL1910E Heat Gun with a Shield Terminator reflector (Setting of 6 – 7)

3. Assembly Procedure

- Place the Outer Insulation Sleeve (Item 1) on one end of the assembly.
- Place each Shield Terminators (Item 3) on each cable side. Smaller ID shall be facing cable.
- Place the Silver-plated Jumper Braid (Item 2) onto one of the cables to be spliced.
- Primary Conductor Splice:
  - Place a insulation sleeve (Item 4) onto the longer lead.
  - Crimp primaries into opposite ends of the crimp splices using a calibrated Tyco Electronics AD-1377 crimp tool or equivalent.
  - Center the insulation sleeves over the splices.
  - Apply heat to the insulation sleeve until it fully recovers.
- Inspection:
  - Conductors must be visible at point where they enter the crimp barrel.
  - Both indentations of a crimp must be on the crimp barrel.
  - Insulation Sleeve must be fully recovered over crimp ferrule and conductors jacket.
  - Sleeve must not have discolored to the degree that the crimp barrel cannot be inspected.
  - Sleeve must not be cut or split.
- Jumper Braid:
  - Center the Silver plated Jumper Braid over the splice and the exposed cable shields. Trim off excess length (as required) so that it will not cover the cable jacket. The jumper braid should overlap the cable braid.
  - Position the Shield Terminator over the end of the Nickel Braid and onto the cable jacket.
  - Heat Shield Terminator to the center of the solder pre-form until it melts, flows, and wets the cable shield. Apply heat on each end of the Shield Terminators until sealing rings melt and flow along cable jacket. Repeat for other Shield Terminator.
- Position the Outer Sealing Sleeve and center to overlap the splice equally on each end and apply heat to shrink the tubing.

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

|                                    |                  |                                     |                                |                         |
|------------------------------------|------------------|-------------------------------------|--------------------------------|-------------------------|
| DOCUMENT NO.:<br><b>D-150-0348</b> | REV:<br><b>C</b> | ECO NUMBER:<br><b>ECO-09-008914</b> | DATE:<br><b>April 10, 2009</b> | SHEET:<br><b>2 of 2</b> |
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