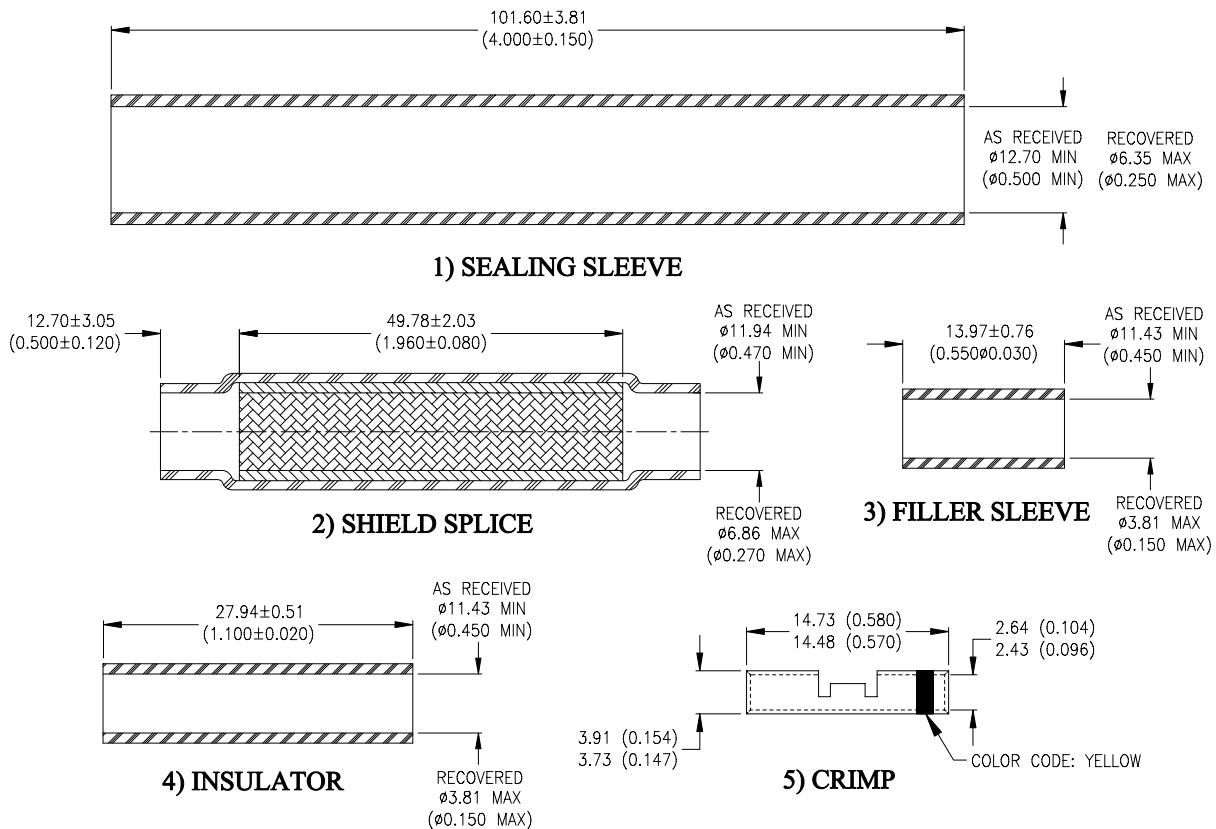


SPECIFICATION CONTROL DRAWING



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).

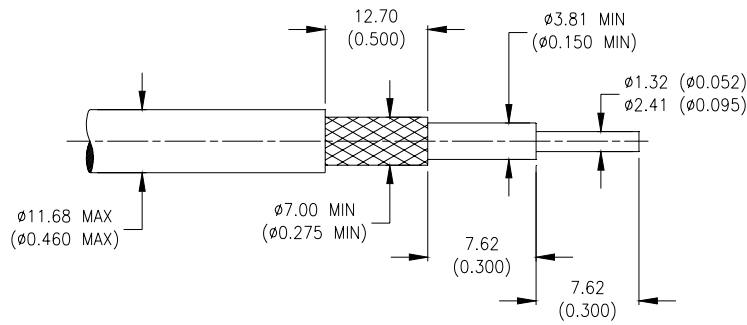
APPLICATION

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 A1, A2, F1, F2, MI
 - Shield: Bare copper or plated with tin, silver or nickel
 - Jacket: 105°C rated. MIL-C-17 Types: IIa, 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; 149; 216.
4. Typical Raychem Cables: 5012EI339; 5012F3332; 5012M3612; 5016D3132.

tyco <i>Electronics</i>	Tyco Electronics Corporation 305 Constitutional Drive Menlo Park, CA 94025 USA	RAYCHEM Products	TITLE : SPLICE KIT, COAXIAL CABLE,				
Unless otherwise specified dimensions are in millimeters. Inches dimensions are in between brackets.			DOCUMENT NO.: D-150-0214				
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.	DATE: May 29, 2001	DOC ISSUE: 1			
DRAWN BY: M. FORONDA	REPLACES: N/A	DCR NUMBER: D010126	PROD. REV. A	SCALE: None	SIZE: A	SHEET: 1 of 2	

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SPECIFICATION CONTROL DRAWING



INSTALLATION PROCEDURE:

1. Prepare cable as shown in the diagram. Tolerance on all dimensions is ± 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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DRAWN BY: M. FORONDA	REPLACES: N/A	DCR NUMBER: D010126	PROD. REV. A	SCALE: None	SIZE: A	SHEET: 2 of 2	

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