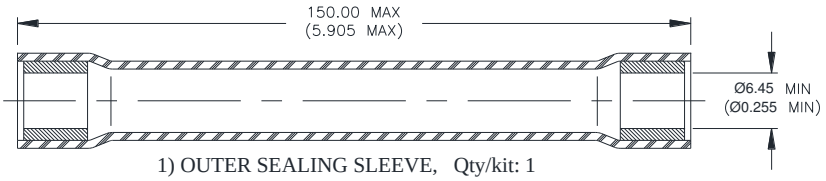
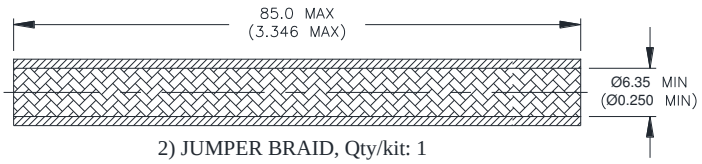
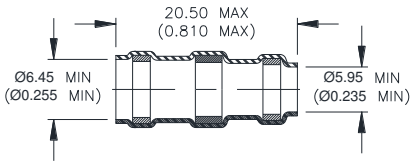
CUSTOMER DRAWING



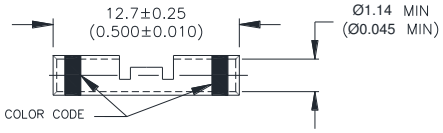
1) OUTER SEALING SLEEVE, Qty/kit: 1



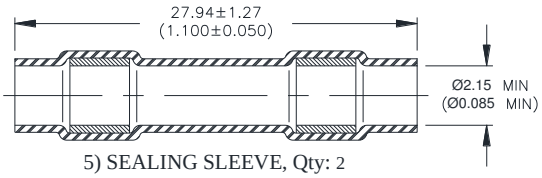
2) JUMPER BRAID, Qty/kit: 1



3) SOLDERSLEEVE, Qty: 2



4) CRIMP, Qty: 2



5) SEALING SLEEVE, Qty: 2

MATERIALS

1. CABLE SEALING SLEEVE:
   INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified fluoropolymer. Color: black
   MELTABLE INSERTS: Environment resistant modified thermoplastic fluoroelastomer. Color: light blue.
2. JUMPER BRAID: Nickel-plated copper alloy.
3. SOLDERSLEEVE:
   INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified fluoropolymer.
   SOLDER PREFORM WITH FLUX:
   SOLDER: TYPE Sn96 per ANSI / J-STD-006.
   FLUX: TYPE ROM1 per ANSI / J-STD-004. Thermal indicator: color changes from orange to colorless.
   MELTABLE INSERT: Thermally stabilized thermoplastic. Color: blue.
4. CRIMP SPLICE: Nickel-plated copper alloy. Color Code: red.
5. SEALING SPLICE SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified fluoropolymer, containing two environment resistant sealing rings. Color: transparent blue.

APPLICATION

1. These kits are designed to make an environment-resistant 1 to 1 in-line splice in double shielded, twisted pair cables having silver or nickel-plated conductors and insulations rated for 150➡C minimum, where cable shields are intended to be connected at the splicing location.
2. Temperature rating: -55 to +200 ➡C.

TE Connectivity			TITLE: **1 TO 1 SPLICES CRIMP, FLEXIBLE SHIELD SPLICE KIT, DOUBLE SHIELDED CABLE 26 THRU 20 AWG**		
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets] DIMENSIONING AND TOLERANCING PER ASME Y14.5-2009		Raychem Devices	DOCUMENT NO.: **D-150-0250-RT**		
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.	REV: **A**	DATE: February 3, 2017	
PREPARED BY: *G.Rositano 1/31/2017*	CAGE CODE: 06090	ECO NUMBER: ECO-17-001539	SCALE: NTS	SIZE: A	SHEET: 1 of 3

