

## User Manual of Heat Shrink Solder Ring

### 1. Sample Preparation

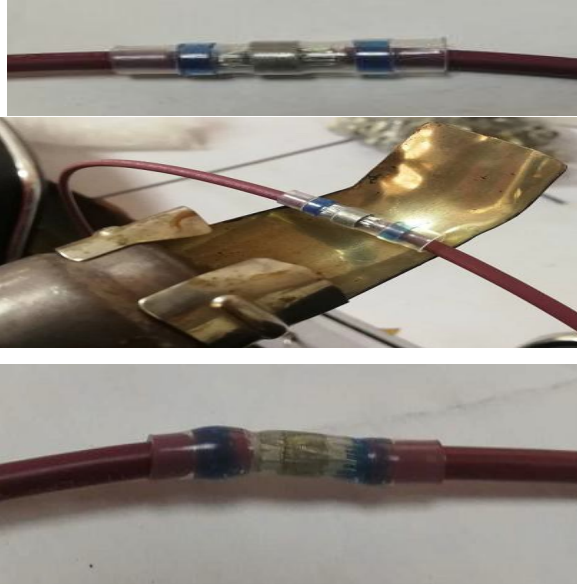
- 1.1 Prepare two wires with suitable diameter, peel off the wire sheath of each wire with the length of 7~10MM.



- 1.2 Spread out the wire, cross and connect both wires the way like the first picture as below, then make the connecting points round and smooth like the second picture as below



1.3 Place the solder ring into the middle, use the hot air gun to heat the rubber ring on both sides first until both sides shrink, then heat the solder ring in the middle until it is melted completely.



## 2. Required tools and Precautions:

2.1 Hot air gun with reflector, Temperature Range: 350-450°C.

2.2 Infrared heating equipment is not recommended for use on black wires and cables and cannot be used on uncross-linked wires.

2.3 If the solder ring is used on uncross-linked wire, the temperature for hot air shall less than 300°C.

2.4 Avoid the overheating situation.

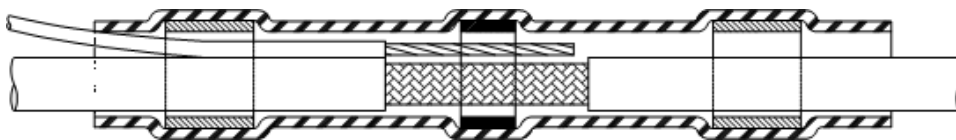
## 3. Heating Process

3.1 Assemble the shielded ground wire and cable as shown in picture 1 as below, put on the solder tube and fix it in place. The exposed end of the shielded ground wire must be long enough to cross the tin ring

3.2 After the cables, shielded ground wires and solder tubes are assembled as showed in picture 1, use a hot air gun to heat, shrink and seal.

3.3 Start to heat evenly from both ends to shrink the sleeve and melt the rubber ring to form a sealing ring.◦

3.4 Continue to heat evenly until the solder melts, flows, and completely penetrates the shielding ground wire and cable braid.



Picture 1

#### 4. Inspection

1. The exposed end of the shielded ground wire must be long enough to cross the tin ring, but cannot cross the entire shielding section of the cable.
2. The heat shrinkable sleeve must shrink to tightly wrap the cable, and at the same time, it must not be overheated to cause the sleeve to melt, carbonize or crack.
3. The solder ring must be heated until it is completely melted and completely impregnated into the ground shield ground wire and cable braid.
4. There should be no wires piercing the heat shrink sleeve or tin material leaking out.



Picture 2

( Unqualified product, insufficient heating, Solder ring is not completely melted )



Picture 3

(Qualified product, the Solder ring is completely melted and completely impregnated into the ground shield, ground wire and cable braid.)