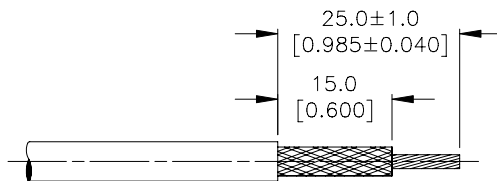


Installation Procedure For B-015-XX And B-016-XX Coax Terminator, Low Temperature

1.0 Cable Preparation

- 1.1 Remove cable jacket, shield and dielectric exposing 10mm [0.394in] of conductor.
- 1.2 Remove 15.0 ± 1.0 mm of jacket to expose shield.



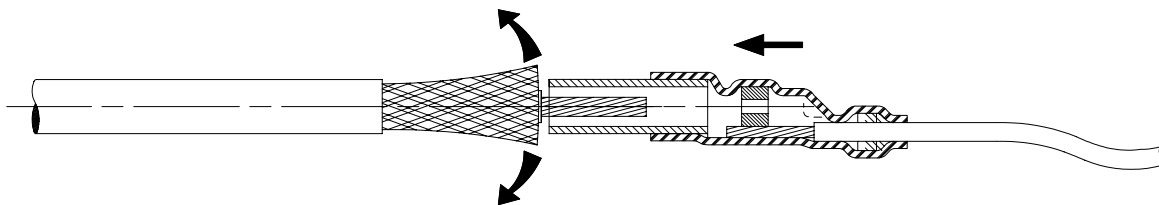
2.0 Installation of Terminator

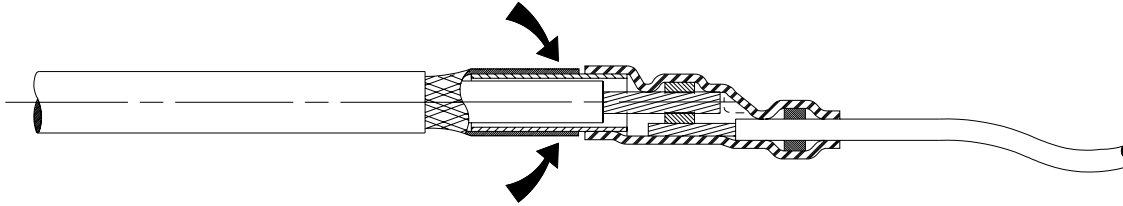
Note: The use of a Raychem AD-1319 holding fixture will aid in keeping leads aligned during installation.

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** for further information.

- 2.1 Insert the primary sleeve barrier under the cable shield as far as possible.
Note: If the cable has a drain wire included, the barrier goes under the drain wire. The cable conductor must extend through the solder perform.

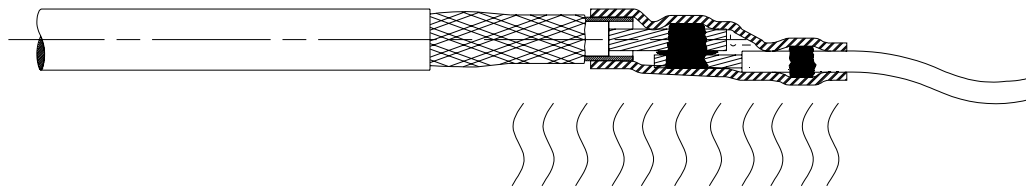




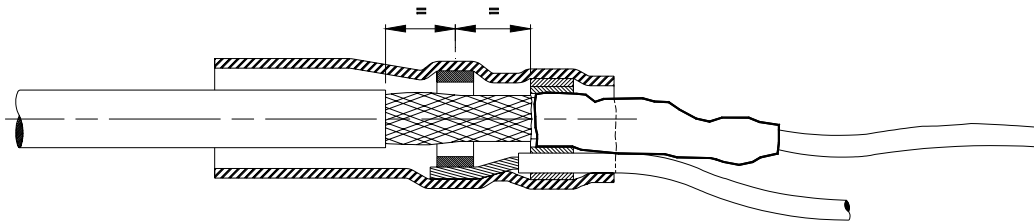
- 2.2 Apply heat, using one of the recommended heat sources to the solder perform until it has completely melted and formed a fillet between the pre-installed lead and the cable conductor.

WARNING

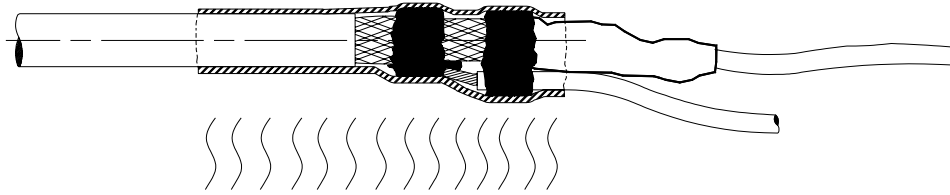
The heating tool and the assembly become hot during the installation of the Coax Terminator. To prevent burns, allow tool and the assembly to cool down before handling.



- 2.3 Position the shield termination sleeve so that the inside of the meltable insert is aligned with the end of the shield.



- 2.4 Heat this sleeve
Position sleeve so that the solder perform is centered in reflector, and heat until the solder melts and forms a fillet between the lead and the shield.
Apply heat to the lead end of sleeve until it recovers and the insert completely melts. If recovery of the sleeve onto the cable jacket is desired, it must be heated very carefully.
Do not allow heat to impinge on the cable jacket outside of the terminator sleeve as this may cause esthetic damage to the insulation.
Note: Do not attempt this recovery with an infrared heat source if the cable jacket is black or gray as infrared radiation may cause the jacket to melt.



3.0 Inspection

Full color photographs showing accept/reject criteria are available from Raychem. Also, the inspection criteria of MIL-HBDK-454 requirement 5 may be used.

3.1 Assembly

3.1.1 Conductor Splice

- a. At least 5mm [0.200in] of the conductor lead must overlap the cable conductor.
- b. The barrier must be inserted under braid to within 5mm [0.200in] of the cable jacket.

3.1.2 Shield Termination

- a. At least 7mm [0.276in] of the ground lead conductor must overlap the stripped portion of the shield.
- b. The insulation sleeve must be completely covering the stripped portion of the shield.

3.2 Heating

- 3.2.1 The solder performs must have completely melted and flowed along lead/conductor and lead/shield interfaces.
- 3.2.2 A solder fillet must be visible along at least one side of both interfaces.
- 3.2.3 The fillet should be at least 3mm [0.118in] long.
- 3.2.4 The sleeve must not be discolored to the point where it prevents visual inspection of the solder joint.

3.3 Damage

- 3.3.1 The sleeve must not be cut or split.
- 3.3.2 The strands of the conductor, leads or shield must not be poking through the insulation sleeve of the terminator.

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