1.0 Scope

This standard contains the procedures for installing the D-260-C-X RaySeal repair sleeves on cables as defined on the TE Customer Drawing.

2.0 References

TE Customer Drawing (TE CD) Series D-260-C-X

3.0 Application Equipment

Heating tool CV-2014 Hot Jet S (115 V) with PR-38B-Reflector

4.0 Kit components

RaySeal repair sleeve Kit Description
The TE Connectivity D-260-C-X Series consists of:

a) Outer repair sleeve for encapsulating the cable.
b) Abrasive cleaning pad, 2-inches square, for abrading cable.
c) Wet/Dry cleaning wipes for degreasing cable jacket.
d) PTFE tape #422, 1-inch width, 2-mil thick
e) Installation Guide.

5.0 Part Selection

Unless otherwise specified, dimensions are in inches (metric dimensions are in parentheses).

TABLE 1 (Reference)

Part Description	Cable Size	Cable OD	
		Minimum	Maximum
D-260-C-A	8, 10	.14 (3.5)	.20 (5.2)
D-260-C-B	4, 6	.23 (5.7)	.30 (7.8)
D-260-C-C	1/0, 2	.35 (9.0)	.46 (11.8)
D-260-C-D	3/0, 2/0	.49 (12.3)	.59 (15.0)
D-260-C-E	4/0	.59 (15.0)	.64 (16.3)

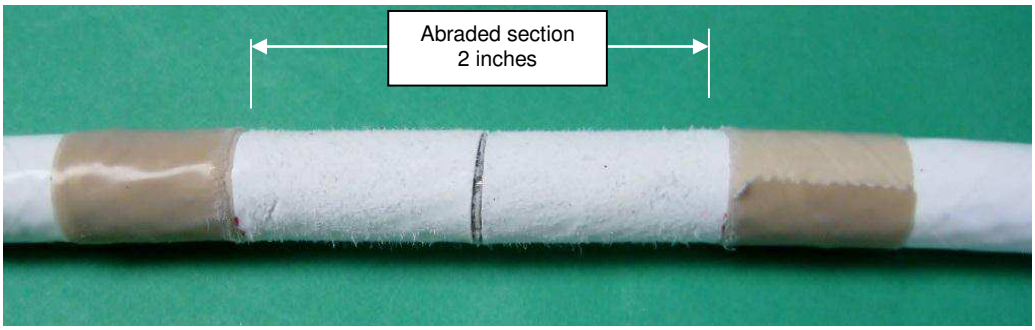
6.0 Procedure

WARNING

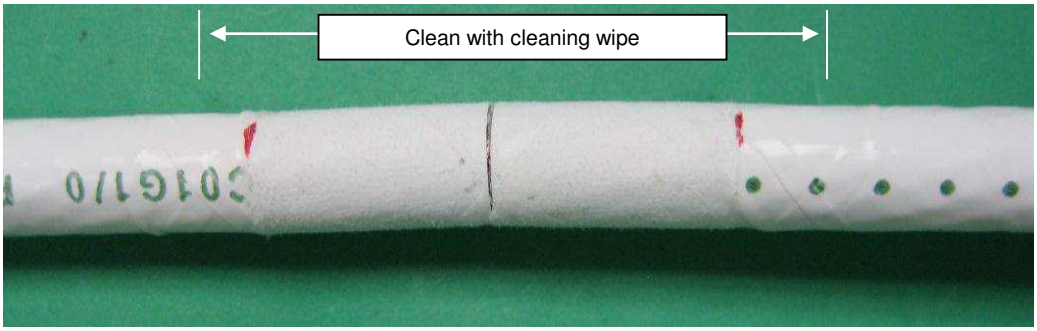
- **Wear eye protection and safety gloves suitable for heating tools.**
- Overheating the product to charring or burning may produce vapors that may cause eyes, skin and nose or throat irritation. Persons with pre-existing eye, skin or respiratory disorders (e.g., asthma conditions) may be more susceptible to the effects of these vapors.
- Shrink products in a well-ventilated area.

6.1 Prepare Cable

1. Mark the damaged area a distance of 2 inches where the damaged area is located approximately at the center and isolate the area with tape. Thoroughly abrade the cable jacket with the abrasive cleaning pad 2” x 2” included in the kit.



