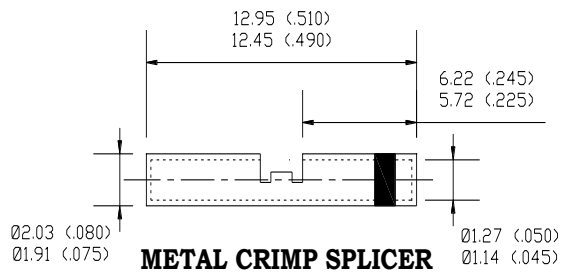
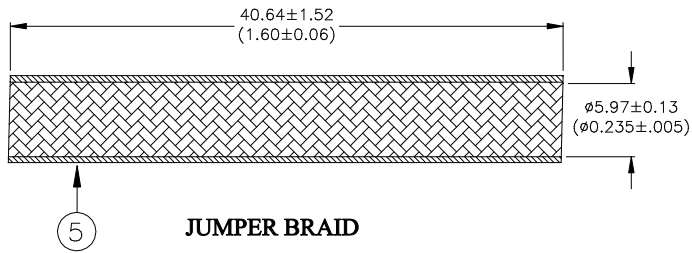
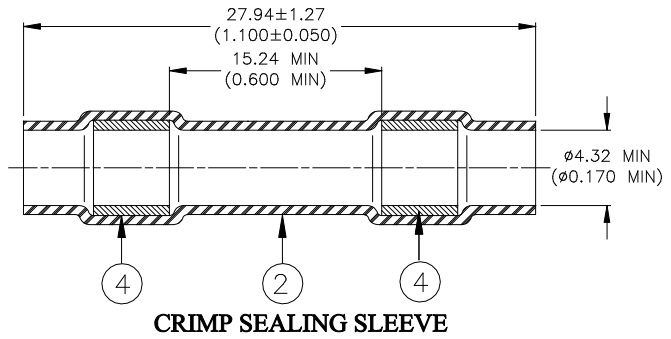
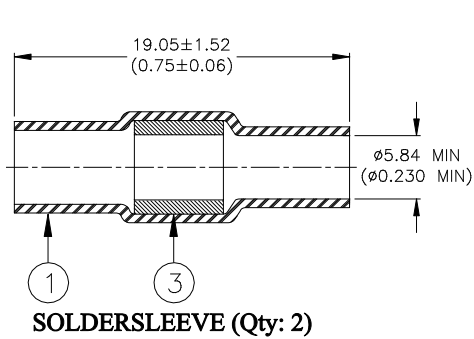
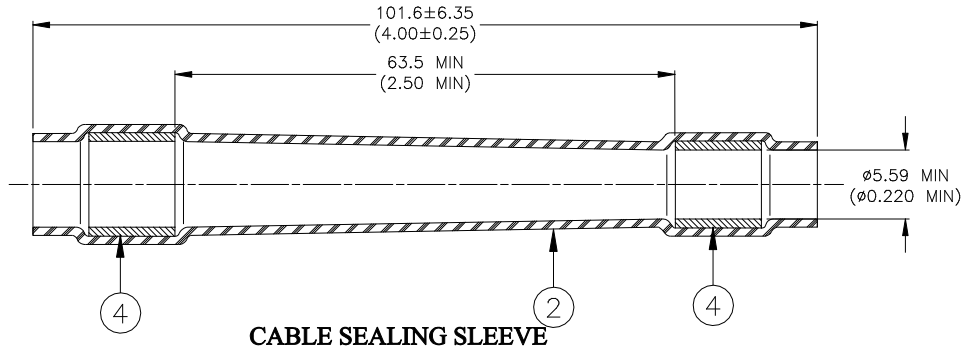
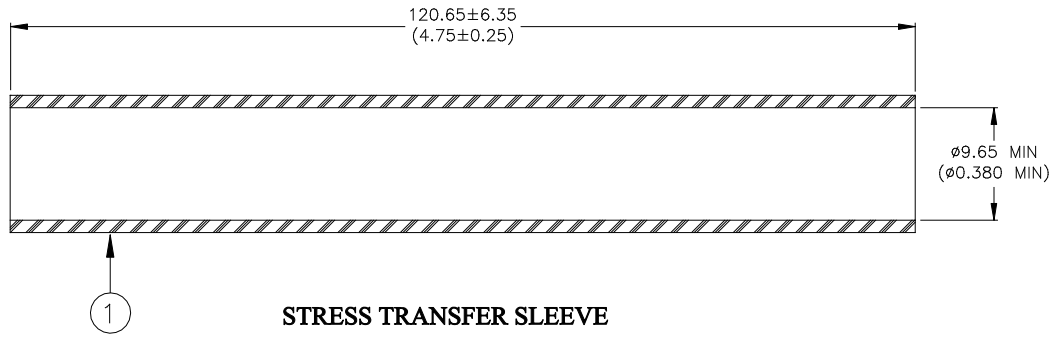



