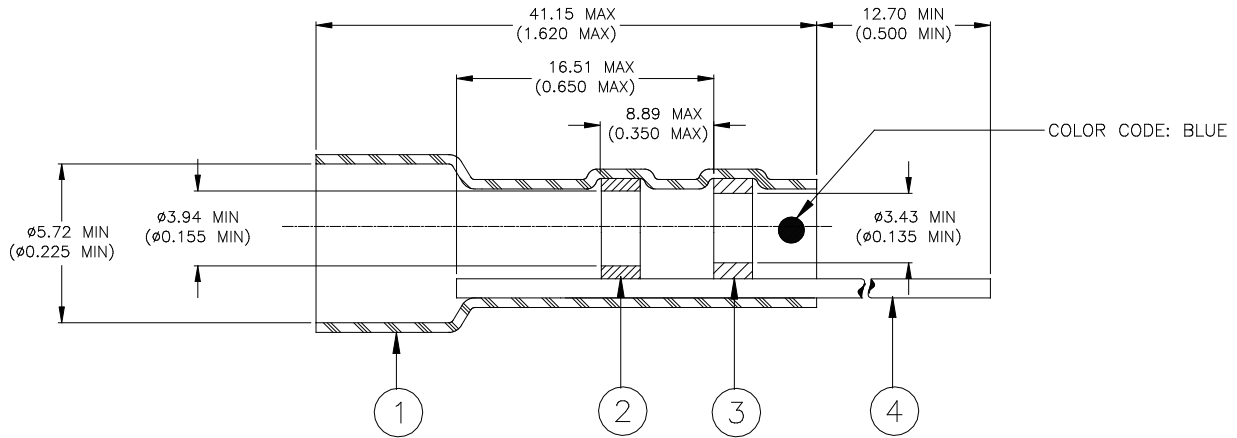


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MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent gray, radiation cross-linked modified thermoplastic.
2. SOLDER PREFORM WITH FLUX:
 SOLDER: TYPE Sn63 per ANSI J-STD-006.
 FLUX: TYPE ROL0 per ANSI J-STD-004.
3. MELTABLE INSERT: Thermally stabilized thermoplastic, Color – blue.
4. BUSS WIRE: 20 AWG, Tin coated copper.

APPLICATION

1. These parts are designed for use on tin or silver plated copper shields.
2. Raychem D-513 series Dielectric Barrier should be used on cables with low temperature insulation.
3. For selection guide and installation instructions, see below and sheet 2.


SELECTION GUIDE

1. Determine maximum diameter of cable dielectric/primary insulation.
2. Select smallest D-513 Barrier having minimum I.D. greater than cable dielectric/ primary insulation diameter (See Table 1)
3. Select appropriate sleeve from Table 1.

TABLE 1.

Soldersleeve	Barriers		
	Part Name	Min. I.D.	Color
D-134-04 For Cable Dia. 2.29 – 5.46 (0.090 – 0.215)	D-513-05	1.27 (0.050)	White
	D-513-06	1.52 (0.060)	Yellow
	D-513-07	1.78 (0.070)	Blue
	D-513-08	2.03 (0.080)	White
	D-513-09	2.29 (0.090)	Yellow

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		Wire and Harnessing Products	TITLE : 20 AWG BUSS WIRE, SOLDERSLEEVE, PADDLECARD TERMINATOR			
Unless otherwise specified dimensions are in millimeters. Inches dimensions are in between brackets.			DOCUMENT NO.: D-134-04			
TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A	ANGLES: N/A ROUGHNESS IN MICRON	TE Connectivity reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.	Revision: 2		Issue Date: March 2020	
DRAWN BY: M. FORONDA	DATE: 18-July-01	ECO: ECO-20-003568	SCALE: None	SIZE: A	SHEET: 1 of 3	

Print Date: 13-Mar-20 If this document is printed it becomes uncontrolled. Check for the latest revision.

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INSTALLATION PROCEDURE:

A: SHIELDED CABLE

- Strip cable and insert Barrier per Figure 1. End of Barrier should protrude from shield.

