

**Installation Procedure for B-070-12-XX  
SolderShield Device in Multiple Shield Termination**

**1. Application Equipment:**

Recommended hot air generators:

 CV-1981 set on position 8, vent open with PR25D reflector (420°C ±20°C)<sup>(1)</sup>

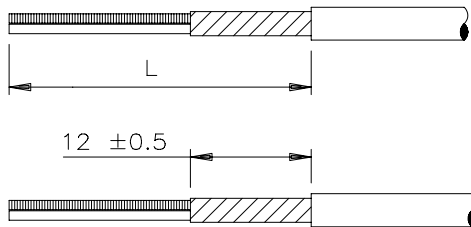
 HL1910E, setting = 6 on dial<sup>(1)</sup>, with PR-25D and HL1802E-ADAPT

 HL2010E, 700°F on LCD<sup>(1)</sup>, with PR-25D and HL1802E-ADAPT

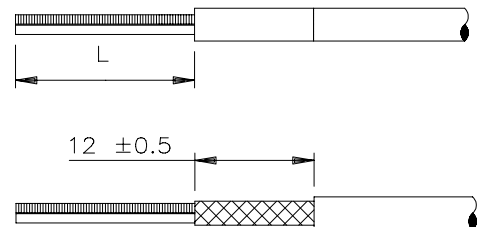
**2. Cable Preparation:**
**2.1 Helicoidal braided shielding:**

Strip off a length L of the outer jacket depending on the final application.

Unwind the braid from the inner wires, cut it to a length of 20 mm and rewind it to get a length of 12mm.


**2.2 Cross braided shielding:**

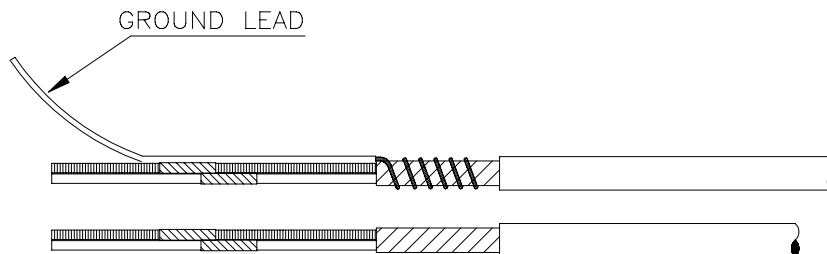
Strip off a length L of the out jacket and braid depending on the final application. Then strip off 12mm of the braid.


**3. Assembly:**

Slide and recover a marked sleeve on each wire.

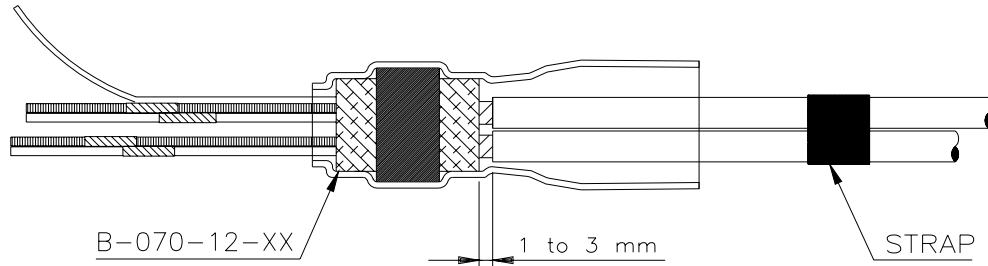
Strip off 20mm of the outer jacket of a ground lead.

Wind the ground lead round the braid of one of the cables, and position it along its conductors.



Line up the cables and tie them with a strap.

Place the SolderShield\* device over the cables, positioning the heat shrinkable braid at 1 to 3mm from the end stripping of the cable jacket.



**4. Termination Procedure:**

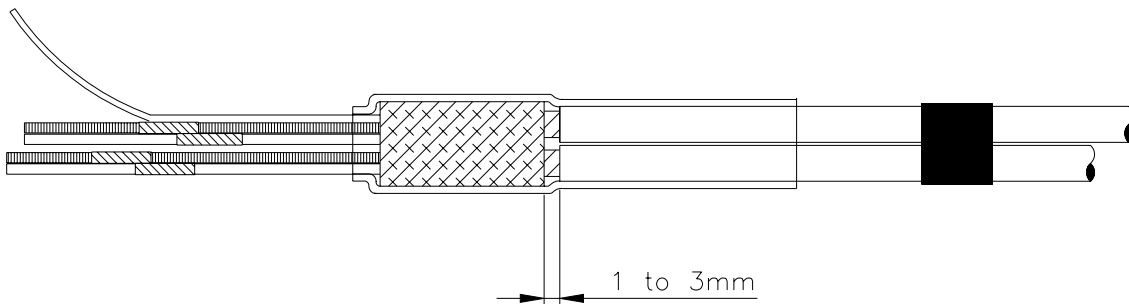
Preheat the Raychem CV1981 hot air generator for at least one minute.  
Apply heat with PR25D reflector in the center of the solder ring until the ring has melted and disappeared in the braid. Move slowly over the tubing to recover it onto the outer jacket.

Allow the assembly to cool down before handling.

**Note:** In case of a nickel plated braid, continue heating for 45 seconds after the solder preform has disappeared. Some solder flowing over the end stripping of the cable braid should be seen. (Only B-070-12-08 and B-070-12-11 products)

**5. Inspection:**

- The solder preform must be completely melted, and have flowed along the braid.
  - The SolderShield\* device braid must not touch the cable jacket. (1 to 3mm gap)
  - A slight darkening of the tubing is acceptable.
  - Wires insulation must not be damaged. (melting.)
- Damage of wire insulation such as charring, melted insulation is not allowed.



These values are for reference only and may change based on other variables (i.e. reflector type, sleeve's relative distance to the reflector, etc.)  
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Unless otherwise specified dimensions are in millimeters. [Inches dimensions are in between brackets]

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