CUSTOMER DRAWING



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MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent gray, radiation cross-linked polyolefin.
2. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
3. SOLDER PREFORM WITH FLUX:
 - SOLDER: TYPE Sn63 per ANSI J-STD-006.
 - FLUX: TYPE ROL0 per ANSI-J-STD-004.
4. MELTABLE RINGS: Immersion resistant thermoplastic.
5. JUMPER BRAID: Silver coated copper wire braid.
6. CRIMP: Copper Alloy 102 per ASTM B75. Tin plated per MIL-T-10727. Red stripe code.

APPLICATION

1. This kit is designed to provide an immersion resistant splice in 210-37528-1 cable when installed as outlined herein.
2. Kit may be used on coaxial cables having silver plated braid and dielectric and insulation of PTFE or Irradiated PE Foam.
 - Cable dimensions shall be within the range:
 - Conductor: 26 – 20 AWG (conductors smaller than 0.51 (0.020) must be folded back).
 - Jacket: 2.79 to 3.94 (0.110 to 0.155)

INSTALLATION PROCEDURE

Slide Stress transfer sleeve, Cable sealing sleeve, Soldersleeves and Jumper braid over the cable.

I. CONDUCTOR SPLICE

- A. Strip cables to dimensions shown in Figure 1.

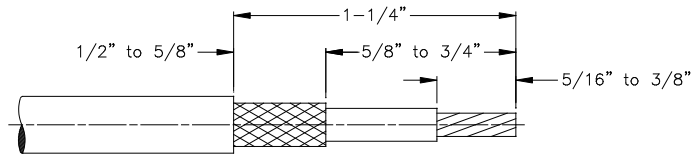



Figure 1

- B. Slide the crimp sealing sleeve over the conductor before crimping.
Crimp cable center conductors into ends of metal crimp splicer, using one of the crimp tools listed.
- C. Slide the crimp sealing sleeve into position so that the metal crimp splicer is centered between the sealing rings.

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II. SHIELD SPLICE

- A. Slide the SolderSleeve onto second cable. Slide jumper braid over splice assembly. End of jumper braid should overlap shield of first cable. Twist jumper braid down tightly on shield of first cable (see Figure 2). Jumper braid should not overlap cable jacket.

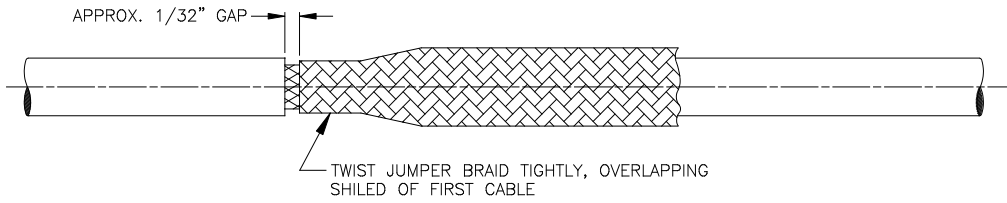


Figure 2

- B. Slide SolderSleeve into position so that solder ring is centered on shield-braid overlap. (Figure 3). Apply heat until solder ring melts and flows into the braid. SolderSleeve will shrink tightly onto cable jacket and jumper braid.

