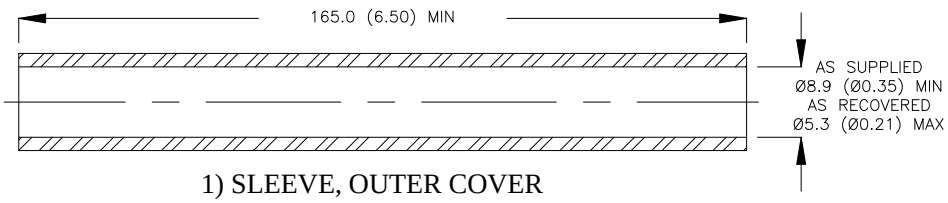
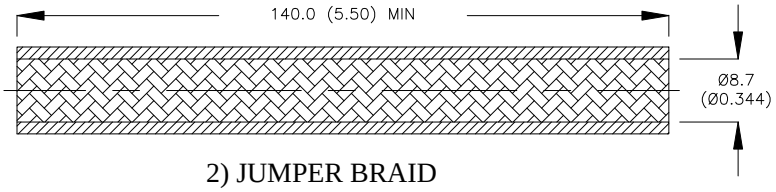
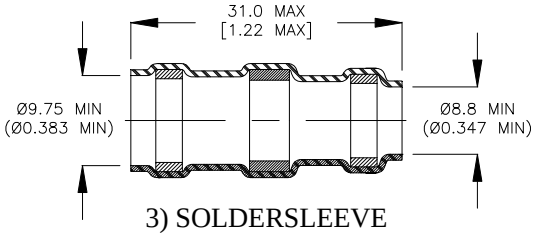
CUSTOMER DRAWING



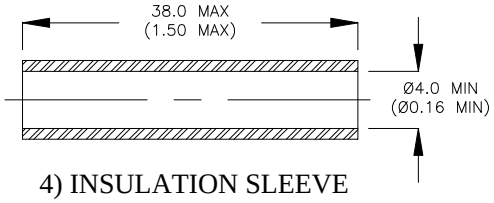
1) SLEEVE, OUTER COVER



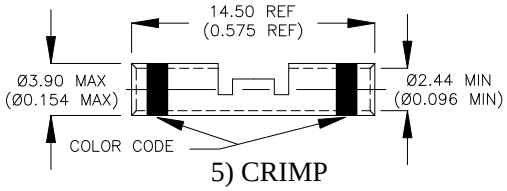
2) JUMPER BRAID



3) SOLDERSLEEVE



4) INSULATION SLEEVE



5) CRIMP

MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent clear, modified polytetrafluorethylene with meltable liner. Qty: 1
2. JUMPER BRAID: Nickel-plated copper alloy. Qty: 1
3. SOLDERSLEEVE: 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 Item 3: Grey
4. INSULATION SLEEVE: Heat-shrinkable, transparent clear, modified polytetrafluorethylene with meltable liner. Qty: 3
5. CRIMP SPLICE: Nickel-plated copper alloy. Yellow color code. Qty: 3
   BASE METAL: Copper Alloy 101 or 102
   PLATING: Ductile Nickel per SAE-AMS-QQ-N-290.

APPLICATION

1. This kit is used to provide an environmentally protected 1 to 1 splice in shielded cables.
   One cable must have three AWG 16, and second cable three AWG 14 nickel-plated primaries. Both cables must have nickel plated shield and PTFE jacket.
2. Temperature range: -55°C to +200°C.

