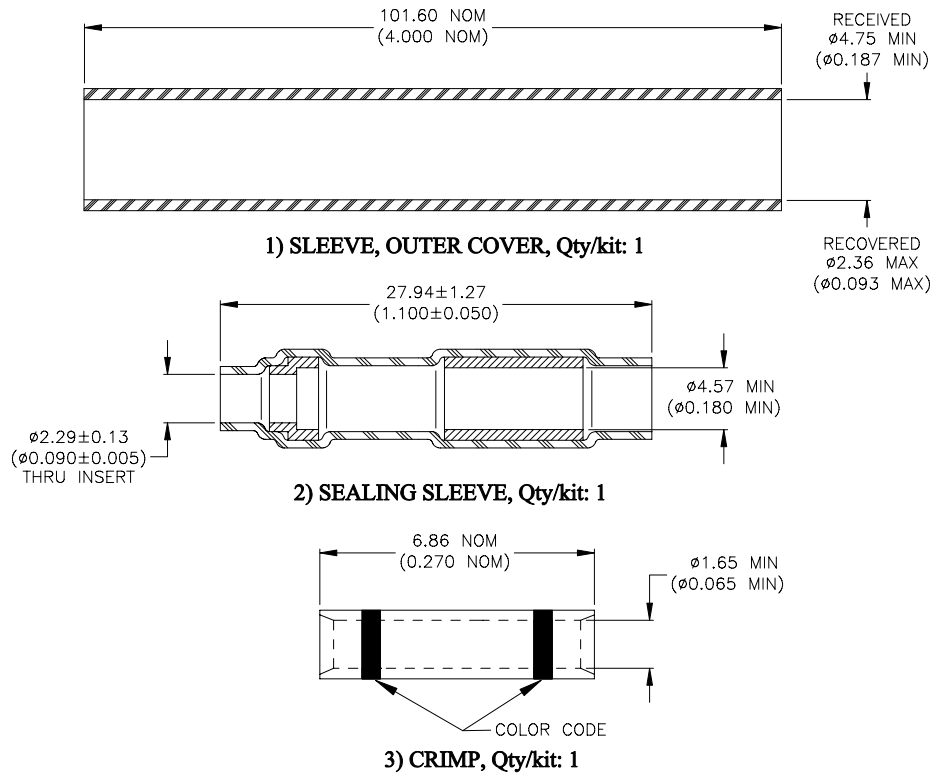


SPECIFICATION CONTROL DRAWING



MATERIALS

1. OUTER INSULATION SLEEVE: Heat-shrinkable, radiation cross-linked fluoroelastomer. Color: black.
2. SEALING SLEEVE:
INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
SEALING RINGS: Fluorocarbon-based thermoplastic. Color: natural.
3. CRIMP SPLICE: Nickel-plated copper alloy. Color code: blue.
BASE METAL: Copper Alloy 101 or 102 per ASTM B-75.
PLATING: Ductile Nickel per QQ-N-290.

APPLICATION

1. This kit is used to provide an environmentally protected stub splice in cables having nickel-plated shield and conductors, and having an insulation rated for at least 135°C, (eg. 1-Raychem 55PC2126-22-9/0-9).
Primary: Total CMA: 779 – 2680
Jacket diameter: 4.74 (0.187) max.
2. Temperature range: -55°C to +175°C.

<div><div>tyco</div><div>Electronics</div></div>		<div><div>Raychem Products</div><div>305 Constitution Drive Menlo Park, CA 94025, USA</div></div>		<div>TITLE : TWISTED PAIR STUB SPLICE KIT, MEDIUM, Ni-PLATED CRIMP</div>			
Unless otherwise specified dimensions are in millimeters. Inches dimensions are in between brackets.				DOCUMENT NO.: D-150-0311			
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.		DCR NUMBER: D020254		REPLACES: D010301	
DRAWN BY: mforonda		DATE: 18-Jul-02	PROD. REV. A	DOC ISSUE: 1	SCALE: None	SIZE: A	SHEET: 1 of 2

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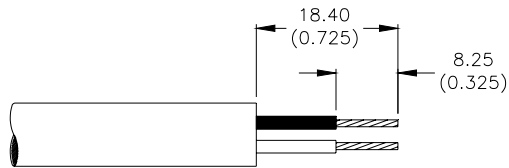
SPECIFICATION CONTROL DRAWING

INSTALLATION PROCEDURE

1. Cable preparation. See figure below.

Tolerances: All lengths ± 0.50 (0.020)

- a) Remove cable jacket and shield: 18.40 (0.725)
- b) Strip primaries: 8.40 (0.325)



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



- a) Place the tubing on one end of the assembly.
- b) Primary conductor splice:
 - 1) Crimp the primaries together using the stub crimp splice. Use a calibrated Raychem AD-1377 crimp tool or equivalent.
 - 2) Position the sealing sleeve over the splice.
 - 3) Apply heat to the center of the sleeve until it recovers, and then heat ends until sealing rings melt and flow along wires.
- c) Position the outer sleeve to overlap the splice and apply heat to shrink the tubing.
- d) Inspection:
 - 1) Conductors must be visible at point where they enter the crimp barrel.
 - 2) Both indentations of a crimp must be on the crimp barrel.
 - 3) Sealing sleeve inserts must have flowed along wire insulation.
 - 4) Sleeve must not have discolored to the degree that the crimp barrel cannot be inspected.
 - 5) Sleeve must not be cut or split.

Unless otherwise specified dimensions are in millimeters. (Inches dimensions are in between brackets).

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