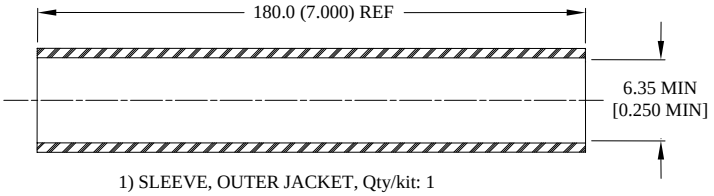
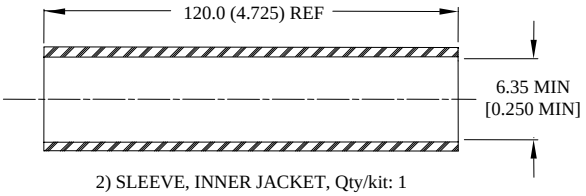
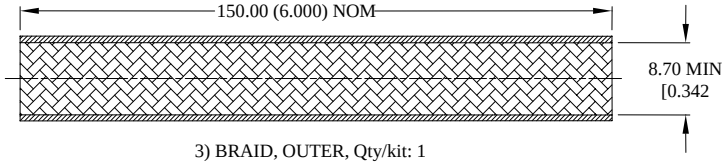
# SPECIFICATION CONTROL DRAWING



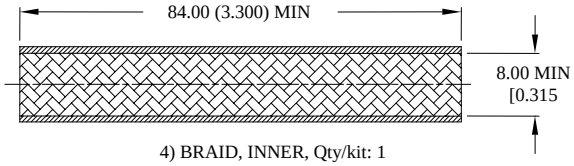

1) SLEEVE, OUTER JACKET, Qty/kit: 1



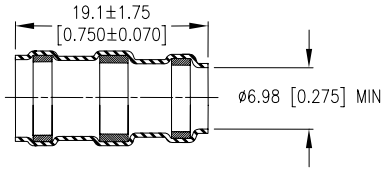

2) SLEEVE, INNER JACKET, Qty/kit: 1



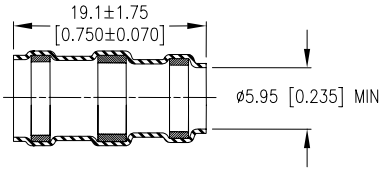

3) BRAID, OUTER, Qty/kit: 1



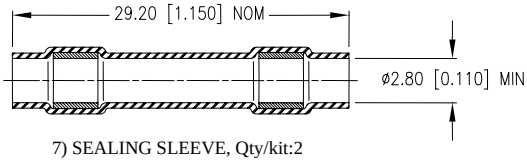

4) BRAID, INNER, Qty/kit: 1



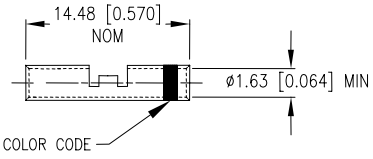

5) SOLDERSLEEVE, Qty/kit: 2




6) SOLDERSLEEVE, Qty/kit: 2




7) SEALING SLEEVE, Qty/kit:2




8) CRIMP, Qty/kit: 2

**MATERIALS**

1. & 2. INSULATION SLEEVE: Heat-shrinkable, radiation cross-linked modified fluoropolymer. Color: black.
3. & 4. BRAID: Tin-plated copper alloy.
5. & 6. SOLDERSLEEVE: Qty: 2
   INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
   SOLDER PREFORM WITH FLUX AND THERMAL INDICATOR:
   SOLDER: TYPE Sn63 per ANSI/J-STD-006.
   FLUX: TYPE ROL1 per ANSI/J-STD-004.
   THERMAL INDICATOR: Fusible ring, Melt point: 221°C.
   MELTABLE RINGS: Environment resistant thermoplastic. Color: blue.
7. CRIMP SPLICE: Tin-plated copper alloy. Color code: blue, Qty: 2
   BASE METAL: Copper Alloy 101 or 102 per ASTM B-75M.
   PLATING: Tin per ASTM B545, Class A.
8. 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 blue.

| | | | | | | |
|---|---|---|---|---|---|---|
| tyco Electronics | Tyco Electronics Corporation<br>300 Constitution Drive,<br>Menlo Park, CA. 94025, U.S.A. | Raychem | TITLE:<br>2-TO-1 SHIELDED TWISTED PAIR,<br>FLEXIBLE SOLDERSHIELD SPLICE KIT,<br>TIN-PLATED CRIMP AND BRAID | | | |
| Unless otherwise specified dimensions are in millimeters.<br>[Inches dimensions are shown in brackets] | | | DOCUMENT NO.:<br>**D-150-0340** | | | |
| TOLERANCES:<br>0.00 N/A<br>0.0 N/A<br>0 N/A | ANGLES: N/A<br><br>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.:<br>A | DATE:<br>20-Oct-06 | | |
| PREPARED BY:<br>Luis Rodriguez | DCR NUMBER:<br>D060318 | REPLACES:<br>---- | CAGE CODE :<br>06090 | SCALE:<br>--- | SIZE:<br>A | SHEET:<br>1 of 3 |

# SPECIFICATION CONTROL DRAWING

**APPLICATION**

1. This kit is used to provide an environmentally protected 2 to 1 splice in twisted shielded cables having tin or silver-plated primaries and shield, and having an insulation rated for at least 125°C, (eg. Tyco Electronics 55A8113-22-*).
2. Temperature range: -55°C to +150°C.

