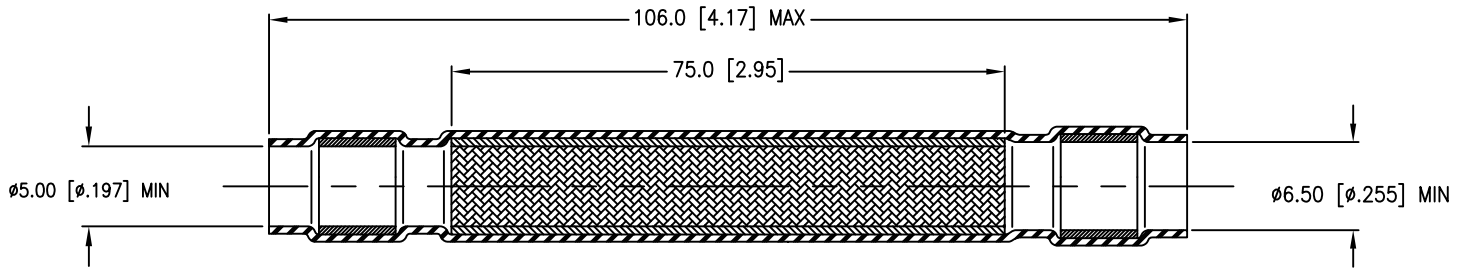
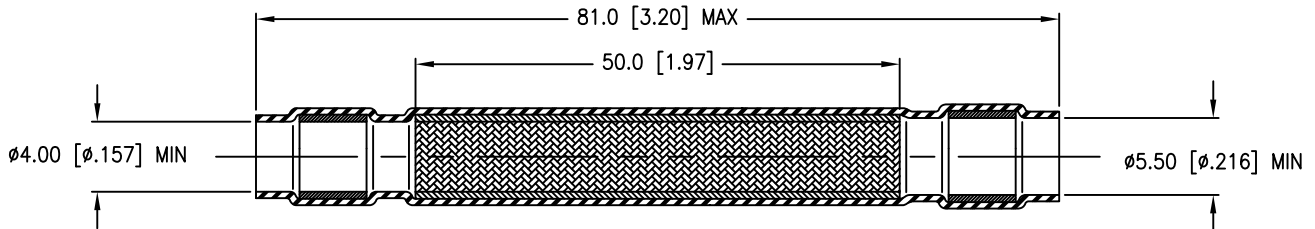


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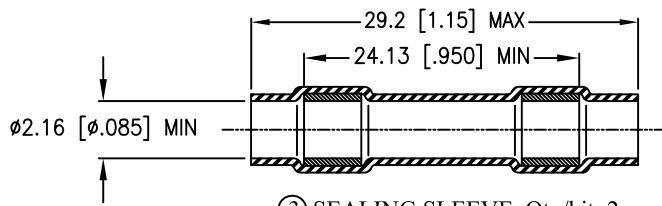
REVISION			
LTR	DESCRIPTION	DATE	APPROVED
B	REVISED PER ECO-07-006791	03/22/2007	L. RODRIGUEZ
B1	REVISED PER ECO-15-016061	11/06/2015	L. RODRIGUEZ



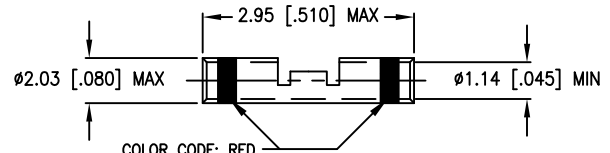
① SOLDERSHIELD SPLICE (OUTER), Qty/kit: 1



② SOLDERSHIELD SPLICE (INNER), Qty/kit: 1



③ SEALING SLEEVE, Qty/kit: 2



④ METAL CRIMP SPLICE, Qty/kit: 2

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.

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Raychem Devices
 CUSTOMER DRAWING

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS. REFERENCE DIMENSIONS ARE IN BRACKETS [inches].	DRAWN: P. TALLY	DATE: 02/11/2007		TE Connectivity
	REDRAWN: T. NGUYEN	DATE: 11/05/2015		
DECIMALS TOLERANCES: 0.00 ± N/A 0.0 ± N/A 0. ± N/A	APPROVED: L. RODRIGUEZ	DATE: 11/06/2015	TITLE: DOUBLE SHIELDED PAIR, CABLE 1 TO 1 SOLDERSHIELD SPLICE KIT, RIGID, NI-PLATED BRAID AND CRIMP	
	MATERIAL: SEE NOTES	RPN: N/A		
ANGLES TOLERANCE: ± N/A	CAD FILE: D-150-0326.dwg	THIRD ANGLE PROJECTION: 	SIZE: A	SHEET: 1 OF 2
SCALE: DO NOT SCALE THIS DRAWING			CAGE CODE: 06090	DRAWING NO: D-150-0326
				REV. B1

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.

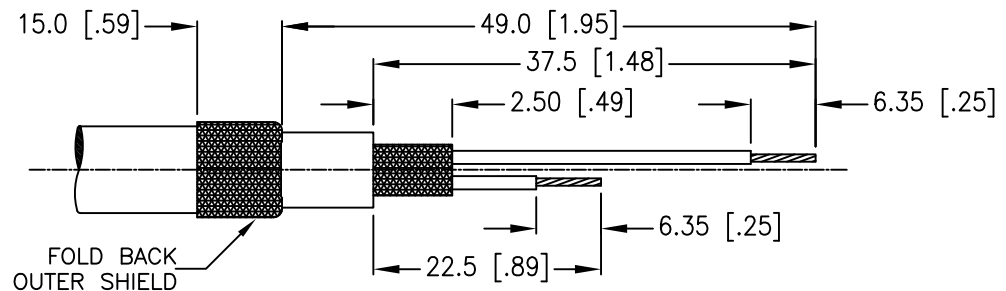
Tolerances: All lengths ± 0.50 (.025).

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 [.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 [.49] length from inner jacket.
6. Cut one primary 22.5 [.89] from inner jacket.
6. Strip primary wires to 6.35 (.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 TE Connectivity / 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.

TE PROPRIETARY INFORMATION

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CUSTOMER DRAWINGDO NOT
SCALE THIS
DRAWING

SIZE:	CAGE CODE:	SHEET:
A	06090	2 OF 2

DOCUMENT NO:

D-150-0326

REV.
B1