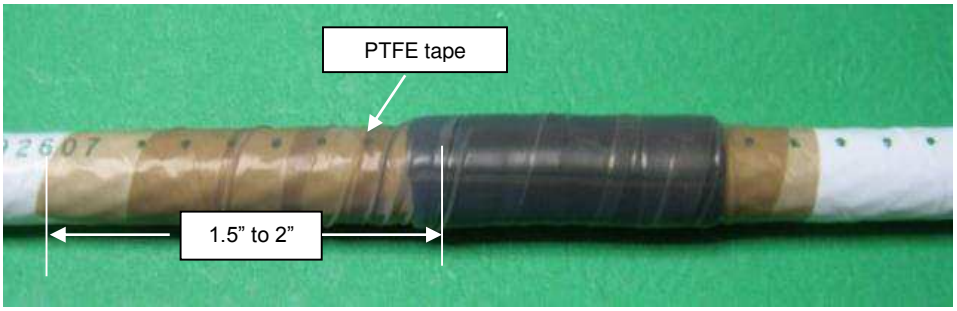
2. Remove the tape at both ends of the abraded area and clean with cleaning wipes included in the kit, or equivalent cleaning solvent (e.g. IPA).
3.



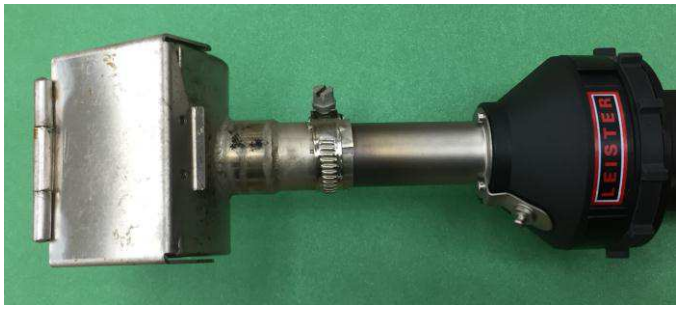
6.2 Install Repair Sleeve

1. Refer to Table 1 or TE CD and select the appropriate repair sleeve size for the cable. Center and wrap the sleeve around the damaged area of cable jacket with the coated adhesive inside.

2. Tightly wrap the repair sleeve with the PTFE tape by stretching the tape to create a compression force. Wrap the overlap tape sections approximately 50% around the RaySeal sleeve as shown. The length of the outside end of PTFE tape should extend 1.5” to 2” to prevent the tape from unraveling during the heating process. For ETFE jacket apply two extra wraps of PTFE tape next to each end of the RaySeal sleeve during wrapping to avoid wire jacket turning to light brown after the heating process.

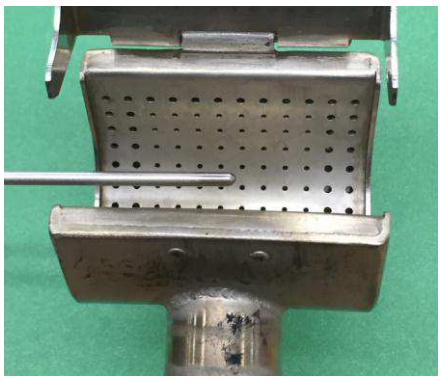


3. Install the CV-2014 Hot Jet S with the PR-38B-Reflector by inserting the reflector to the built-in positive stop or approximately 1.7 inch from heat gun base. Tighten the clamp on the reflector to prevent any unintentional extraction (right photo below):

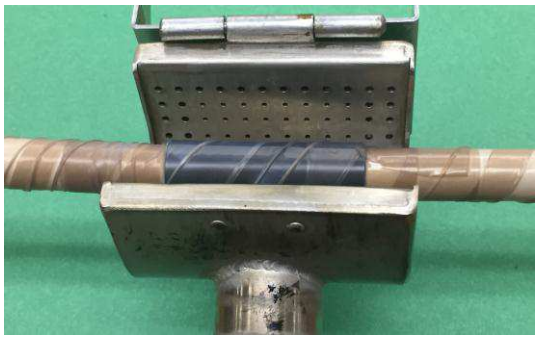


4. Close the reflector flat metal top. Turn the air volume control (black dial) clockwise to # 4 and turn the temperature adjustment (red dial) to # 6 as shown below (left

photo). Warm-up the hot air tool for 5 minutes until temperature stabilizes at ~ 330 to 350 °C when measured with a thermocouple at the approximate center of the closed reflector (see right photo below).
For ETFE jacket turn the temperature adjustment (red dial) to # 5 before warming up the hot air tool (temperature ~ 270 to 290 ℃)

