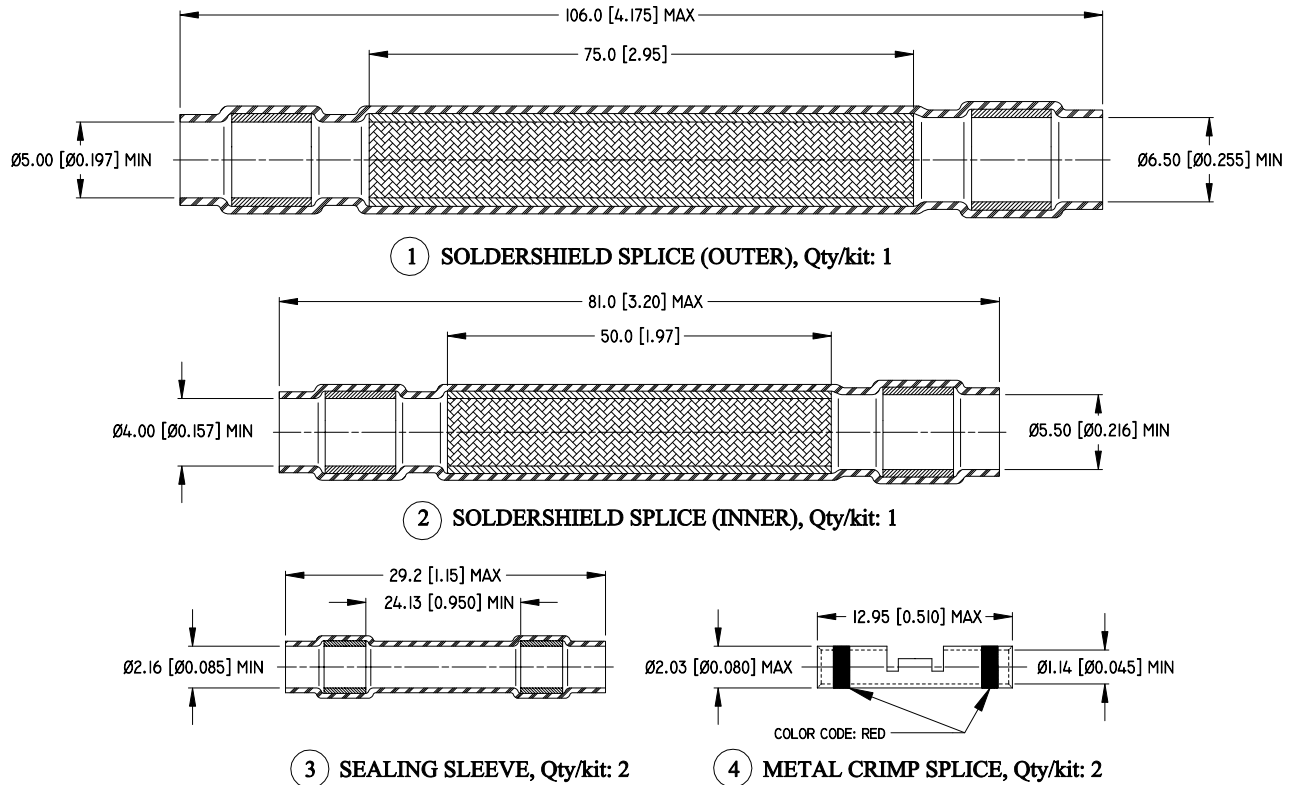


SPECIFICATION CONTROL DRAWING



MATERIALS

1. & 2. SOLDERSHIELD SPLICE (OUTER & INNER):

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

SHIELD: Solder impregnated, flux coated, nickel-plated copper braid.

SOLDER: TYPE Sn96 per ANSI-J-STD-006.

FLUX: TYPE ROM1 per ANSI-J-STD-004.

MELTABLE RINGS: Thermally stabilized thermoplastic. Color: gray.

3. SEALING SLEEVE: Qty: 2

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

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

4. CRIMP SPLICE: Nickel-plated copper alloy. Color code: red, Qty: 2

BASE METAL: Copper Alloy 101 or 102 per ASTM B-75.

