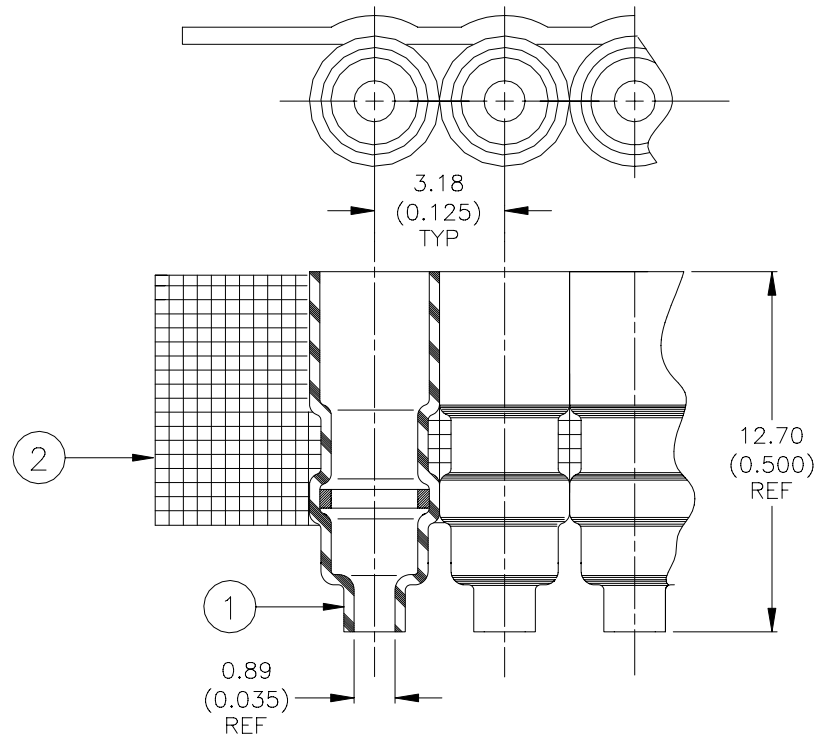


SPECIFICATION CONTROL DRAWING



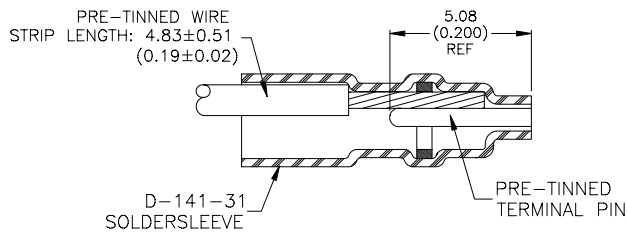
MATERIALS

1. SOLDERSLLEEVE: D-141-31. Quantity Per Assembly: 1000
2. CARRIER STRIP: Adhesive Coated High Temperature Tape

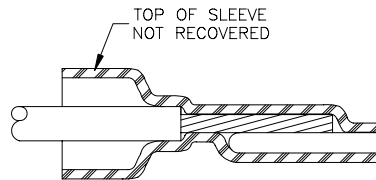
APPLICATION

1. This assembly is designed for terminating 26 AWG to 22 AWG PVC wire to connectors having 0.64 (0.025) square pins on 3.18 (0.125) center spacing.
2. Sleeves are to be installed using Raychem-approved convection or infrared heating tools.
3. Strip wires to 4.83 ± 0.50 (0.190 \pm 0.02) and pre-tin.
4. Trim connector terminals, if required to 5.08 (0.200) and pre-tin.
5. Heat should be applied until the solder perform melts and flows. The insulation sleeve will partially recover down onto the wire insulation sleeve near the solder joint. The tops of the sleeves should not recover onto wire insulation (see fig. below). Enough heat has been applied when the solder perform has completely lost its original shape on all sides of the termination and a fillet of solder is formed between conductor and terminal.

Solder Sleeve and Lead in Position for Assembly



Terminated Assembly



tyco <i>Electronics</i>	Raychem	Tyco Electronics Corporation 300 Constitutional Drive Menlo Park, CA 94025 USA	TITLE: SOLDERPAK ASSEMBLY, 0.64 (0.025) square x 5.08 (0.200) Terminals on 3.18 (0.125) Center Spacing, PVC Wire				
Unless otherwise specified dimensions are in millimeters. Inches dimensions are in between brackets.			DOCUMENT NO.: D-711-07				
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.	DATE: 22-Jun-01		DOC ISSUE: 1		
DRAWN BY: M. FORONDA	CAGE CODE: 06090	REPLACES: N/A	DCR NUMBER: D010412	PROD. REV.: A	SCALE: None	SIZE: A	SHEET: 1 of 1

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