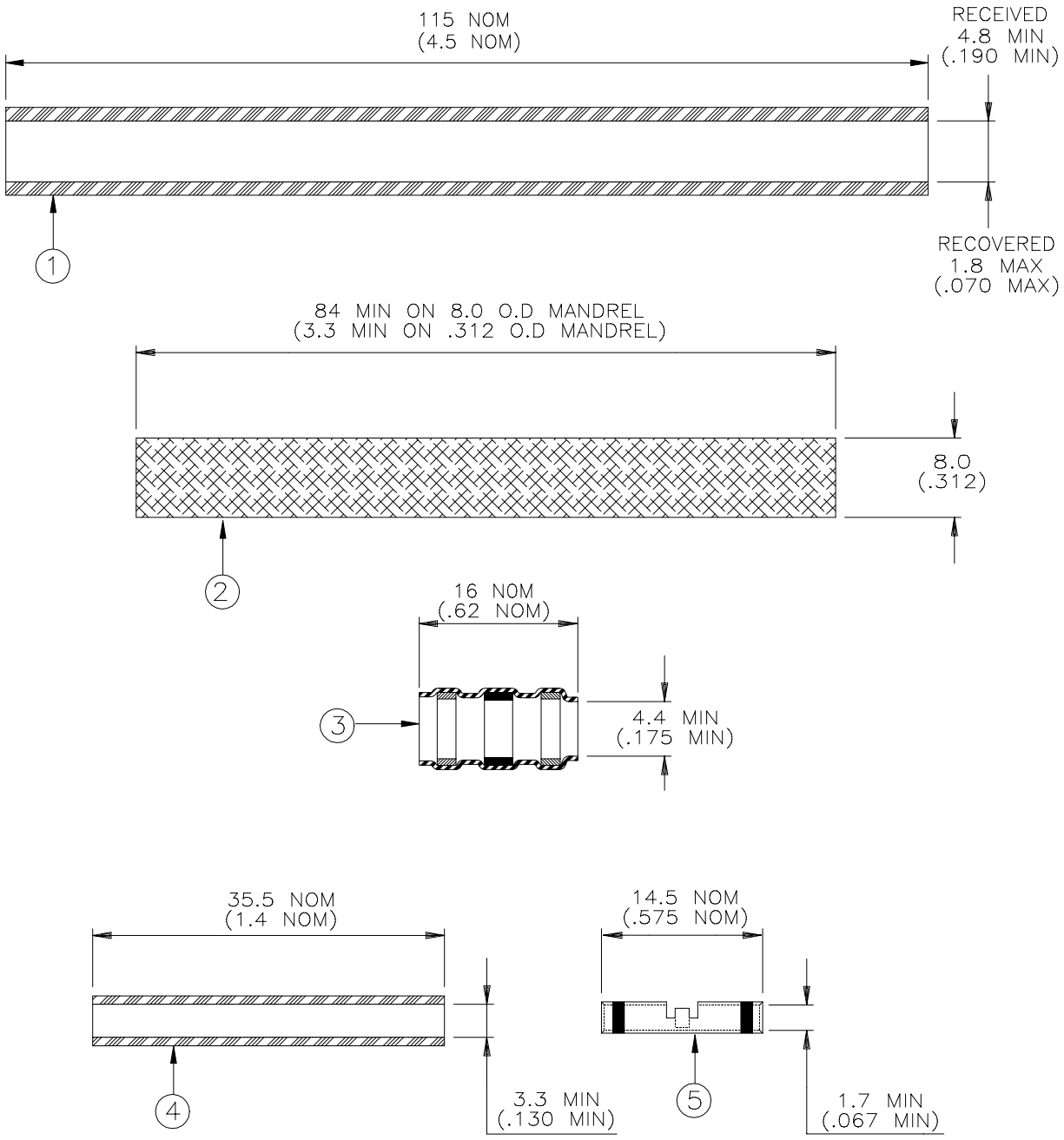
SPECIFICATION CONTROL DRAWING



MATERIALS

tyco Electronics	Tyco Electronics Corporation 300 Constitution Drive, Menlo Park, CA. 94025, U.S.A.	Raychem		TITLE: **Shielded Single Cable 1 to 1 Splice Engine Harness 200 Degrees Centigrade**			
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]				DOCUMENT NO.: **D-150-0250**			
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.		DOC. ISSUE: 1		DATE: 16-Oct-98	
DRAWN BY: M. FORONDA	CAGE CODE: 06090	REPLACES: D150250	DCR NUMBER: D981803	PROD. REV.: C	SCALE: None	SIZE: A	SHEET: 1 of 2

