VERIFICATION OF 219 TYPE CONNECTOR, COAXIAL SPLICE

CONTENTS

1. GENERAL

1.1 Scope of Section

1.11 This section covers requirements for verifying that coaxial cable splices have been properly made using 219 type connectors.

1.2 Requirements

1.21 The requirements used in this section were established from BSP 800-612-164.

1.22 The verifications listed in this section should be performed before the circuits containing the 219 type splices are put into service.

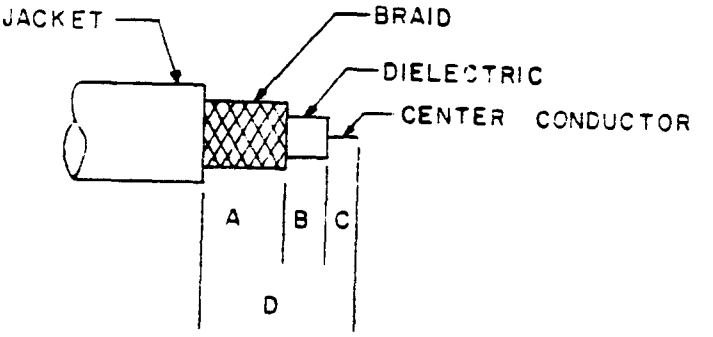
1.3 Service Outages

1.31 The 219 type connector has been a major source of Service Outages with many of these outages the result of poor workmanship. The verification procedures listed in this section are meant to prevent any of these work manship items from getting into the system.

2. CABLE PREPARATION

2.1 The installer should have prepared coaxial cables for his 219 type connector in accordance with Section 749, Paragraphs 6.1 to 6.3 and Table A. There are eight types of 219 Connectors.

2.2 Table A from Section 749 is reproduced below.



METHOD OF PREPARING CABLE

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3. CONNECTING CABLES

3.1 Verify that the proper 219 type connector was used to splice cables (Table B).

3.2 Verify that proper outer sleeve was used on crimp to each cable (Table B).

TABLE A

CABLE	219 TYPE CONNECTOR	DIMENSION			
		BRAID	DIELECTRIC	CENTER COND.	TOTAL DIM.
730	219A,219B,219E	1/2	1/16	3/16	3/4
724	219A,219C,219D,219G,219H	1/2	1/16	3/16	3/4
KS-19224,L-2	219B,219F,219H	1/2	1/8	3/16	13/16
KS-19224,L-1	219D	1/2	1/8	3/16	13/16
KS-19906	219G	1/2	1/16	3/16	3/4

TABLE B

219 TYPE CONNECTOR	CONNECTS CABLES:	OUTER SHIELD CONNECTOR KS-15712,L-	OUTER SHIELD CONNECTOR COLOR CODE
219A	730 to	20	YELLOW (O.D. .297)
(SEE NOTE)	724	22	TIN (O.D. .372)
219B	730 to	20	YELLOW (O.D. .297)
(SEE NOTE)	KS-19224,L-2	38	RED (O.D. .179)
219C	724 to	22	TIN (O.D. .372)
(SEE NOTE)	724	22	TIN (O.D. .372)
219D	724 to	22	TIN (O.D. .372)
(SEE NOTE)	KS-19224,L-1	36	BLUE (O.D. .152)
219E	730 to	20	YELLOW (O.D. .297)
(SEE NOTE)	730	20	YELLOW (O.D. .297)
219F	KS-19224,L-2 to KS-19224,L-2	38 38	RED (O.D. .179) RED (O.D. .179)
219G	724 to	22	TIN (O.D. .372)
(SEE NOTE)	KS-19906	1	BLUE (O.D. .215)
219H	724 to	22	TIN (O.D. .372)
(SEE NOTE)	KS-19224,L-2	38	RED (O.D. .179)

NOTE: Information shown in the above tables for the 724 cable may also be used for the 728A cable and information shown for the 730 Cable may be used for the 731 Cable.

3.3 Verify the outer sleeve of each crimp to insure it complies with the following:

a) No cracks in outer sleeve
b) No evidence of double crimp
c) No portion of the outer covering of a cable jacket shall be crimped under the outer sleeve.
d) The crimped outer sleeve shall be located within 1/32 inch of butting against 219 barrel.
e) The crimped portion of the outer sleeve shall be minimum 1/4 inch measured along the axial dimension of the sleeve.
f) The crimped outer sleeve shall exhibit six approximately flat surfaces with no fins or excessive rounding at the 60-degree corner bends.