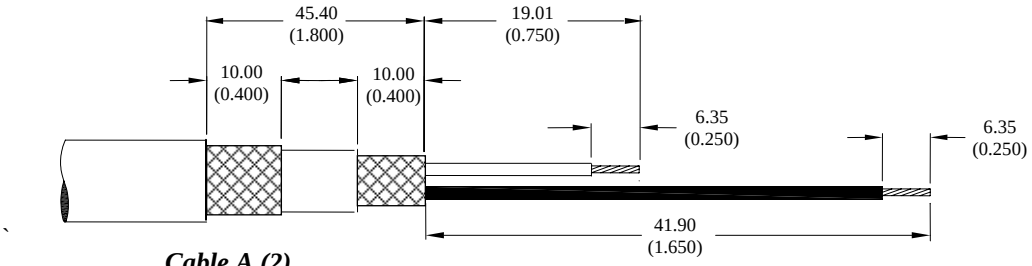
**CABLE PREPARATION AND INSTALLATION PROCEDURE**

Application Equipment:

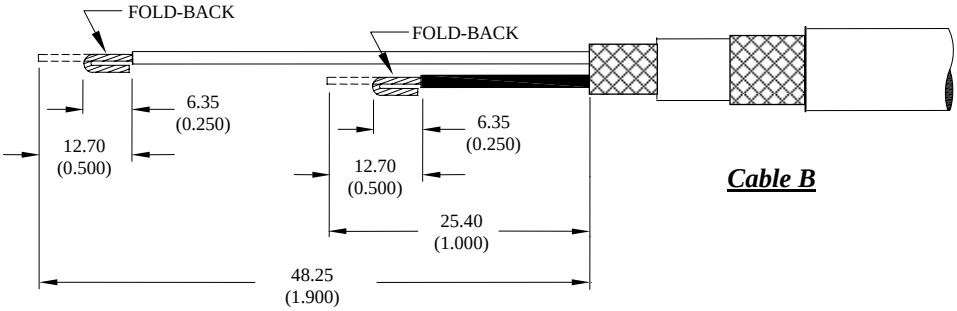
a) AD-1377 crimp tool or equivalent.
b) Steinel HG2310 LCD or equivalent Heat Gun with a soldersleeve reflector

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

1. Prepare all cables as shown below.
   a. Remove outer jacket, outer shield, inner jacket, and inner shield 41.90 (1.650) for Cable A, 48.25 for Cable B.
   b. Cut one of the primary conductors on each Cable; 19.01 mm (0.750) for Cable A, 25.40 mm (1.000) for Cable B. Short primary conductor on Cable A must be left uncut on Cable B.
   c. Strip primary conductors 6.35 (0.250) for Cable A. Strip primary conductors 12.70 (0.500) and fold back for Cable B.
   d. Remove outer jacket 45.40 (1.800)
   e. Trim outer shield to 10.16 (0.400) length.
   f. Remove inner jacket 10.00 (0.400)

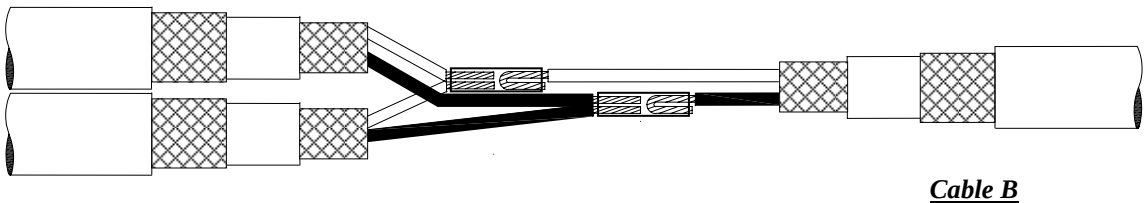



***Cable A (2)***




***Cable B***

2. Slide outer and inner sleeve, soldersleeves (Item 6), outer and inner braids on Cable B.
3. Slide soldersleeves (Item 5) on top of both Cable A. Soldersleeves shall hold cables together.
4. Slide one of the sealing sleeves onto longer conductor on Cable B. Slide second sealing sleeve onto 2 longest conductors of Cable A.
5. Crimp conductors as shown below.



***Cable B***

***Cable A***

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

| DOCUMENT NO.: | DCR NUMBER: | CAGE CODE : | REV.: | DATE: | SHEET: |
|---|---|---|---|---|---|
| D-150-0340 | D060318 | 06090 | A | 20-Oct-06 | 2 of 3 |

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

4. Center Sealing sleeve over crimp barrel and shrink until sealing inserts melt and flow. Use Steinel HG2310 LCD Heat Gun with an appropriate soldersleeve reflector.
5. Center inner braid over cable so one side of the braid overlaps exposed cable inner shield. Slide one of the soldersleeves (Item 6) on top of the end of the braid. Apply heat to the soldersleeve until the tubing shrinks, and the solder melts and flow.
6. Position second soldersleeve on second end of the inner braid. If required, trim any excess of braid in length. Apply heat to the soldersleeve until the tubing shrinks, and the solder melts and flow.
7. Slide and center inner sleeve. Apply heat until the inner sleeve completely shrinks and insulates inner braid.
8. Center outer braid over cable so one side of the braid overlaps exposed cable outer shield. Slide one of the soldersleeves (Item 5) on top of the end of the braid. Apply heat to the soldersleeve until the tubing shrinks, and the solder melts and flow.
9. Position second soldersleeve on second end of the outer braid. If required, trim any excess of braid in length. Apply heat to the soldersleeve until the tubing shrinks, and the solder melts and flow.
10. Slide and center outer sleeve. Apply heat until the outer sleeve completely shrinks and insulates outer braid.