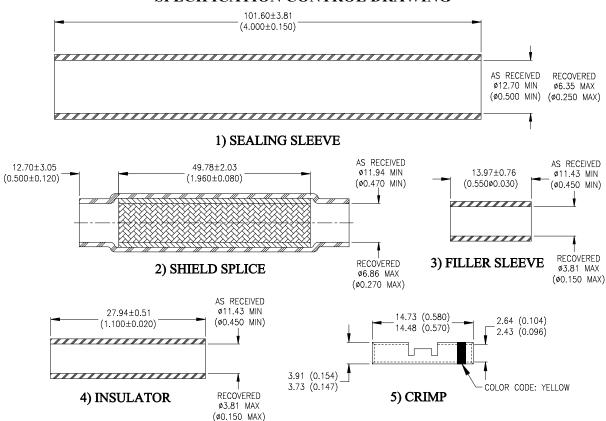
# SPECIFICATION CONTROL DRAWING



### **MATERIALS**

- 1. SEALING SLEEVE: Heat-shrinkable, radiation cross-linked polyolefin with adhesive liner, color: black.
- 2. SHIELD SPLICE:

INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride. SHIELD: Solder impregnated, flux coated copper wire braid.

SOLDER: TYPE Sn63 per ANSI-J-STD-006. FLUX: TYPE ROM1 per ANSI-J-STD-004.

- 3. & 4. INSULATION SLEEVE: Heat-shrinkable, radiation cross-linked polyolefin, color: black.
- 5. CRIMP SPLICE: Tin plated copper alloy. Color code: yellow

BASE METAL: Copper Alloy 101 or 102 per ASTM B-75.

PLATING: Tin per MIL-T-10727, Type 1.

SIZE RANGE: 16 to 12 AWG, (1900 – 6755 circular mils).

## **APPLICATION**

1. Kit may be used to make an environment-resistant in-line splice in coaxial cables meeting the size range shown in the diagram (see sheet 2) and having the following component materials:

Conductor: Tin-plated, silver-plated or bare copper

Dielectric: Rayfoam or MIL-C-17 Types Al, A2, Fl, F2, MI Shield: Bare copper or plated with tin, silver or nickel

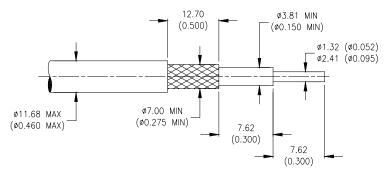
Jacket: 105°C rated. MIL-C-17 Types: Ila, IIIa, V, VIIa, VIIb, IX, X, XI

- 2. Typical RG cable numbers: 8A; 9B; 87A; 90; 115A; 143A; 144; 165, 213, 214, 225, 391, 397

  3. These cables may be used if the center conductor is doubled back on itself, RG, 11A; 13A; 140, 216
- 3. These cables may be used if the center conductor is doubled back on itself: RG-11A; 13A; 149, 216.
- 4. Typical Raychem Cables: 5012EI339; 5012F3332; 5012M3612; 5016D3132.

<b>tyco</b> Electronics	305 C	onstitut	nics Corporation ional Drive CA 94025 USA	<b>RAYCHEM</b> Products	SPLICE KIT, COAXIAL CABLE,			
Unless otherwise sp Inches dimensions				DOCUMENT NO.: <b>D-150-0214</b>				
TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A	ANGLES: ROUGHNE		Tyco Electronics reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.		DATE: May 29, 2001		doc issue: 1	
DRAWN BY: M. FORONDA		REPL N/A	ACES:	DCR NUMBER: D010126	PROD. REV.	SCALE: None	SIZE:	SHEET: 1 of 2

# SPECIFICATION CONTROL DRAWING



# **INSTALLATION PROCEDURE:**

- 1. Prepare cable as shown in the diagram. Tolerance on all dimensions is  $\pm 0.76$  (0.030).
- 2. Place items 1, 2, 4 and 3 onto one of the cables in sequence listed.
- 3. Crimp conductors into opposite ends of the crimp splice using a calibrated Raychem AD-1377.
- 4. Place the Filler Sleeve (shortest sleeve) over crimp and heat, using a Raychem approved hot air heater and reflector, until sleeve recovers onto crimp.
- 5. Center the Insulator over the splice and recover it onto cable.
- 6. Position the Shield Splice so that an equal amount of cable braid is exposed between the sleeve shield and the cable jacket.
- 7. Start in center of sleeve and heat until the solder melts and the sleeve recovers. Move assembly through the heat slowly enough to keep the solder melting and the sleeve recovers. Heat overlap portion of shields 5 to 10 extra seconds to ensure adequate heat transfer to cable shield. Then move back to center and heat toward other end of sleeve.
- 8. Center the Sealing Sleeve over assembly and heat to recover the sleeve and melt the adhesive. Start in center and work toward ends.

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Unless otherwise s Inches dimensions				DOCUMENT NO.: <b>D-150-0214</b>				
TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A	ANGLES: 1 ROUGHNE MICRON	-	Tyco Electronics reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.		DATE: May 29, 2001		DOC ISSUE: 1	
		REPL N/A	ACES:	DCR NUMBER: D010126	PROD. REV.	SCALE: None	SIZE:	SHEET: 2 of 2