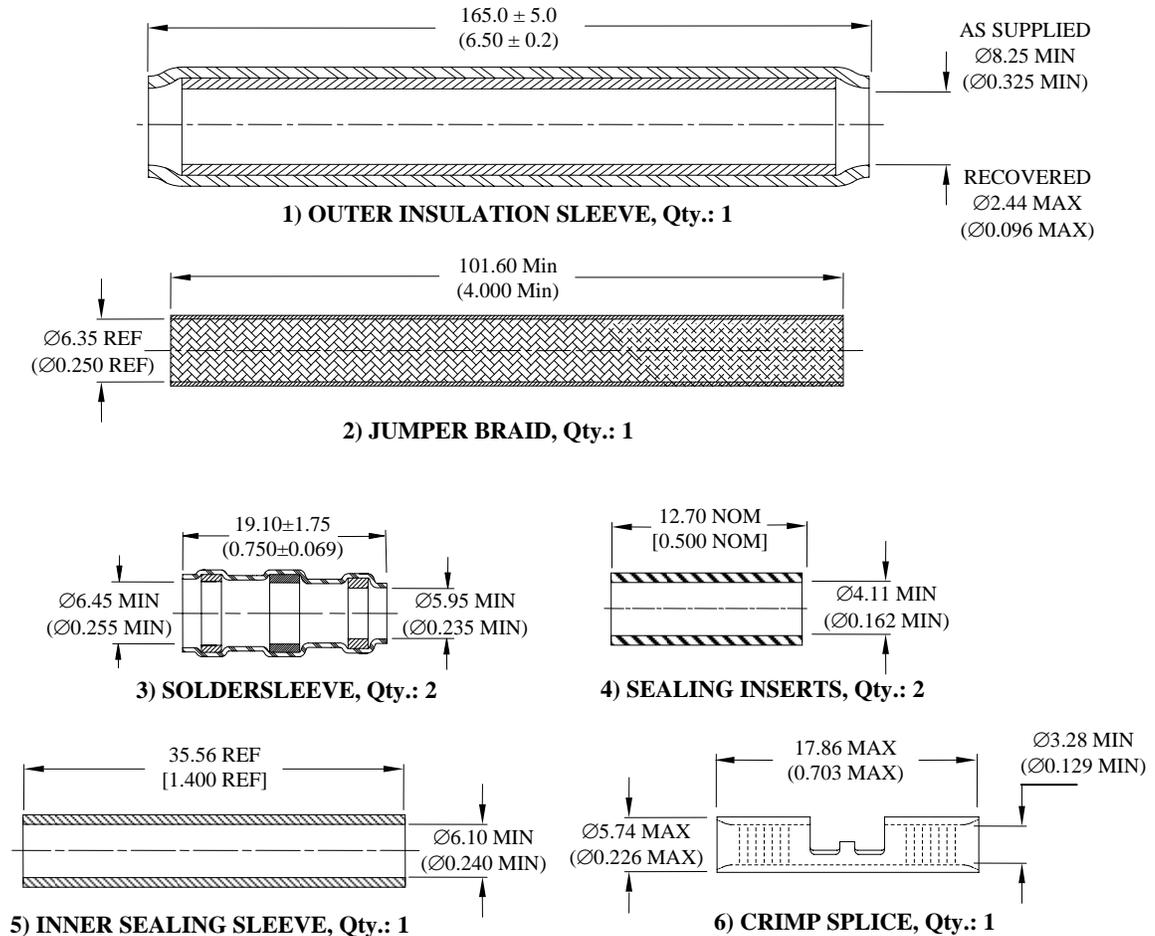


## CUSTOMER DRAWING



### MATERIALS

1. OUTER INSULATION SLEEVE:  
 INSULATION SLEEVE: Heat-shrinkable, transparent clear, modified polytetrafluorethylene  
 MELTABLE RING: meltable clear fluorinated ethylene propylene
2. JUMPER BRAID: Nickel-plated copper alloy
3. SOLDERSLEEVE: Qty.: 2  
 INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride  
 SOLDER PREFORM WITH FLUX:  
 SOLDER: TYPE Sn96 per ANSI / J-STD-006.  
 FLUX: TYPE ROM1 per ANSI / J-STD-004.
4. SEALING INSERTS: Qty.: 2; Meltable liner.
5. INNER SEALING SLEEVE: Heat-shrinkable, transparent clear, modified polytetrafluorethylene with meltable liner
6. CRIMP SPLICE: Ni-plated copper.  
 Base Metal: Copper Alloy 101 or 102 per ASTM B-75.  
 Plating: Nickel per SAE AMS-QQ-N-290.