3.4 When the crimped connection looks bad verification that the proper crimping tool was used can be made by referring to Table B of Section 749.

4. VERIFICATION OF SOLDERED CONNECTION

4.1 The main causes of SERVICE OUTAGES involving 219 type connectors has been no solder or too much solder on the center conductors of the splice.

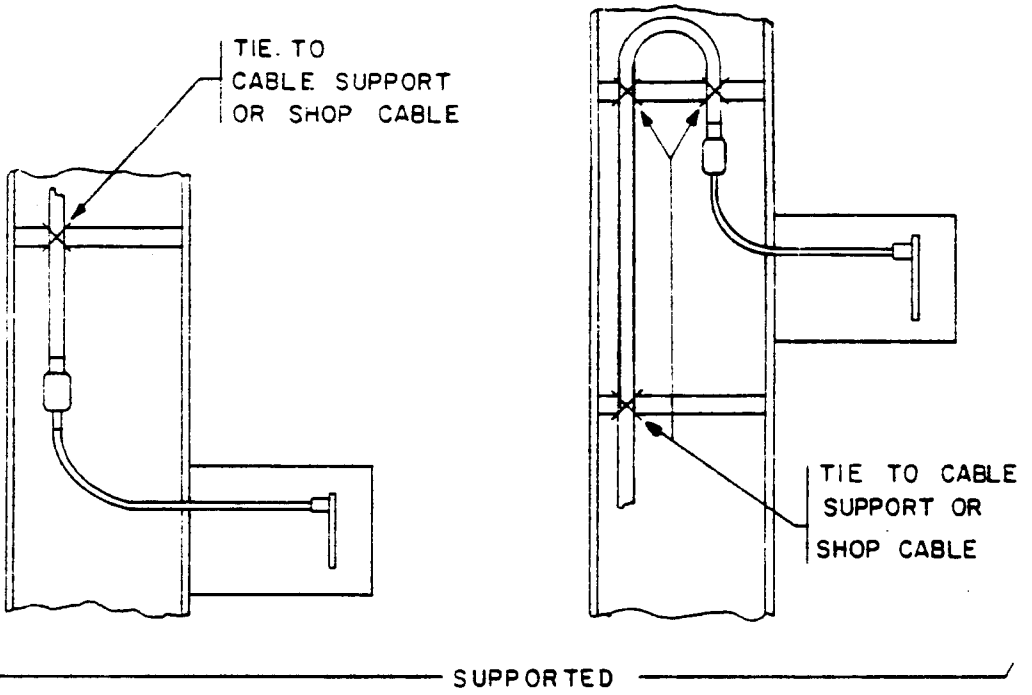
4.2 Verify that both sides shop and installer made solder center conductor connection are soldered.

4.3 Verify that solder flow is around entire center conductor area. Verify that both center conductor wire outlines are visible under solder.

4.4 Verify that no solder splash is between center conductor and the body of 219 connector.

4.5 Droplets of solder that may have formed while soldering should not be allowed to remain within the 219 connector body.

5.2 Verify that when a connection has been made within a cable duct and larger cable requirements were such that an excessive amount of slack was present, the slack has been fed back onto the cable rack. Mini cable slack should not have been fed back onto the rack. The portion of cable left in the duct should be tied to the cable straps



EXAMPLES OF SUPPORTING MINI-CABLE.

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5. VERIFY THAT SUPPORT HAS BEEN PROVIDED TO ELIMINATE STRAIN ON 219 CONNECTOR AND KS-19224 MINI CABLE

5.1 Verify that when 219 connector is used to connect a KS-19224 miniature coaxial cable to a larger cable, the connector has been positioned so that it and the mini cable are supported by the larger cable (see above).

REASON FOR REISSUE:
To remove reference to KS-15712 list 5 outer sleeve from Table B.

to insure protection for the 219 connector in congested cable ducts or where future work will take plate.

6. VERIFICATION OF SPLICE CLOSING

6.1 Verify that screw which holds connector sleeve to body is in place.

6.2 Verify that connector is taped with overlapping turns of tape extending 1/4 inch beyond each end of the connection, or KS-21886L-1 sleeving is over 219 connector.

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