

**Single Shield Cable with Solder Sleeve Primary Splice.**

26. Prepare the cable using the following procedure:

- a. Remove 31mm of cable jacket (Figure 5–27).
- b. Trim shield to 9mm from cable jacket.
- c. Strip primary conductors 12.7mm and pre-tin.
- d. Trim fillers flush with shield.

27. Assemble as follows:

- a. Place D-150-0124-01 outer sleeve and D150-0124-02 shield splice (small end first) onto one cable.
- b. Insert primary conductors in D-150-0124-03 primary splice assembly.

- c. Overlap conductors under solder preforms.
- d. Use a holding fixture to hold wires in alignment.

**WARNING**

Use only hot air gun M83521/5-01 or equivalent on fuelled aircraft.

**WARNING**

Use of nitrogen with hot air gun M83521/5-01 in an enclosed area can be hazardous. Ensure area is well ventilated.

- e. Heat solder preforms until they melt and form a fillet along wires.

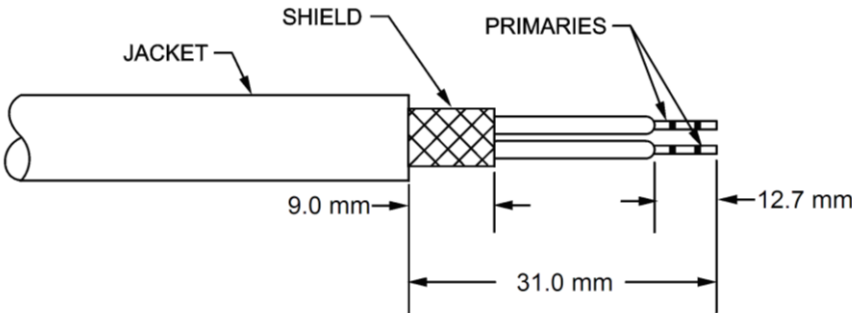


Figure 5–27 Single Shield Cable Strip Dimensions

Table 5–4 Tooling

Name	Part Number
Crimp Tool	AD-1377 or M22520/10-01 with die M22520/10-104
Holding Fixture	AD-1319
Hot Air Gun	M83521/5-01
Databus Harness Tester (Aircraft specific test leads required)	S2476N