PLATING: Ni-plated per SAE AMS-QQ-N-290.

APPLICATION

1. This kit is used to provide an environmentally protected 1 to 1 splice in double shielded pair cables with 26 – 22 AWG primaries. They may be used in harnesses where the cable temperature does not exceed 175°C.

Cable jacket diameter: Outer - 4.5 [0.177] max; Inner – 3.80 [0.150] max

Cable shield diameter: Outer – 2.5 [0.098] min; Inner – 2.0 [0.080] min

2. Temperature range: -55°C to +175°C.

		Tyco Electronics 300 Constitution Dr Menlo Park, CA 94025, U.S.A.		TITLE: DOUBLE SHIELDED PAIR, CABLE 1 TO1 SOLDERSHIELD SPLICE KIT, RIGID, NI-PLATED BRAID AND CRIMP		
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]		<i>Raychem</i>		DOCUMENT NO.: D-150-0326		
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: B	DATE: 22-Mar-07	
DRAWN BY: P.TALLY	CAGE CODE: 06090	REPLACES: D040109	ECO NUMBER: 07-006791	SCALE: NTS	SIZE: A	SHEET: 1 of 2

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SPECIFICATION CONTROL DRAWING

INSTALLATION PROCEDURE

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

1. Cable preparation. See figure below.

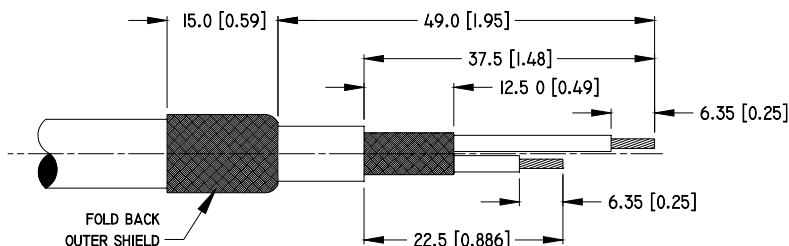
Tolerances: All lengths ± 0.50 (0.025).

The short primary on cable side A is to be connected to the long primary on cable side B.

For purposes of clarity, one of the cables to be spliced shall be "Cable A" and the other shall be "Cable B".

a). Prepare both cables.

1. Remove outer jacket 49.0 [1.93].
2. Trim outer shield to 15.0 [0.59] length and fold back over outer jacket.
3. Remove inner jacket to 37.5 [1.48] from cable end.
5. Trim inner shield to 12.5 [0.49] length from inner jacket.
6. Cut one primary 22.5 [0.886] from inner jacket.
6. Strip primary wires to 6.35 (0.25).



2. Application Equipment:

- a) AD-1377 crimp tool or equivalent.
- b) Steinel HL1802E Heat Gun with a SolderSleeve reflector (Setting of 13 – 14)

3. Assembly Procedure

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.

- a) Slide the outer SolderShield splice (larger of two splices), then the inner SolderShield splice (smaller of two splices) on Cable A. Slide splices on smaller end first (to aid in final positioning). Install Cable A primary wire into crimp barrel using a Tyco Electronics / Raychem AD-1377 crimp tool. Repeat for the other wire.

- b) Slide the Sealing sleeves, one each primary on Cable A beyond crimp barrels.

NOTE: Make sure that four sleeves (two for crimp plus two shield splices) have been prepositioned on Cable A side.

- c) Crimp Cable B side of primary wires.

- d) Center Sealing sleeve over crimp barrel and shrink until sealing inserts melt and flow. Use Steinel HL1802E Heat Gun with an appropriate SolderSleeve reflector

Caution: Do not overheat adjacent wires when using heat gun.

- e) Center inner SolderShield over sleeve and shrink until both solder and sealing inserts melt and flow. To shrink, begin in the center and heat until solder melts and sleeve recovers. After center section of SolderShield has melted and recovered, move assembly through heat towards one end slowly enough to keep solder melting and sleeve recovering; after doing one end, move heat toward other end.

- f) Fold outer shield back into place over the end of the inner splice. Then center outer SolderShield over the inner splice. And outer shield ends and shrink as in (e) above.

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

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