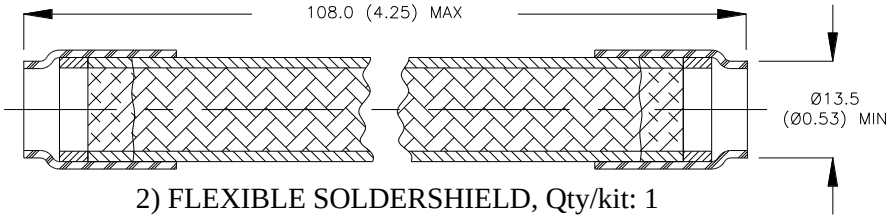
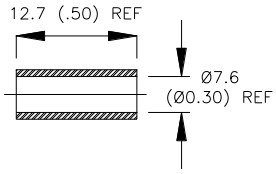
CUSTOMER DRAWING

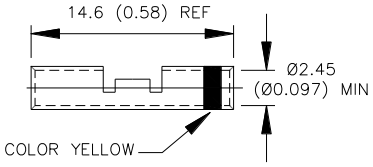
1) OUTER SLEEVE, Qty/kit: 1



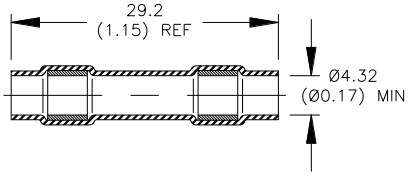
2) FLEXIBLE SOLDERSHIELD, Qty/kit: 1



3) SPLIT ADHESIVE SLEEVE, Qty/kit: 3



4) CRIMP, Qty/kit: 2



5) SEALING SLEEVE, Qty/kit: 2

MATERIALS

1. OUTER SLEEVE: Heat-shrinkable, flexible, cross linked polyolefin.
2. FLEXIBLE SOLDERSHIELD: Tin plated copper braid, tinned and fluxed with Sn63 Solder and ROM1 flux at both ends.
   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 ROL0 per ANSI/J-STD-004
3. SPLIT ADHESIVE SLEEVE: Hot melt polyolefin adhesive
4. CRIMP BARREL: Yellow stripe code.
   BASE METAL: Copper alloy 101 or 102 per ASTM B-75.
   PLATING: Tin plated per MIL-T-10727, Type I.
5. SEALING SLEEVE:
   INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.

			TITLE: **FLEXIBLE SHIELD SPLICE KIT**		
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets] DIMENSIONING AND TOLERANCING PER ASME Y14.5-2009		Raychem Devices	DOCUMENT NO.: **D-150-3000-02**		
TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A	ANGLES: N/A ROUGHNESS IN MICRON	TE Connectivity reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.	Revision: C	Issue Date: 21 August 2020	
PREPARED BY: *RODRIGUEZ*	CAGE CODE: 06090	ECO: ECO-20-011740	SCALE: NTS	SIZE: A	SHEET: 1 of 3

CUSTOMER DRAWING

SEALING RINGS: Immersion resistant thermoplastic. Color: one clear, one yellow.

APPLICATION

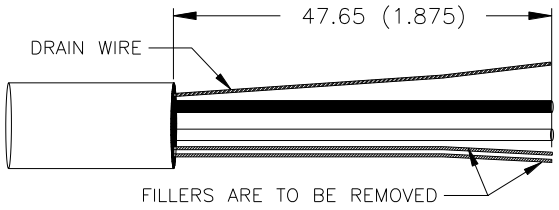
1. This flexible cable joint is designed to facilitate the assembly or maintenance of pre-cabled digital harness components for J1939 networks for a 2 to 1 splice. It should be used where continuous flexing is not a functional requirement.
2. Cables to be joined: 2021D0309, 2019D0309

INSTALLATION PROCEDURE

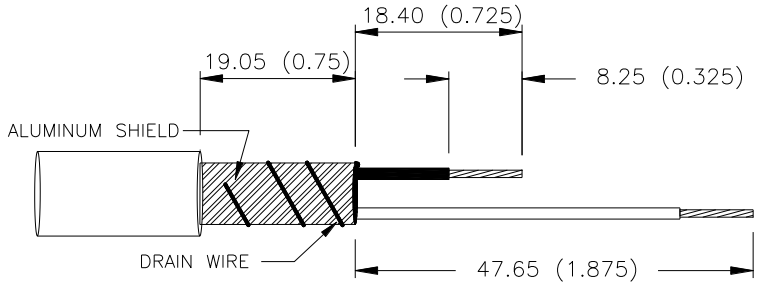
1. Cable preparation. See figure below

Tolerances: All length ± 0.50 (0.020)