TE Connectivity			TITLE: SHIELDED CABLE SPLICE, FLEXIBLE, NI-PLATED BRAID AND CRIMP, 200 DEG C		
Unless otherwise specified dimensions are in millimeters.[Inches dimensions are shown in brackets]	Raychem Devices		DOCUMENT NO.: D-150-0351		
TOLERANCES: 0.00 ± 0.15 MM 0.0 ± 0.2 MM 0 ± 0.5 MM	ANGLES: ± 0°30' ROUGHNESS IN MICRON	Tyco Electronics Corporation reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.	REV: A	DATE: August 12, 2011	
PREPARED BY: *YNGUYEN*	CAGE CODE: 06090	ECO NUMBER: ECO-11-017112	SCALE: NTS	SIZE: A	SHEET: 1 of 2

CUSTOMER DRAWING

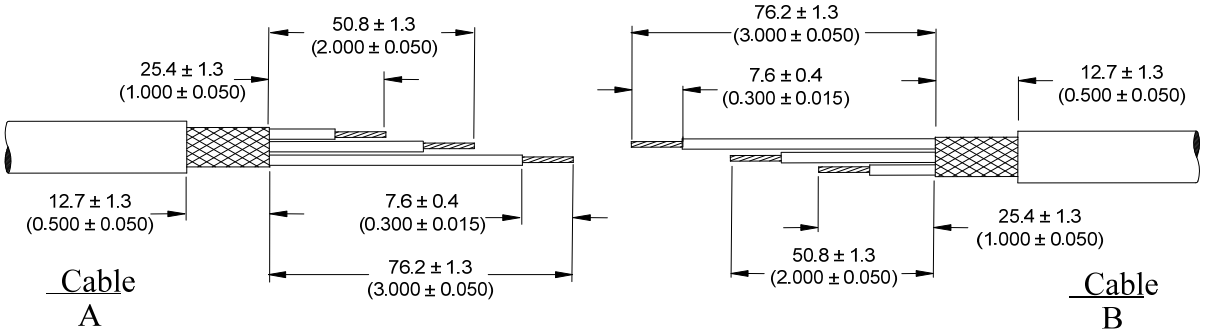
INSTALLATION PROCEDURE

***WARNING*:** Use adequate ventilation and avoid charring or burning during installation. Charring or burning of the product will produce fumes that may cause eye, skin, nose and throat irritation.

1. Cable preparation.

Cable A: Triax Twisted AWG 16 Shielded Cable
Cable B: Triax Twisted AWG 14 Shielded Cable

Strip the cables as shown;



2. Assemble components onto cables.
   - 2-1. Place the Outer Sealing Sleeve (Item 1) onto cable (B).
   - 2-2. Place one SolderSleeve Item 3 onto cable (A), place the other SolderSleeve Item 3 onto cable (B). Load sleeves small end first.
   - 2-3. Cut off the fused ends of the jumper braid (Item 2) and place it onto cable (A).
   - 2-4. Install a crimp barrel (Item 5) onto the two shortest primary conductors of cable (A), and one onto shortest primary conductor of cable (B). Use a calibrated Raychem AD-1377 crimp tool.
   - 2-5. Place one sleeve (Item 4) onto the long primary of cable (A) and two other sleeves over longest primaries of cable (B).
   - 2-6. Crimp matching primaries together.

***WARNING*:** **The heating tool and the assembly become hot during the installation of the Sleeves. To prevent burns, allow tool and the assembly to cool down before handling.**

   - 2-7. Center the sleeves (Item 4) over the crimp splices and heat starting from the center, until the liner melts and the sleeves recover. 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 (Item 2) so that the trailing end just clears the jacket of cable (A). Twist this end down onto the cable shield.
   - 2-9. Position the SolderSleeve (Item 3) so that the edge of the solder preform is 2.5mm (0.100 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 re-solidify before handling.
   - 2-10. Pull jumper braid (Item 2) tightly across the splice and twist it down onto the cable (B) shield. Cut off any braid that overlaps the cable jackets. Repeat step 9, using the other SolderSleeve (Item 3) to terminate jumper braid.
   - 2-12. Center Outer Sealing Sleeve (Item 1) over the assembly. 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. Apply heat at ends of the Sealing Sleeve long enough to fully shrink it and have adhesive liner melt and flow.