Installation Procedure for PlugPak* Connector, PBD-50-XX-S

1. Products / Cables:

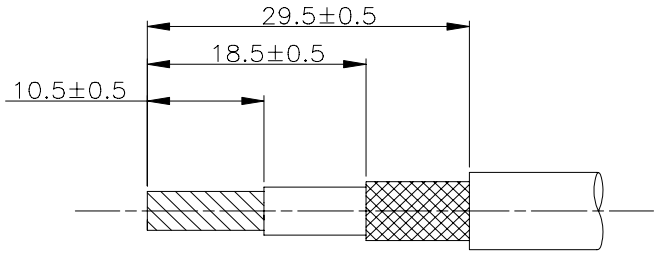
Table 1

Products	Reflectors	Raychem Cables
PBD-50-82-S PBD-50-85-S PBD-50-96-S PBD-50-97-S	PR-25	5021K1011 5020A3311 5021D1331
PTD-50-82-S PTD-50-85-S PTD-50-94-S		
PBD-50-89-S PBD-50-92-S	PR-25-D	5012H3012
PTD-50-89-S PTD-50-90-S PTD-50-91-S PTD-50-92-S PTD-50-95-S		

2. Application Equipment:

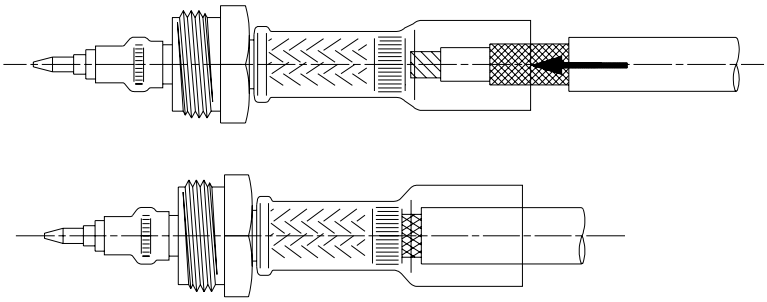
- CV-1981 with reflector (see Table I).
- Setting: 7 - 8.
- Recommended Temperature = 420°C (checked with an AD-1999 reflector).

3. Cable Preparation:

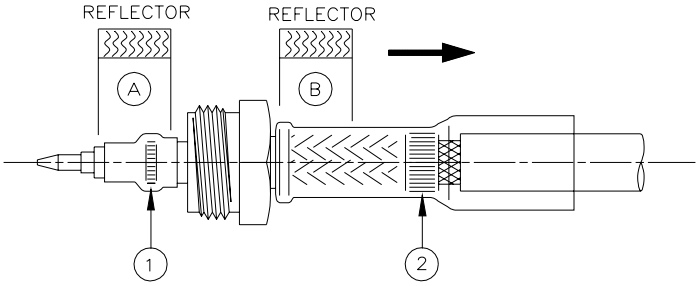


4. Assembly:

- Slide the cable into the transition until it butts against the dielectric insulator.



5. Termination of the transition:



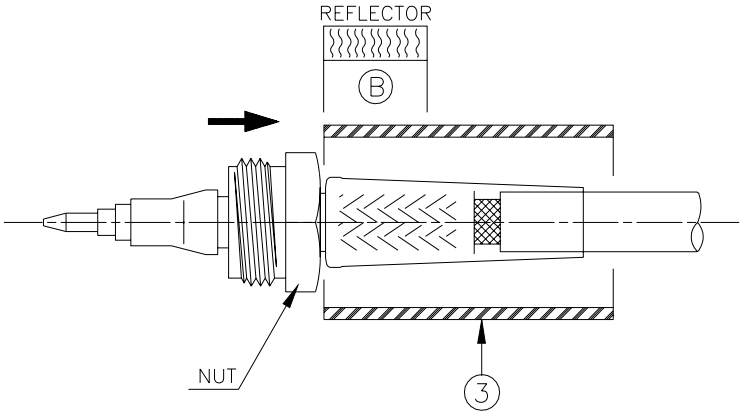
- Center the solder ring (1) in the reflector at location (A) and heat it until the ring melts, flows into the inspection holes, and completely disappears (keep heating a few seconds).
- Move the reflector to location (B). Heat until the SolderShield collapses and the impregnated solder melts and flows. Heat along the insulation sleeve until the solder ring (2) melts and flows.
- Move the reflector to shrink the sleeve down on the cable insulation. Let assembly cool down before handling.

6. Inspection:

Check: - Solder rings(1) and (2) have flowed.
- The sleeve and wire insulation show no signs of mechanical damage or overheating.

7. Protection of the Transition:

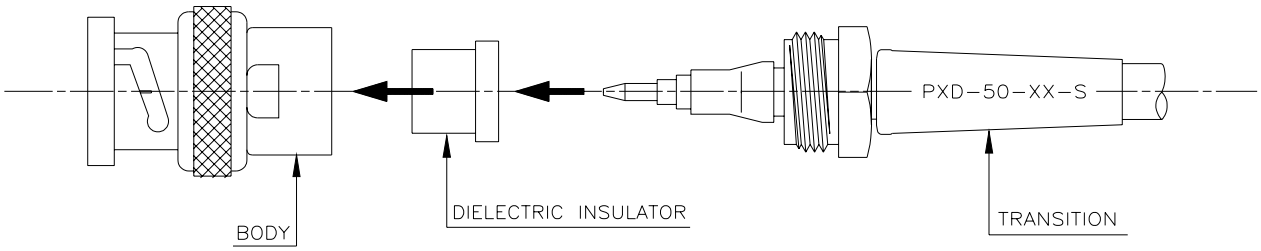
Slide the insulation sleeve (3) over transition. Position it to butt against the nut. Shrink the sleeve completely starting from region (B).



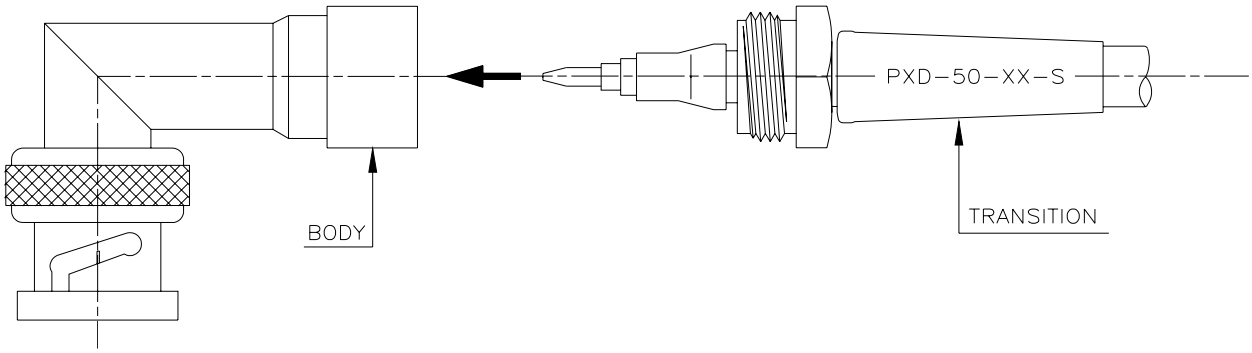
8. Connector Assembly:

- Push the dielectric insulator into the body*.
- Screw the transition into the connector body.

* Angle plug connector does not have the dielectric insulator.



Straight Plug Connector



Angle Plug Connector