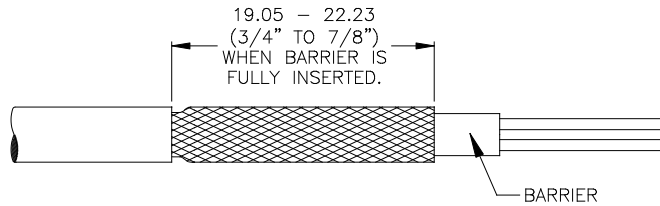


FIGURE 1
Multi-Conductor Cable Preparation

- Slide sleeve over end of cable until meltable ring is over the end of shield, per Figure 2.

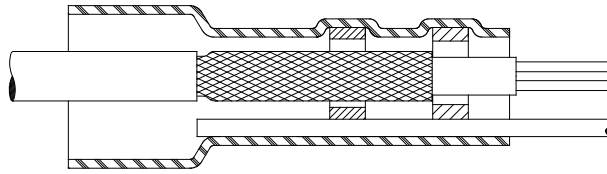


FIGURE 2

- Place in Raychem IR-500 Heater, equipped with RG-2 Nose Cone, so that solder preform is at the notch. Apply heat until solder preform melts and flows.

B: COAXIAL CABLE

This procedure must be followed when terminating coaxial cables with low temperature (less than 125°C) dielectric or high temperature dielectric with high shrink-back characteristics. It is recommended for all coaxial cable applications to reduce stress on center conductor/Paddlecard joint.

- Cable is to be prepared as follows:
 - Remove 44.45 ± 3.18 (1-3/4 \pm 1/8 inch) of cable jacket.
 - Remove all but 25.40 – 28.58 (1 to 1-1/8 inch) of shield and dielectric.
 - Insert D-513 Barrier of correct size (see Table 1) under shield. Trim excess braid as required so that cable looks as shown in Figure 3.

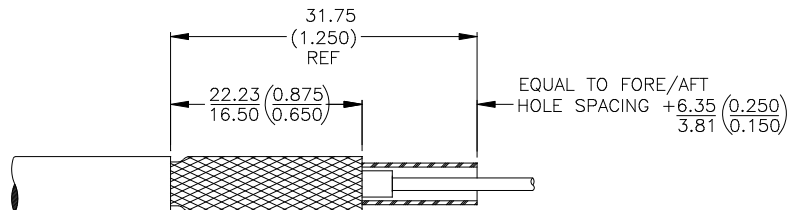


FIGURE 3

- Place D-134 sleeve onto assembly so that extension of Barrier from end of sleeve is equal to Fore/Aft Hole Spacing of Paddlecard [± 1.27 (± 0.050)], see Figure 4.

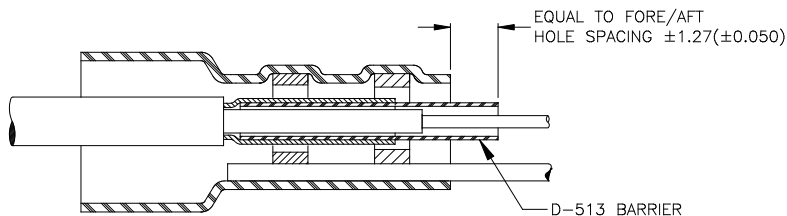


FIGURE 4

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- e). Place assembly into IR-500 so that solder preform is centered on notch in the RG-2 nose cone. Activate heater until solder melts and flows axially along the Buss Wire. It may be necessary to apply a small amount of heat to ends of sleeve to fully recover tubing. Remove from heat and allow to cool undisturbed until solder resolidifies.
- f). To mount terminated cable to Paddlecard, bend center conductor at end of Barrier and Buss Wire at end of sleeve and insert wires through holes in board (Figure 5).

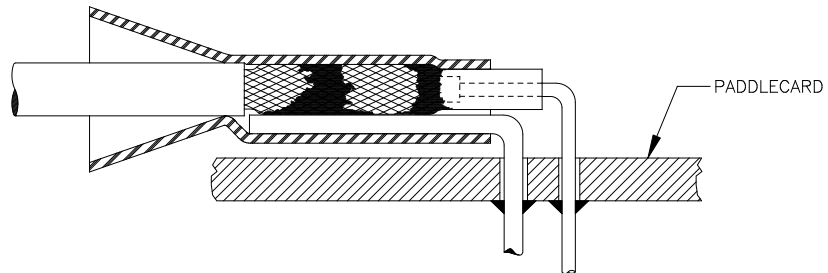


FIGURE 5

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