		300 Constitution Dr Menlo Park, CA 94025, U.S.A.	TITLE: <b>SHIELDED CABLE SPLICE, FLEXIBLE, Ni-PLATED BRAID AND CRIMP, 200 DEG C</b>		
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]		Raychem Devices	DOCUMENT NO.: <b>D-150-0349</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.		REV:	DATE:
REVISED BY: <i>UNGUYEN</i>	CAGE CODE: 06090			ECO NUMBER: ECO-09-013095	D
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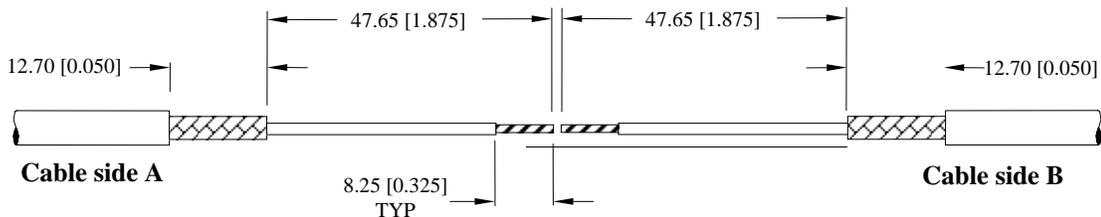
# CUSTOMER DRAWING

## APPLICATION

1. These Cable Splice kits may be used to obtain an immersion resistant cable splice. Both conductors and shield shall be nickel-plated and cables must be rated for not less than 150°C.
2. Temperature rating: -65°C to + 200°C.
3. Install using a Raychem-approved hot-air heaters or equivalent. Use Tyco Electronics AMP 46447 to crimp inner conductors

## INSTALLATION PROCEDURE

1. Cable preparation. See figure below.  
Tolerances: All lengths  $\pm 0.50$  (0.020)
  - a) Remove cable jacket and shield: 47.65 (1.875)
  - b) Strip all conductors: 8.25 (0.325)
  - c) Remove cable jacket to exposed braid: 12.70 (0.500)



2. Application Equipment
  - a) AMP-46447 crimp tool or equivalent.
  - b) CV-1981 Heat Gun with a Shield Terminator reflector PR 34. Setting at 8-9 (375-450° C)
3. Assembly Procedure
  - a) Place the Outer Insulation Sleeve (Item 1) on one end of the assembly.
  - b) Place each Shield Terminators (Item 3) on each cable side. Smaller ID shall be facing cable.
  - c) Place the Ni-Plated Jumper Braid (Item 2) onto one of the cables to be spliced.
  - d) Primary Conductor Splice:
    - 1) Place insulation sleeve (Item 5) onto one of the conductors to be spliced.
    - 2) Crimp conductor into opposite end using a calibrated Tyco Electronics AMP 43447 crimp tool or equivalent.
    - 3) Center the insulation sleeves over the crimp splice.
    - 4) Apply heat to the insulation sleeve until it fully recovers.
  - e) 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) Insulation Sleeve must be fully recovered over crimp ferrule and conductors jacket.
    - 4) Sleeve must not be cut or split.
  - f) Jumper Braid:
    - 1) Center the Silver plated Jumper Braid over the splice and the exposed cable shields. Trim off excess length (as required) so that it will not cover the cable jacket. The jumper braid should overlap the cable braid.
    - 2) Position the Shield Terminator over the end of the Nickel Braid and onto the cable jacket.
    - 3) Heat Shield Terminator to the center of the solder pre-form until it melts, flows, and wets the cable shield. Apply heat on each end of the Shield Terminators until sealing rings melt and flow along cable jacket. Repeat for other Shield Terminator.
  - g) Position the Outer Sealing Sleeve and center to overlap the splice equally on each end and apply heat to shrink the tubing.

### Note:

Item 4 (Sealing Insert) should only be used on multiple conductors for sealing.

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

DOCUMENT NO.: <b>D-150-0349</b>	REV: D	ECO NUMBER: ECO-09-013095	DATE: June 2, 2009	SHEET: 2 of 2
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Print Date: 2-Jun-09

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