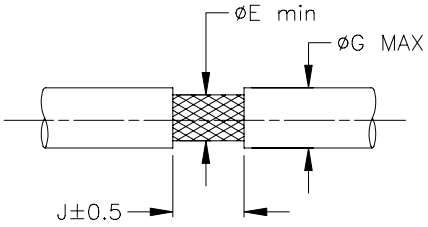
Installation Procedure For B-150-XX-F

1. Cable Preparation:



Product Name	Cable Dimensions		
	E Min.	G MAX	J±0.5
B-150-05-F	2.0	4.3	6.5
B-150-07-F	3.3	6.8	8.0

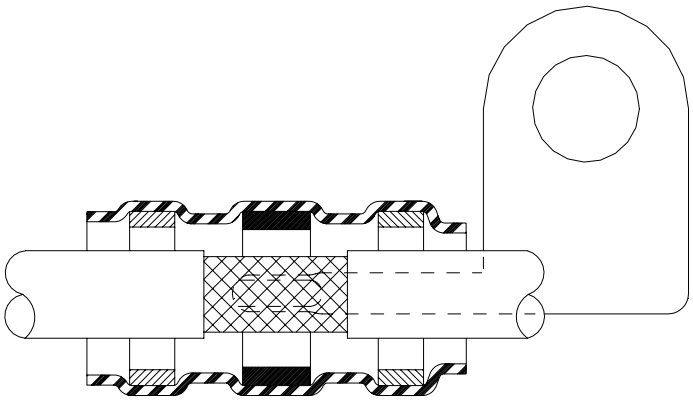
2. Application Equipment Recommendation:

	Configurations	
Product Name	Reflector	Hot Air Gun
B-150-05-F	PR25D	CV-1981 (220V or 110V) - 1460W (Setting between 7 and 7.5)
B-150-07-F	PR25D	

3. Assembly:

3-1. Slide the SolderSleeve device over the cable. Center the solder preform over the stripped area of cable as shown:

NOTE: Be sure that the flag terminal is positioned such that the termination of the flag terminal to other grounding point can be achieved.



3-2. 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 flag terminal and the cable braid must be visible. Allow the assembly to cool down before handling.

Caution: Flag terminal can become extremely hot to handle.
Allow sufficient time to cool down.

4. Inspection:

4-1. Inspection for proper assembly:

- The insulation sleeve must overlap the cable jacket so that there is no exposed braid.

4-2. Inspection for proper heating:

- The solder preform must be completely melted and has flowed along the conductor.
- A solder fillet must be visible between the flag terminal 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 onto the cable jacket.
  - An incomplete shrunk sleeve indicates an underheated termination.
  - A discolored dark brown sleeve indicates an overheated termination.

4-3. 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.

5. Repair: (if necessary)

5-1. Repair of underheated termination:

- Reheat underheated termination to obtain proper solder flow (see section 3.2)

5-2. 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 jacket.
- By using the same heating tool as for the 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 3).