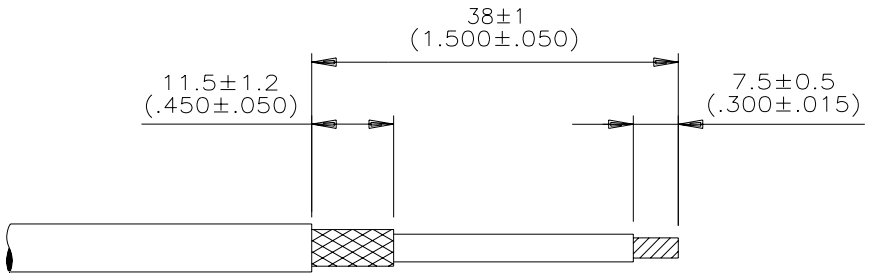
1. INSULATION SLEEVE: Heat-shrinkable, transparent clear, modified polytetrafluorethylene with meltable liner.
2. JUMPER BRAID: Nickel plated copper alloy.
3. SOLDERSLEEVE: Radiation cross-linked modified polyvinylidene fluoride sleeve. Qty: 2.
   SOLDER PREFORM WITH FLUX:
   SOLDER: TYPE Sn96 per ANSI-J-STD-006.
   FLUX: TYPE ROM1 per ANSI-J-STD-004.
   MELTABLE RINGS: Thermally stabilized thermoplastic. Color:red/blue.
4. INSULATION SLEEVE: Heat-shrinkable, transparent clear, modified polytetrafluorethylene with meltable liner.
5. CRIMP SPLICE: Nickel plated copper alloy. Blue color code.

APPLICATION

1. This kit is used to provide an environmentally protected 1 to 1 splice in shielded cables.
   Cable usage parameters:
   Cable must have one size 20 or 18 nickel plated primary, nickel plated shield and PTFE jacket.
2. Temperature range: -55°C to +200°C.

INSTALLATION PROCEDURE

1. Cable preparation.
   Strip the cables as shown;



For ease of description one cable to be spliced is designated as cable A and the other as cable B.

2. Assemble components onto cable.
   2-1. Place the sleeve (1) onto cable (A).
   2-2. Place one SolderSeeve (3)onto each cable.
   2-3. Cut off the fused ends of the jumper braid and place it onto cable (B).
   2-4. Place the sleeve (4) onto cable (B).
   2-5. Crimp primaries together. Use a calibrated Raychem AD-1377 crimp tool.
   2-6. Center the sleeve (4) over the crimp splice and heat starting from the center, until the liner melts and the sleeve recovers. When sleeve first starts to recover there will be longitudinal lines in the meltable liner, continue heating until these lines disappear.
   2-7. Position the jumper braid (2) so that the trailing end just clears the jacket of cable (B). Twist this end down onto the cable shield.
   2-8. Position the SolderSeeve so that the edge of the solder preform is 2.5mm (.100 inch) passed the cable jacket. Place the assembly in heater so that the solder preform is centered in the reflector. Apply heat until the solder melts and flows into the shield. Allow solder to resolidify before handling.
   2-9. Pull jumper braid (2) tightly across the splice and twist it down onto the cable (A). Cut off any braid that overlaps the cable jacket. Repeat step 8.
   2-10. Center the sleeve (1) over the assembly. Sleeve should overlap the cable jacket by about 25mm (1.0 inch) at each end. Heat this sleeve, starting in the center, until the inner liner melts and the sleeve recovers. When sleeve first starts to recover there will be longitudinal lines in the meltable liner, continue heating until these lines disappear.