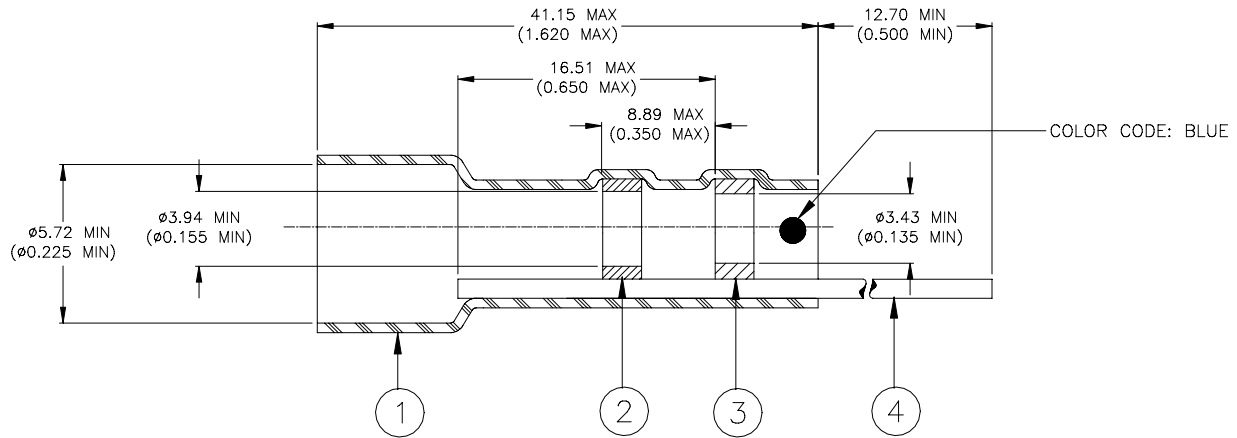


## SPECIFICATION CONTROL DRAWING



### 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 ROL1 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

<b>tyco / Electronics / Raychem</b> 307 Constitution Drive, Menlo Park, CA 94025, USA		<b>Wire and Harnessing Products</b>	TITLE: <b>20 AWG BUSS WIRE, SOLDERSLEEVE, PADDLECARD TERMINATOR</b>				
Unless otherwise specified dimensions are in millimeters. Inches dimensions are in between brackets.			DOCUMENT NO.: <b>D-134-04</b>				
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.	DCR NUMBER: D010438	REPLACES: N/A			
DRAWN BY: M. FORONDA	DATE: 18-July-01	PROD. REV. E	DOC ISSUE: 1	SCALE: None	SIZE: A	SHEET: 1 of 3	

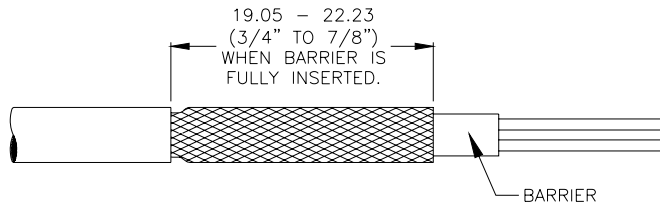
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# SPECIFICATION CONTROL DRAWING

## INSTALLATION PROCEDURE:

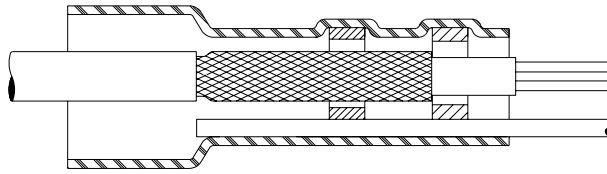
### A: SHIELDED CABLE

- 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.



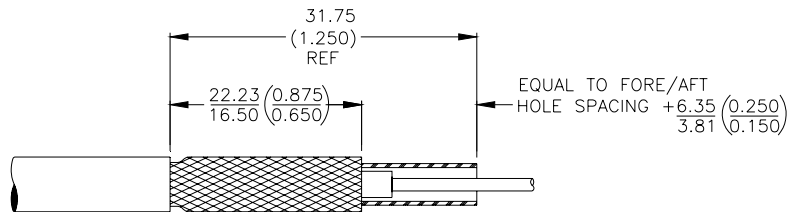
**FIGURE 2**

- 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

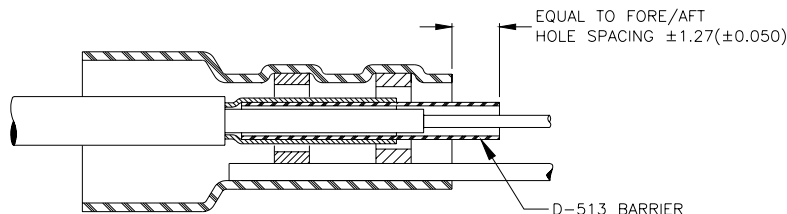
This procedure must be followed when terminating coaxial cables with low temperature (less than 125°C) dielectric or high temperature dielectric with high shrink-back characteristics. It is recommended for all coaxial cable applications to reduce stress on center conductor/Paddlecard joint.

- Cable is to be prepared as follows:
  - Remove  $44.45 \pm 3.18$  (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 [ $\pm 1.27$  ( $\pm 0.050$ )], see Figure 4.



**FIGURE 4**

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## SPECIFICATION CONTROL DRAWING

- 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).

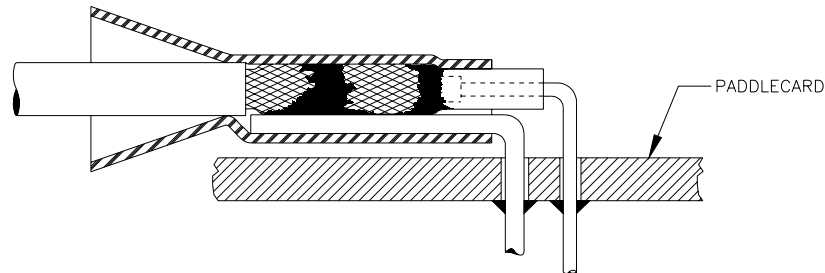


FIGURE 5

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