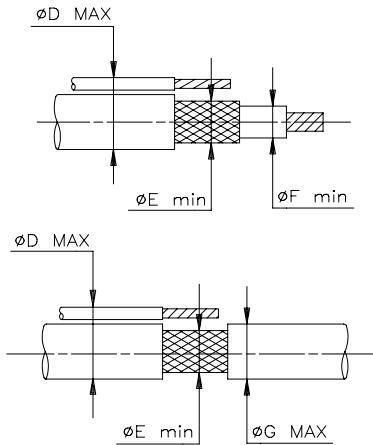


Installation Procedure For B-151-XX

1. Cable Dimensions:



Cable Dimensions				
Product Name	ϕD MAX	ϕE min	ϕF min	ϕG MAX
B-151-05	4.8	2.0	1.5	4.3
B-151-07	7.3	3.3	2.8	6.4
B-151-11	11.5	4.5	4.0	10.0
B-151-13	15.1	7.0	6.5	13.0
B-151-17	18.0	9.0	8.0	16.0

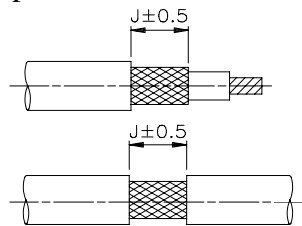
2. Application Equipment:

Product Name	Configurations	
	Reflector	Hot Air Gun
B-151-05	PR25D	CV-1981 (220V or 110V - 1460W) (Setting between 7 and 7.5)
B-151-07	PR25D	
B-151-11	PR25D	
B-151-13	PR33 or PR34	
B-151-17	PR33 or PR34	

3. Cable

Preparation:

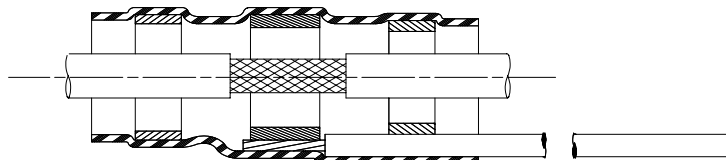
3-1. Prepare the cable as shown:



Product Name	$J \pm 0.5$
B-151-05	7.0
B-151-07	11.0
B-151-11	13.0
B-151-13	17.0
B-151-17	23.0

4. Assembly:

4-1. Slide the SolderSleeve* device over the exposed braid. Center the solder preform over the stripped area of the cable as shown:



4-2. Heating

Procedure:

Allow the hot air gun to reach its operating temperature. Place the assembly centrally in the appropriate reflector (see section 2) so the heat is concentrated on the solder preform.

When heat is applied, the tubing shrinks, the inserts melt, flow and form a seal. Continue heating until the solder melts and flows. A solder fillet between the ground lead and the cable braid must be visible.

4-3. Ground Lead:

When bending the ground lead, a minimum bend radius of 1 diameter of the wire should be allowed.

5. Inspection:**5-1. Inspection for proper assembly.**

- The exposed ground lead must not overlap the cable jacket.
- The insulation sleeve must overlap the cable jacket so that there is no exposed braid.

5-2. Inspection for proper heating.

- The solder preform must be completely melted and have flowed along the conductor.
- A solder fillet must be visible between the ground lead and the braid.
Visible remnants of the original shape of the solder preform indicate an underheated termination.
Lack of solder fillet indicates an overheated termination.
- The sleeve must be shrunk into the cable jacket.
An incompletely shrunk sleeve indicates an underheated termination.
A discolored dark brown sleeve indicates an overheated termination.

5-3. Inspection for damage.

- The sleeve must not be cut or split.
- There must be no braid poking through the sleeve.
- The cable jacket and the shield termination should not exhibit signs of mechanical damage or overheating such as cuts, melting charring.

6. Repair: (if necessary)**6-1. Repair of underheated termination.**

- Reheat underheated termination to obtain proper solder flow (see section 4-2).

6-2. Repair of overheated termination.

Remove the shield termination as follows.

- Score the full length of the sleeve with a sharp blade. Be careful not to cut the cable or wire jacket.
- By using the same heating tool as for installation, heat the shield termination to soften it, and strip it off with pliers or twizzers.
- Install a new shield termination in accordance with the procedure (see section 4).