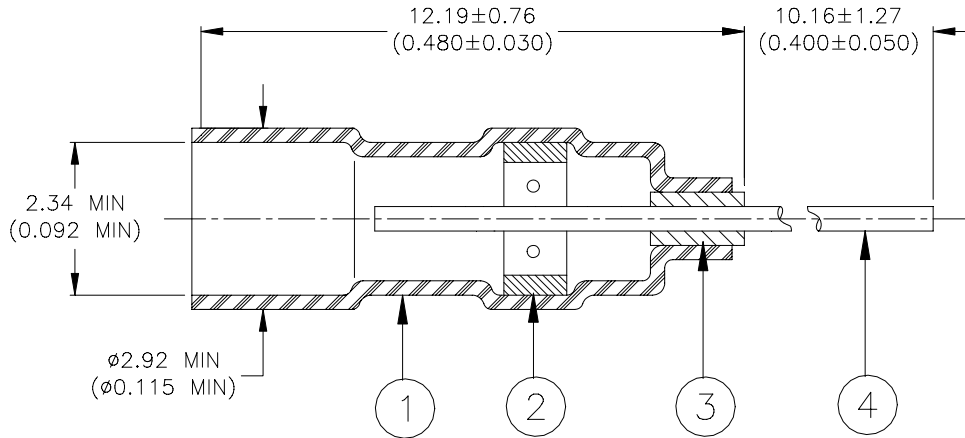


SPECIFICATION CONTROL DRAWING



MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride. Recovered I.D.: 1.27 (0.050) max.
2. SOLDER PREFORM WITH FLUX:
SOLDER: TYPE Sn63 per ANSI J-STD-006.
FLUX: TYPE ROL1 per ANSI J-STD-004.
3. SPACER SLEEVE: Radiation cross-linked modified polyvinylidene fluoride.
4. PRE-INSTALLED PIN: 21 AWG (0.74 (0.029) dia., Solder (Sn63) plated phosphor bronze.

APPLICATION

1. This sleeve is designed to splice wires to the pre-installed pin. Part will accept 1 or 2 wires having a cross-sectional area (CMA) between 750 and 1250 (range may be extended to 2500 if conductors are pre-tinned).
2. Wires are to be stripped 6.35 – 7.92 (0.250 – 0.312), pre-tinned if necessary, and inserted to the shoulder in the sleeve. The part is then heated, using a Raychem approved infrared or convection heat source and reflector until the solder performs melts, flows and forms a fillet between the conductors and the pre-installed lead.

tyco / Electronics / Raychem		Wire and Harnessing Products	TITLE : SOLDERSLEEVE TERMINATOR WITH PIN				
307 Constitution Drive, Menlo Park, CA 94025, USA							
Unless otherwise specified dimensions are in millimeters. Inches dimensions are in between brackets.			DOCUMENT NO.: D-141-0171				
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: D010435		REPLACES: N/A		
DRAWN BY: M. FORONDA	DATE: 13-July-01	PROD. REV. A	DOC ISSUE: 1	SCALE: None	SIZE: A	SHEET: 1 of 1	

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