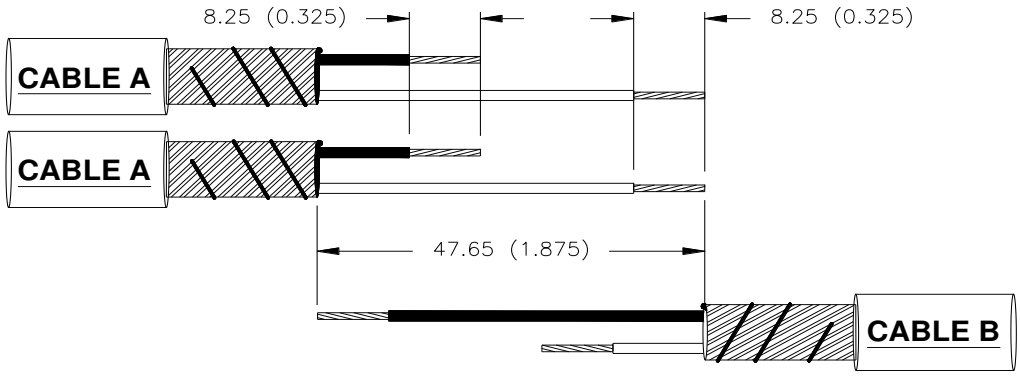
a) Remove cable jacket, aluminum shield and filler: 47.65 (1.875)



b) For each cable to be spliced, cut one of the primaries: 18.40 (0.725) from cable jacket.
c) Strip primary: 8.25 (0.325)
d) Remove cable jacket to exposed aluminum shield: 19.05 (0.75). The drain wire shall be folded back over and wrapped around the aluminum shield.



e) The short primaries on both cables A are to be connected to the long primary on cable B.



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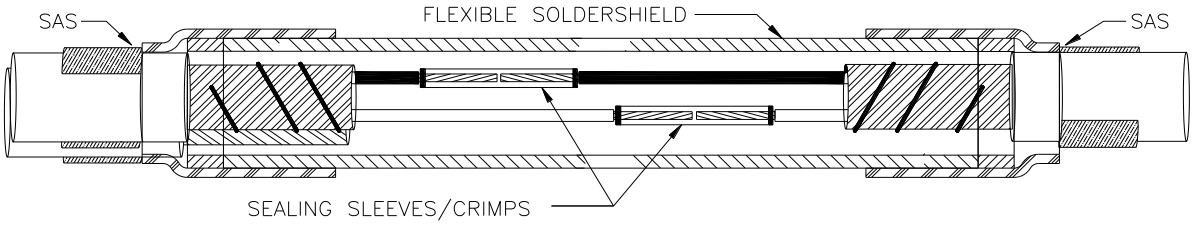
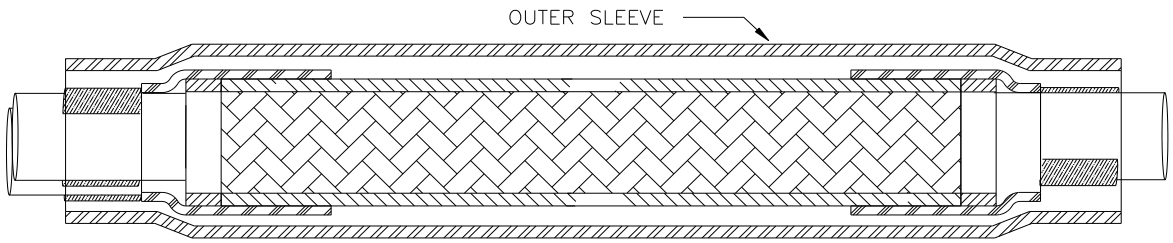
2. Application Equipment
   a) AD-1377 crimp tool or equivalent
   b) Steinel HL-2010E Heat Gun with a PR 34 SolderSleeve reflector (setting of 750º F)

3. Assembly Procedure

   a) Place the outer tubing on one end of the assembly.
   b) Place the SolderShield 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 TE AD-1377 crimp tool or equivalent
      3) Center the sealing sleeve 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) Primaries 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 insert must have flowed along primary insulation
      4) Sleeve must not have discolored to the degree that the crimp barrel can't be inspected.
      5) Sleeve must not be cut or split
   e) Shield Splice
      1) Center the SolderShield over the splice and the exposed aluminum shield.
      2) Heat the SolderShield.
         a. Apply heat to the end of sleeve until rings melt and flow along cable jacket
         b. Repeat for other end of SolderShield
         c. Place the Split Adhesive Sleeve flush to edge on the insulation as possible



         d. Position the tubing and center to overlap the splice equally on each end and apply heat to shrink the tubing



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