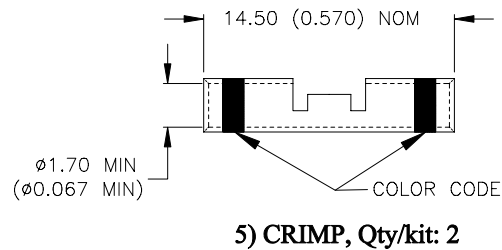
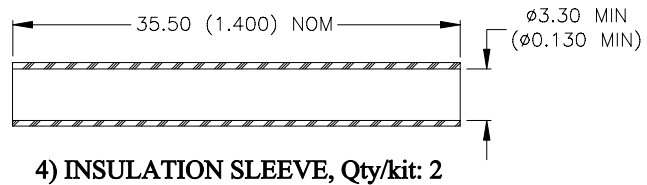
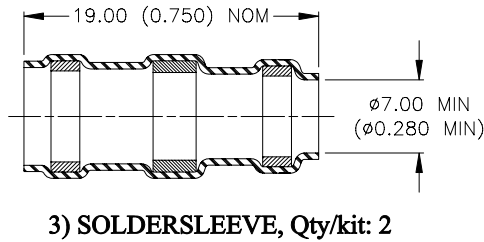
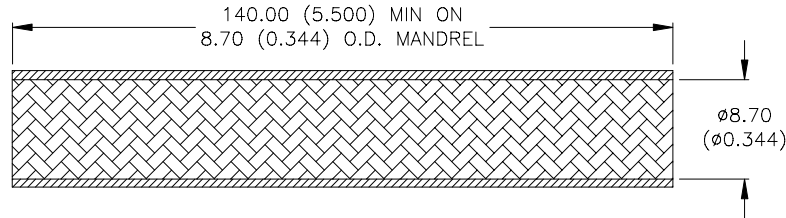
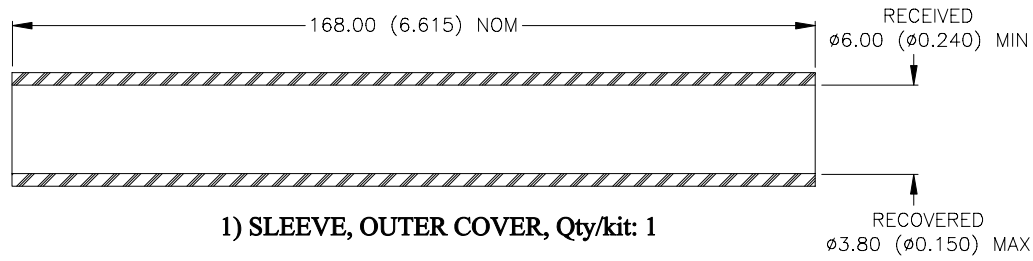


SPECIFICATION CONTROL DRAWING



MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent clear, modified polytetrafluorethylene with meltable liner.
2. JUMPER BRAID: Nickel-plated copper alloy.
3. SOLDER SLEEVE: Radiation cross-linked modified polyvinylidene fluoride sleeve. Qty: 2.
 SOLDER PREFORM WITH FLUX:
 SOLDER: TYPE Sn96 per ANSI-J-STD-006.
 FLUX: TYPE ROM1 per ANSI-J-STD-004.
 MELTABLE RINGS: Thermally stabilized thermoplastic. Color: red/blue.
4. INSULATION SLEEVE: Heat-shrinkable, transparent clear, modified polytetrafluorethylene with meltable liner. Qty: 2.
5. CRIMP SPLICE: Nickel-plated copper alloy. Color code: blue. Qty: 2.

APPLICATION

1. This kit is used to provide an environmentally protected 1 to 1 splice in shielded cables.
 Cable usage parameters:
 Cable must have one size 20 AWG or 18 AWG nickel-plated primaries, nickel-plated shield and PTFE jacket.
2. Temperature range: -55°C to +200°C.