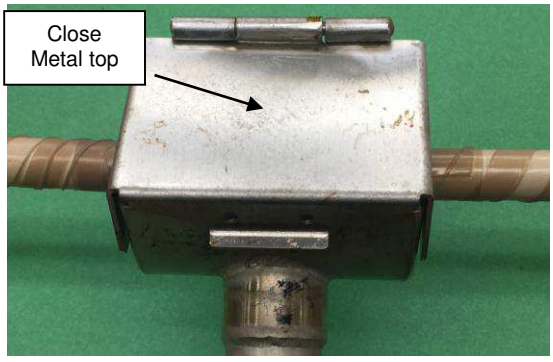


5. Open the reflector flat metal top and position the RaySeal sleeve assembly at the center of the reflector.



NOTE
Close the reflector cover immediately to minimize cooling down the temperature of the reflector cavity

6. Close the metal top and heat the assembly for 4 minutes +15 / - 0 second



7. Remove the heating tool and allow the assembly to cool room temperature then peel off the PTFE tape (optional).

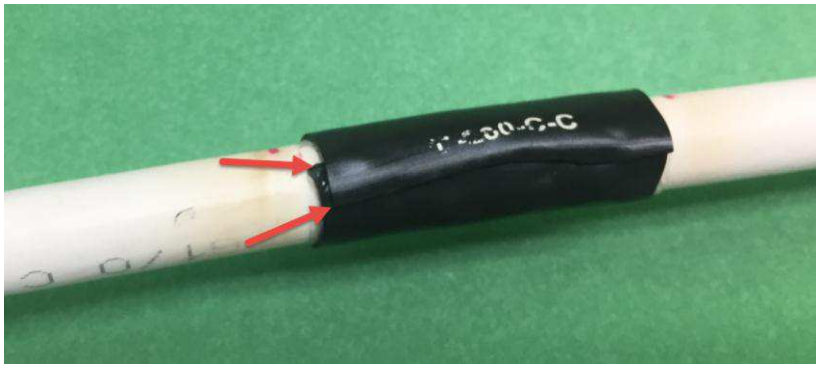
8. The outside edge of the RaySeal sleeve has been fused to the sleeve body and the adhesive should be melted and flown out at the ends during the heating process if enough heat is applied. Remove any excess adhesive at the sleeve ends. Clean the assembly with cleaning wipes or IPA if necessary.

Acceptable – visible adhesive at both ends of the repair sleeve.

Unacceptable – darkened adhesive at and baked on PTFE tape adhesive residue – overheating.

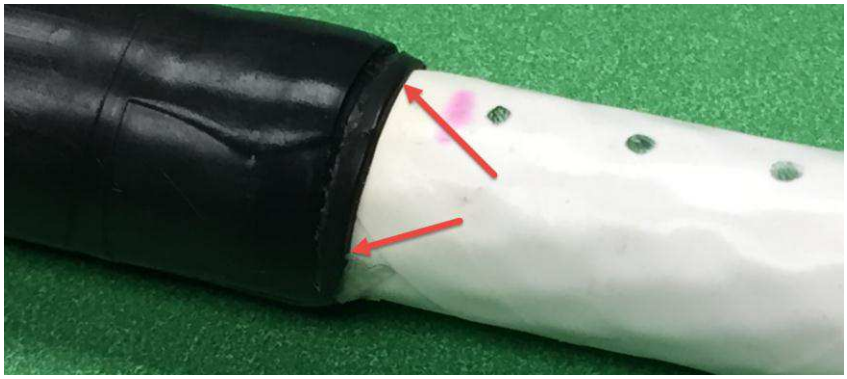
Unacceptable – incomplete bonding from insufficient heating (time or heat)

Unacceptable – no evidence of adhesive flow at the ends – insufficient heating



Unacceptable – insufficient overlap (arrow) – lack of PTFE tape wrap pressure.

Unacceptable – evidence of adhesive on the top layer (arrow) – reverse installed.



Unacceptable – no adhesive on the bottom layer (arrow) – reverse installed.

Material safety data sheet:

For assistance or more information, call TE Connectivity/Raychem: 1-800-522-6752

Product Name	SDS (MSDS) References
D-260-C-A	3122
D-260-C-B	
D-260-C-C	
D-260-C-D	
D-260-C-E	

IMPORTANT

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