SPECIFICATION CONTROL DRAWING

101.60±3.81
(4.000±0.150)

AS RECEIVED ø12.70 MIN (ø0.500 MIN)   RECOVERED ø6.35 MAX (ø0.250 MAX)

1) SEALING SLEEVE

12.70±3.05 (0.500±0.120)   49.78±2.03 (1.960±0.080)   AS RECEIVED ø11.94 MIN (ø0.470 MIN)

RECOVERED ø6.86 MAX (ø0.270 MAX)

2) SHIELD SPLICE

13.97±0.76 (0.550ø0.030)   AS RECEIVED ø11.43 MIN (ø0.450 MIN)

RECOVERED ø3.81 MAX (ø0.150 MAX)

3) FILLER SLEEVE

27.94±0.51 (1.100±0.020)   AS RECEIVED ø11.43 MIN (ø0.450 MIN)

RECOVERED ø3.81 MAX (ø0.150 MAX)

4) INSULATOR

14.73 (0.580)
14.48 (0.570)   2.64 (0.104)
2.43 (0.096)

3.91 (0.154)
3.73 (0.147)

COLOR CODE: YELLOW

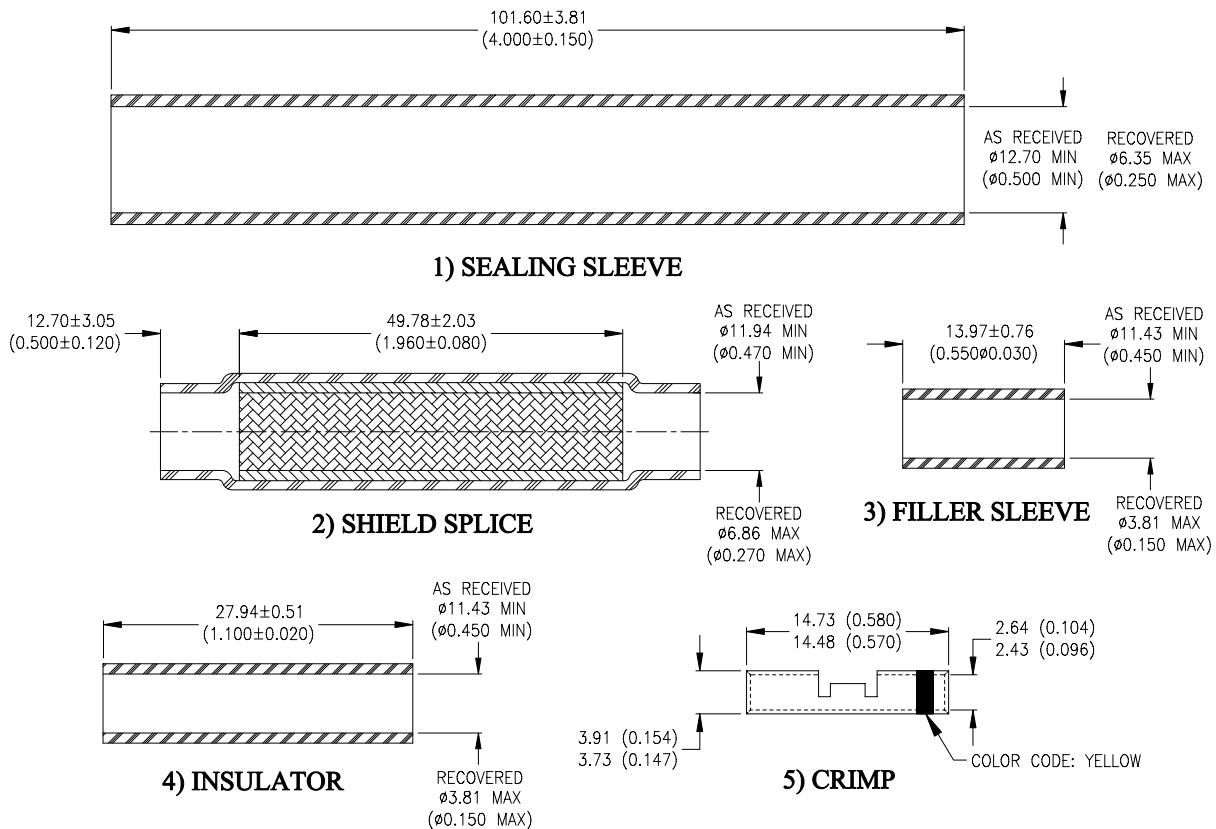## 5) CRIMP

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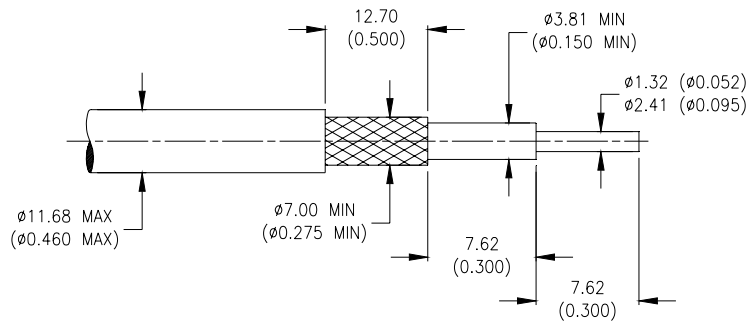   SIZE RANGE: 16 to 12 AWG, (1900 – 6755 circular mils).

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, VIlb, 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 Electronics	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

12.70 (0.500)

ø3.81 MIN (ø0.150 MIN)

ø1.32 (ø0.052)
ø2.41 (ø0.095)

ø11.68 MAX (ø0.460 MAX)

ø7.00 MIN (ø0.275 MIN)

7.62 (0.300)

7.62 (0.300)

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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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: 2 of 2	

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>>TE Connectivity(泰科)