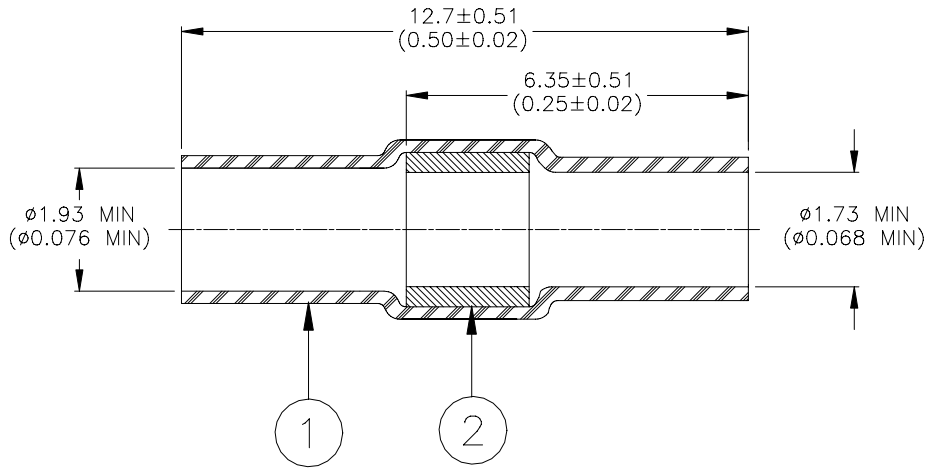


## SPECIFICATION CONTROL DRAWING



### MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
2. SOLDER PREFORM WITH FLUX:  
 SOLDER: TYPE Sn63 per ANSI J-STD-006.  
 FLUX: TYPE ROL1 per ANSI-J-STD-004.

### APPLICATION

1. This sleeve is designed to connect leads having a pretinned conductor and an insulation rated for not less than 125°C to flat cable conductors having maximum widths of 1.65 (0.065) across the insulation, pre-tinned conductors and insulation rated for at least 125°C.
2. For assembly techniques, see page 2.
3. Temperature Rating: -65°C to 150°C.
4. Sleeve will recover to 0.76 (0.030) max. I.D.

<b>Raychem Interconnect</b> <small>a division of tyco ELECTRONICS</small> 300 Constitution Drive Menlo Park, CA 94025, USA		THERMOFIT DEVICES		TITLE: <b>SOLDERSLEEVE, FLAT CABLE                  TERMINATION, 1.73 (0.068) I.D.</b>			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS. INCHES DIMENSIONS ARE BETWEEN BRACKETS.				DOCUMENT NO.: <b>D-110-19</b>			
TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A	ANGLES: N/A  ROUGHNESS IN MICRON	Raychem reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.		DCR NUMBER: D990945		REPLACES: N/A	
DRAWN BY: M. FORONDA	DATE: 06-July-00	PROD. REV. D	DOC ISSUE: 1	SCALE: None	SIZE: A	SHEET: 1 of 2	

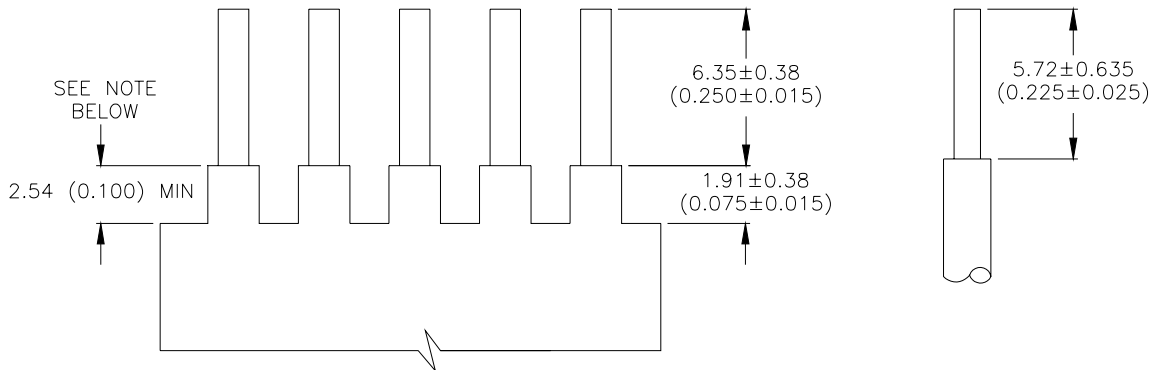
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# SPECIFICATION CONTROL DRAWING

## THERMOFIT ASSEMBLY PROCEDURE FOR D-110-19

### 1. Preparation of Cable and Lead:

Prepare the cable and lead as shown:

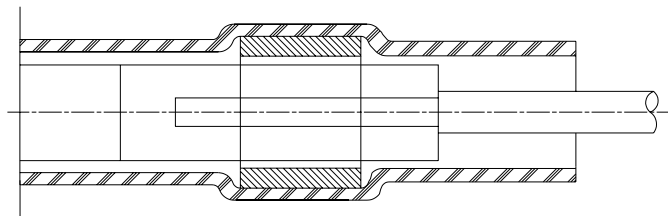


**NOTE:** If cable has a shield over the conductor, it should be cut off at a point not closer than 2.54 (0.100) from the end of the stripped conductor, and ground lead extended as shown in drawing for termination.

Stripped sections of cable and lead are to be pretinned with Sn60 or Sn63 solder, using appropriate flux, and be cleaned after tinning with a non-corrosive material such as trichloroethylene and dried with clean, lint-free wipers.

### 2. Installation of Sleeve:

- a) Place SolderSleeves over conductors of cable so that it covers the insulation remaining on the conductors and solder is centered over the cable strip area.
- b) Insert stripped end of lead into sleeve so that the stripped sections are aligned under the solder preform.



- c) With assembly clamped in place, apply heat until solder ring melts and flows. Heat should be applied with the IR-1012 infrared heater, using AD-1323 wire holding fixture and AD-1352 cable clamp; or a Rayclad Tubes Shop Air Heater CV-4505 operated at 2 1/2 - 3 1/2 psi. Nozzle should be held approximately one quarter inch from the sleeve, applying heat to one sleeve at a time.

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DRAWN BY: M. FORONDA	DATE: 06-July-00	PROD. REV. D	DOC ISSUE: 1	SCALE: None	SIZE: A	SHEET: 2 of 2	

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