<div>tyco</div> <div>Electronics</div>		<div>Raychem Products</div> <div>305 Constitution Drive, Menlo Park, CA. 94025, USA</div>		<div>TITLE:</div> <div>SHIELDED TWISTED PAIR, CABLE 1 TO 1 SPLICE, ENGINE HARNESS 200°C</div>				
Unless otherwise specified dimensions are in millimeters. Inches dimensions are shown in brackets.				<div>DOCUMENT NO.:</div> <div>D-150-0252</div>				
<div>TOLERANCES:</div> <div>0.00 N/A 0.0 N/A 0 N/A</div>		<div>ANGLES: N/A</div> <div>ROUGHNESS IN MICRON</div>					<div>Tyco Electronics reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.</div>	
<div>PREPARED BY:</div> <div>mforonda</div>		<div>DCR NUMBER:</div> <div>D030011</div>		<div>REPLACES:</div> <div>D981014</div>		<div>SCALE:</div> <div>None</div>	<div>SIZE:</div> <div>A</div>	<div>SHEET:</div> <div>1 of 2</div>

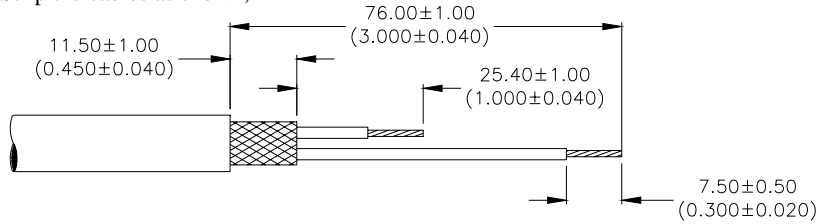
If this document is printed it becomes uncontrolled. Check for the latest revision.

SPECIFICATION CONTROL DRAWING

INSTALLATION PROCEDURE

1. Cable preparation.

Strip the cables as shown;



For ease of description, one cable to be spliced is designated as cable A and the other as cable B.

2. Assemble components onto cable.

- 2.1 Place the insulation sleeve (1) onto cable (A).
- 2.2 Place one SolderSleeve onto each cable.
- 2.3 Cut off the fused ends of the jumper braid (2) and place it onto cable (B).
- 2.4 Install a crimp barrel onto each short primary. Use a calibrated Raychem AD-1337 crimp tool.
- 2.5 Place one insulation sleeve (4) onto each long primary.
- 2.6 Crimp matching primaries together.
- 2.7 Center the sleeve (4) over the crimp splice and heat starting from the center, until the liner melts and the sleeve recovers. When sleeve first starts to recover there will be longitudinal lines in the meltable liner, continue heating until these lines disappear.
- 2.8 Position the jumper braid (2) so that the trailing end just clears the jacket of the cable (B). Twist this end down onto the cable shield.
- 2.9 Position the SolderSleeve (3) so that the edge of the solder preform is 2.5mm (.100 inch) passed the cable jacket. Place the assembly in heater so that the solder preform is centered in the reflector. Apply heat until the solder melts and flows into the shield. Allow solder to resolidify before handling.
- 2.10 Pull jumper braid (2) tightly across the splice and twist it down onto the cable (A). Cut off any braid that overlaps the cable jackets. Repeat step 9.
- 2.11 Center the insulation sleeve (1) over the assembly. Sleeve should overlap the cable jacket by about 25mm (1.0 inch) at each end. Heat this sleeve, starting in the center, until the inner liner melts and the sleeve recovers. When sleeve first starts to recover there will be longitudinal lines in the meltable liner, continue heating until these lines disappear.

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

DOCUMENT NO.: D-150-0252	PROD. REV.: D	DOC. ISSUE: 2	DCR NUMBER: D030011	DATE: 30-Jan-03	SHEET: 2 of 2
------------------------------------	------------------	------------------	------------------------	--------------------	------------------

If this document is printed it becomes uncontrolled. Check for the latest revision