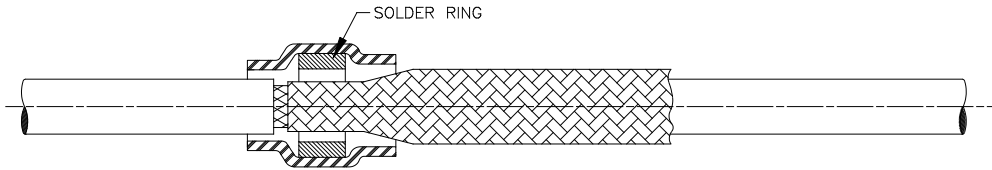


Figure 3

- C. “Milk” the jumper braid down tightly, moving toward the second cable. Free end of jumper braid must overlap shield of second cable. Jumper braid should not overlap cable jacket. Trim off excess jumper braid if necessary.

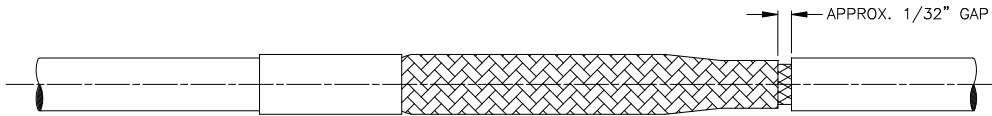


Figure 4

- D. Position second soldersleeve over the jumper braid-shield overlap and heat as in Step II B.
- E. Center the cable sealing sleeve over the splice area. Ends of sealing sleeve should overlap outer jacket of cables by at least ¼ inch (Figure 5).

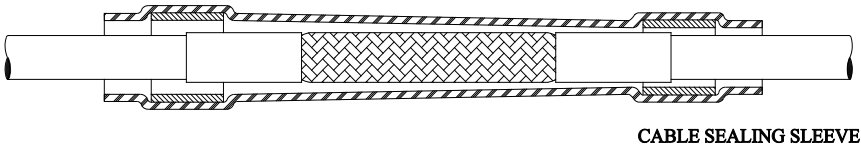



Figure 5

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- F. Apply heat to center of cable sealing sleeve until sleeve recovers and inner sealant melts. Work heat slowly along the sleeve, toward one end. Apply heat at the end of the sleeve until sleeve changes from light blue color to light brown color. Slight amount of clear sealant may extrude from end of sleeve. Heat other end in the same manner.
- G. Center Stress Transfer Sleeve over assembly to recover.

APPLICABLE RAYCHEM HEATING TOOLS:

AA-400	Super heater with SolderSleeve Reflector
CV-5300	Mini-gun with MG-1 SolderSleeve Reflector
CV-4505	Shop Air Heater with SolderSleeve Tip
500 A	Thermogun with TG-14A Reflector

APPLICABLE CRIMP TOOLS:

- 1. Raychem AD-1377 Crimp Tool
- 2. MS 3191-4 Class I Hand Crimp Tool (see note A)

NOTE:

- A) Care must be exercised in using the MS 3191-4 Crimp tool, without turret, to insure proper location of the crimp splicer relative to indenters. Indenters must contact splicer barrel midway between the wire stop and end of splicer. (See Figure 6).

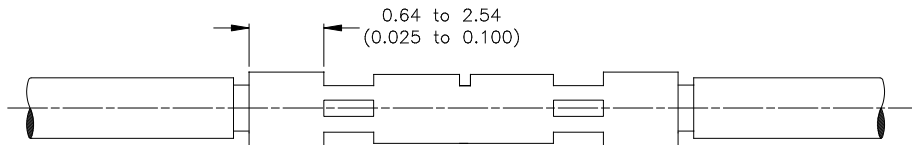



Figure 6

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