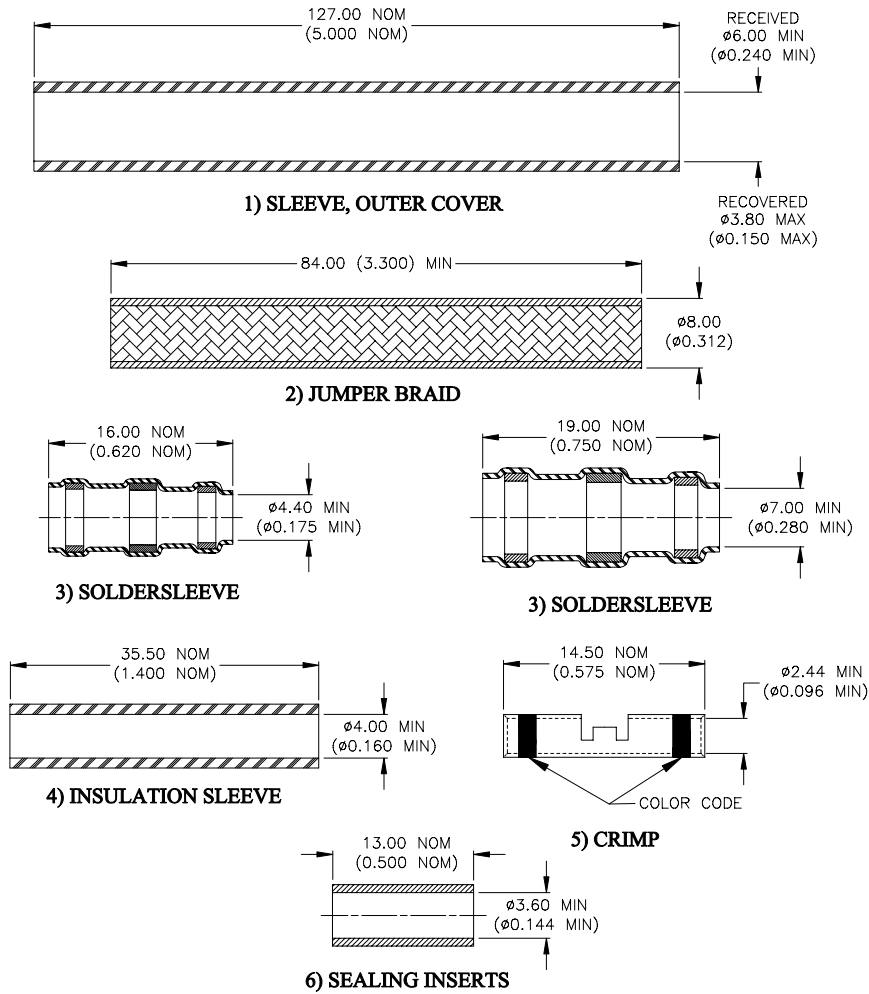


## SPECIFICATION CONTROL DRAWING



### MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent clear, modified polytetrafluorethylene with meltable liner.
2. JUMPER BRAID: Nickel-plated copper alloy.
3. SOLDER SLEEVES: 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: red/blue.
4. INSULATION SLEEVE: Heat-shrinkable, transparent clear, modified polytetrafluorethylene with meltable liner.
5. CRIMP SPLICE: Nickel-plated copper alloy. Yellow color code.  
 BASE METAL: Copper Alloy 101 or 102  
 PLATING: Ductile Nickel per SAE-AMS-QQ-N-290.
6. SEALING INSERTS: Meltable liner. Qty: 2

### APPLICATION

1. This is used to provide an environmentally protected 2 to 1 splice in shielded cables.  
 Cable usage parameters:  
 Cable must have one size 20AWG or 18AWG nickel-plated primary, nickel-plated shield and PTFE jacket.
2. Temperature range: -55°C to +200°C.

<b>tyco</b> <i>Electronics</i>	Tyco Electronics Corporation 300 Constitution Drive, Menlo Park, CA. 94025, U.S.A.	<i>Raychem</i>	TITLE: <b>SHIELDED SINGLE CABLE 2 TO 1 SPLICE ENGINE HARNESS, 200deg. C</b>			
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]			DOCUMENT NO.: <b>D-150-0251</b>			
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.		DOC. ISSUE: <b>3</b>	DATE: <b>22-May-03</b>	
DRAWN BY: <b>M. FORONDA</b>	CAGE CODE: <b>06090</b>			REPLACES: <b>D010314</b>	DCR NUMBER: <b>D030287</b>	PROD. REV.: <b>C</b>
				SHEET: <b>1 of 2</b>		

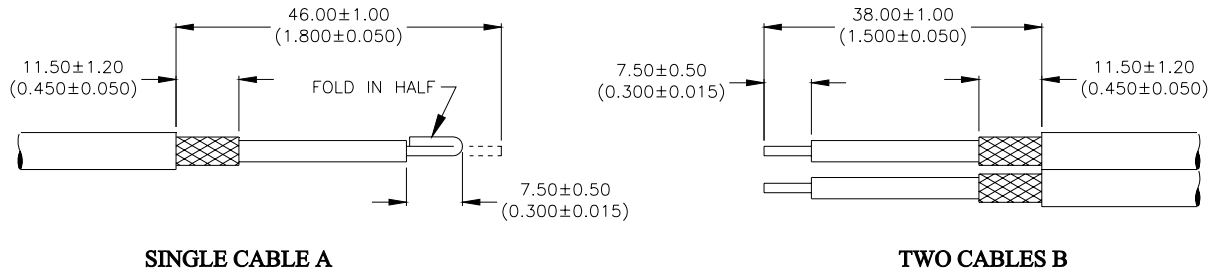
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# SPECIFICATION CONTROL DRAWING

## INSTALLATION PROCEDURE

### 1. Cable preparation.

Strip the cables as shown:



### 2. Assemble components onto cable.

- 2-1. Place one sealing insert (6) onto cable (A) and one onto cables (B).
- 2-2. Place the sleeve (1) onto cable (A).
- 2-3. Place both the Soldersleeve (3) onto cable (A), larger sleeve should be loaded first.
- 2-4. Cut off the fused ends of the jumper braid (2) and place it onto cable (A).
- 2-5. Place the sleeve (4) onto cable (A).
- 2-6. Crimp primaries together. Use a calibrated Raychem AD-1337 crimp tool.
- 2-7. Center the sleeve (4) over the crimp splice and heat starting from the center, until the 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.
- 2-8. Position the jumper braid (2) so that the trailing end just clears the jacket of the cable (A). Twist this end down onto the cable shield.
- 2-9. Position the smaller Soldersleeve so that the edge of the solder preform is 2.5mm (0.100 inch) past 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 resolidify before handling.
- 2-10. Pull jumper braid (2) tightly across the splice and twist it down onto the cables (B). Cut off any braid that overlaps the cable jackets. Repeat step 9 with large Soldersleeve.
- 2-11. Position the sealing inserts (6) adjacent to the end of the Soldersleeve terminations.
- 2-12. Center the sleeve (1) over the assembly. Sleeve should overlap the sealing inserts at each end. 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 sleeve long enough to melt the sealing inserts.

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DRAWN BY: M. FORONDA		CAGE CODE: 06090		REPLACES: D010314		DCR NUMBER: D030287		PROD. REV.: C	
						SCALE: None		SIZE: A	
								SHEET: 2 of 2	

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