

**Installation Procedure For Soldersleeves
B-003-0X, B-058-0X, B-900-0X**

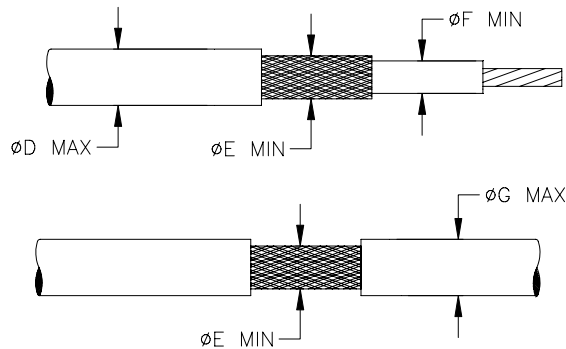
1. Selection Guide

	Product LT	Product MT
SIZE 1	B-003-00	B-058-00 B-900-01
SIZE 2	B-003-01	B-058-01 B-900-02
SIZE 3	B-003-02	B-058-02 B-900-03

LT: Low temperature application (125°C)

MT: Medium temperature application (150°C)

2. Cable Dimensions



Product	Cable Dimensions			
	øD max	øE min	øF min	øG max
SIZE 1	3.1 (0.122)	1.6 (0.063)	1.5 (0.060)	2.6 (0.102)
SIZE 2	4.9 (0.193)	2.2 (0.087)	2.1 (0.083)	4.4 (0.173)
SIZE 3	7.4 (0.291)	3.4 (0.134)	3.2 (0.126)	6.9 (0.272)

3. Application Equipment

Equivalent tools may be used.

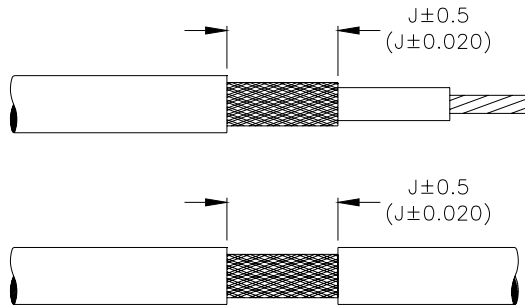
Product	Hot Air Installation	
	Reflector	Gun
SIZE 1	PR25	CV-1981 (220V OR 110V – 1460W) (*Setting: see below)
SIZE 2		
SIZE 3		

*Setting between 7.5 and 8 for product LT

Setting between 8 and 8.5 for product MT

4. Cable Preparation

4.1 Prepare the cable as shown:

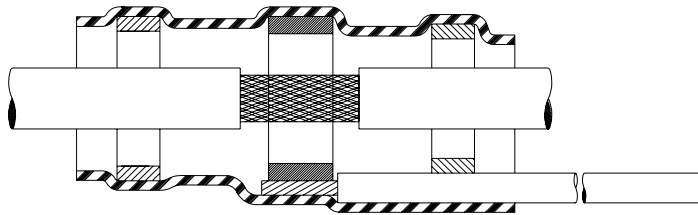


Product	J ± 0.5 (± 0.020)
SIZE 1	7.0 (0.276)
SIZE 2	7.0 (0.276)
SIZE 3	7.0 (0.276)

5. Assembly**WARNING**

Follow installation instructions carefully. 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. Consult Material Safety Data Sheets **RAY5103** or **RAY5104** for further information.

5.1 Slide the soldersleeve device over the exposed braid. Center the solder preform over the stripped area of cable as shown:



5.2 Heating procedure:

WARNING

The heating tool and the assembly become hot during the installation of the SolderSleeve. To prevent burns, allow tool and the assembly to cool down before handling.

Allow the hot air gun to reach its operating temperature. Place the assembly centrally in the appropriate reflector (see section 3). When heat is applied the tubing shrinks, the inserts melt, flow and form a seal. Continue heating until the solder melts and flows. A solder fillet between the ground lead and the cable braid must be visible.

Allow the assembly to cool down before handling.

6. Inspection

6.1 Inspection for proper assembly

- The exposed ground lead must not overlap the cable jacket.
- The insulation sleeve must overlap the cable jacket so that there is no expose braid.

6.2 Inspection for proper heating

- The solder perform must be completely melted and have flowed along the conductor.
- A solder fillet must be visible between the ground lead and the braid.
- Visible remnants of the original shape of the solder preform indicate an underheated termination.
- Lack of solder fillet indicates an overheated termination.
- The sleeve must be shrunk onto the cable jacket.
- An incompletely shrunk sleeve indicates an underheated termination.
- A discolored dark brown sleeve indicates an overheated termination.

6.3 Inspection for damage

- The sleeve must not be cut or split.
- There must be no braid poking through the sleeve.
- The cable jacket and the shield termination should not exhibit signs of mechanical damage or overheating such as cuts, melting, charring...

7. Repair (if necessary)

7.1 Repair of underheated termination.

- Reheat underheated termination to obtain proper solder flow (see section 5.2).

7.2 Repair of overheated termination.

Remove the shield termination as follows:

- Score the full length of the sleeve with a sharp blade. Be careful not to cut the cable or wire jacket.
- By using the same heating tool as for installation, heat the shield termination to soften it and strip it off with pliers or tweezers.
- Install a new shield termination in accordance with the procedure (see section 5).

DISCLAIMER

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