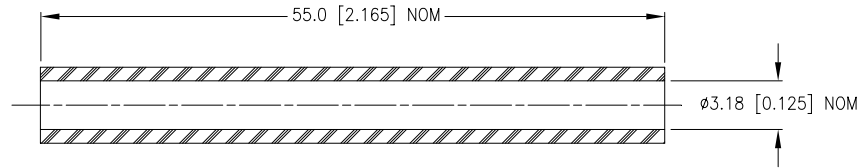
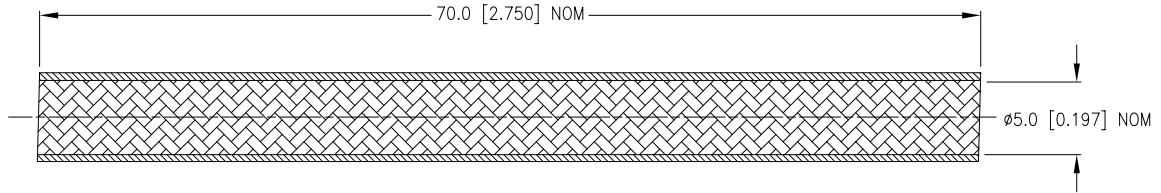


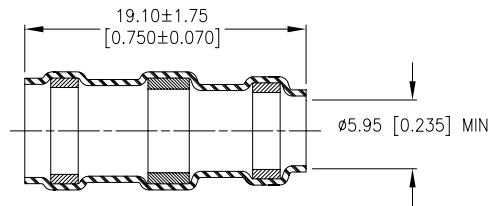
SPECIFICATION CONTROL DRAWING



1) INSULATION SLEEVE, Qty/kit: 2



2) JUMPER BRAID, Qty/kit: 2



3) SOLDERSLEEVE, Qty/kit.: 1

MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, radiation cross-linked modified fluoropolymer. Color: clear. Qty/kit: 2
2. BRAID: Tin-plated copper alloy. Qty/kit: 2
3. SOLDERSLEEVE: Qty/kit: 1

INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.

SOLDER PREFORM WITH FLUX AND THERMAL INDICATOR:

SOLDER: TYPE Sn63 per ANSI-J-STD-006.

FLUX: TYPE ROL1 per ANSI-J-STD-004.

THERMAL INDICATOR: Fusible ring, Melt point: 221°C.

MELTABLE RINGS: Environment resistant thermoplastic. Color: blue.

APPLICATION

1. This kit is used to provide an environmentally protected shield termination on a quadrax cable and two braids, having tin or silver-plated shields, and an insulation rated for at least 125°C.
 - Cable jacket diameter: 5.95 [0.235] max.
 - Cable shield diameter: 3.30 [0.130] min.
 - Conductor insulation diameter: 2.54 [0.100] max.
2. Temperature range: -55°C to +150°C.

tyco <i>Electronics</i>		Tyco Electronics Corporation 300 Constitution Drive, Menlo Park, CA. 94025, U.S.A.		<i>Raychem</i>		TITLE: QUADRAX CABLE SPLICE KIT	
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]						DOCUMENT NO.: D-150-0332	
TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A		ANGLES: N/A ROUGHNESS IN MICRON		Tyco Electronics reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.		REV.: A	
DATE: 22-Jun-06		PREPARED BY: M.Foronda		DCR NUMBER: D060138		REPLACES: ---	
CAGE CODE : 06090		SCALE: ---		SIZE: A		SHEET: 1 of 2	

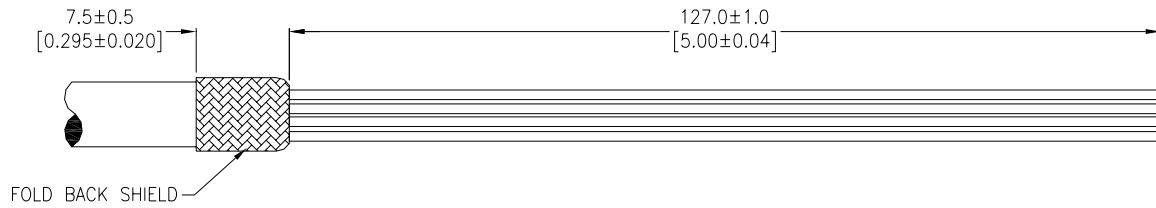
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SPECIFICATION CONTROL DRAWING

INSTALLATION PROCEDURE

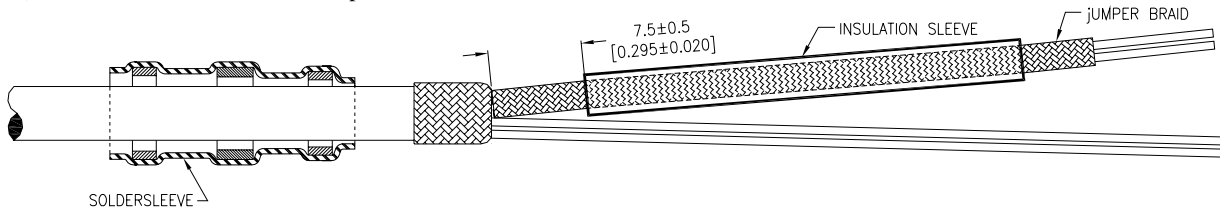
1. Prepare the cable as shown.



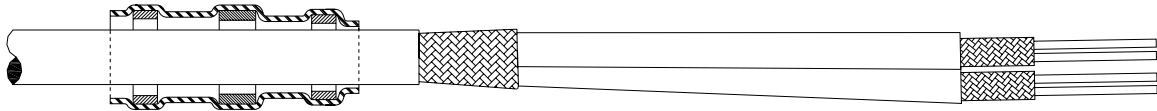
2. Application Equipment: Steinel HL1802E Heat Gun with a SolderSleeve reflector (Setting of 11 – 12)

3. Assembly Procedure

- Slide the SolderSleeve onto the cable.
- Slide the jumper braid over two of the conductors.
- Place the insulation sleeve on top of the braid.



- Apply heat to the insulation sleeve until it completely recovers over the braid.
- Repeat steps 3b and 3c for the other two conductors.
- Fold the cable shield back over the jumper braids.



g) Position the SolderSleeve over the cable shield, the solder preform centered on the shield.



- Apply heat to the center of the SolderSleeve until the solder melts, flows and wets the solder to the cable shield.
 - Apply heat to end of sleeve until rings melt and flow along cable jacket.
- Repeat for other end of sleeve.

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

DOCUMENT NO.: D-150-0332	DCR NUMBER: D060138	REV.: A	DATE: 22-Jun-06	SHEET: 2 of 2
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