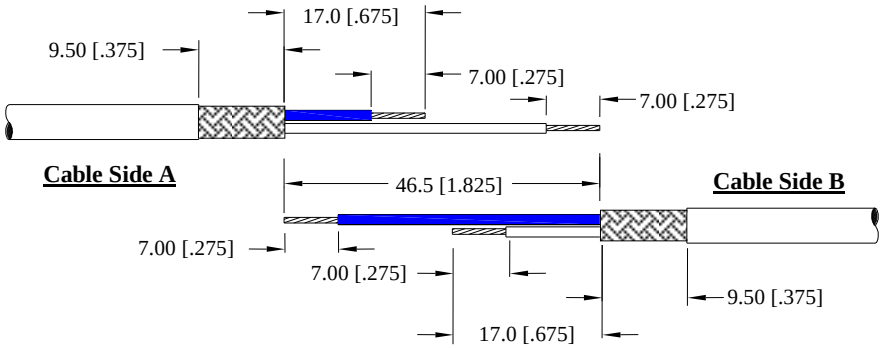
CUSTOMER DRAWING

INSTALLATION PROCEDURE

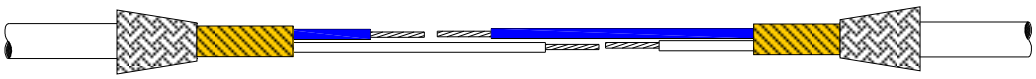
Application Equipment
Wire Handling Tools
1. Wire stripper for primaries.
2. Wire stripper for cable jacket.
3. Small sharp scissors or diagonal cutters for braid.
4. Ruler readable to 0.50 (.025).
5. Raychem (*) AD-1377 Crimp Tool (calibrated).

Heating Tools
Use one of the following or TE approved alternative.
1. Steinel **HL-1910E or** HL2010E with p/n reflector **PR-25**. Temperature setting 750-800➡F
2. Raychem IR-550 Infra-Red Tool RG-2 Reflector (only for jumper braid).

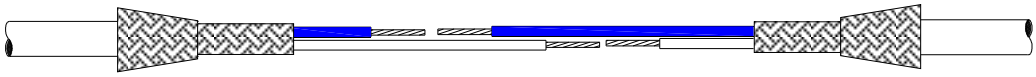
Cable Preparation
Tolerances: All lengths ± 0.50 (.025)
1. Remove cable jacket, shield, and separator tape: 46.50 (1.825)
2. Cut 1 primary on each cable: 17.00 (.675) from cable jacket.
3. Note: Short primaries on cable A must be left uncut on cable B.
4. Strip primaries: 7.00 (.275)
5. Remove cable jacket: 9.50 (.375)



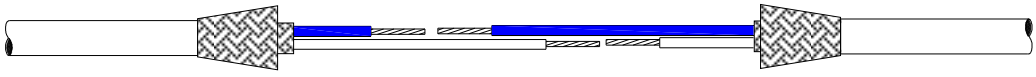
6. Fold back outer cable shield.



7. Remove the separator tape.



8. Fold over outer cable shield



Unless otherwise specified dimensions are in millimeters.
(Inches dimensions are shown in brackets)

Cable Splice Installation

9. Place the outer sealing sleeve, one of the SolderSleeve devices, and the jumper braid onto one of the cables (Cable Side A). The second SolderSleeve device shall be placed on the other cable to be spliced (Cable Side B).
10. Primary Conductors Splice.
    a. Place the sealing sleeve onto one of the primary conductors.
    b. Crimp primaries into opposite ends of the crimp splice using a calibrated Raychem AD-1377 crimp tool. Be sure matching primaries from each cable are in same sleeve.
    c. Center the sleeve over the splice.
    d. Apply heat to the center of the sleeve until adhesive melts and extrudes out at the ends of the sleeve. Use approved heating tools, reflectors, and setting, as specified.
    e. When extruded adhesive is clearly visible, move the sleeve back and forth until the adhesive flows out sufficiently to flatten the tubing along the length of the wire.
11. Flexible Jumper Braid
    a. Center one of the ends of the flexible Jumper braid over one of the exposed cable shields. Flexible jumper braid end shall overlap cable exposed shields. Jumper braid strands shall be conformed tightly over the cable shield to prevent any damage to the SolderSleeve device. Slide one of the SolderSleeve devices and center where the Jumper braid and cable shield overlap.
    b. Heat SolderSleeve device. Apply heat to the SolderSleeve device until the solder melts and heat shrink tubing recovers. Use approved heating tools, reflectors, and setting, as specified.
    c. Stretch second end of the flexible jumper braid until over-laps second cable exposed shields. Jumper braid has to conform to the spliced conductors as possible. Trim and remove any excess of braid length. Slide the second SolderSleeve device and center where the Jumper braid and cable shield overlap. Apply heat until the solder melts and heat shrink tubing recovers.
12. Outer Sealing Sleeve
    a. Center the outer sealing sleeve over the spliced cable. Based on length of the outer sealing sleeve, one of the spliced cables can be marked to facilitate location of the outer sleeve.
    b. Heat sleeve. Use approved heating tools, reflectors, and setting, as specified, with the exception do not use Raychem IR-550 Infra-Red Tool.
    c. Heat center of sleeve until the tube fully recovers.
    d. Move the heat toward one end of the sleeve slowly enough to keep the sleeve recovering as you move along.
    e. Apply heat to the final 12.5 mm (half-inch) of the sleeve until the adhesive flows out sufficiently to flatten the tubing along the length of the splice on the cable. For low temperature rated cable jackets (i.e. ETFE cable jacket), and piece of PTFE tape, or equivalent, can be wrapped around the cable jacket close to the end of the splice to prevent cable jacket damage, and removed after completion.
    f. Repeat for other end of sleeve.