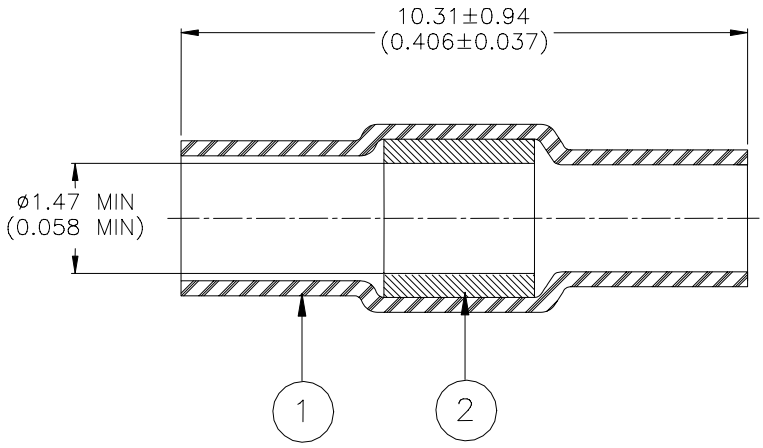
SPECIFICATION CONTROL DRAWING



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. Part will recover to 0.76 (0.03) .
2. This part is designed to meet the requirements as shown below when tested to Raychem Specification RT-1404.

QUALIFICATION TEST ASSEMBLIES

The test configuration shall be a follow-through splice made by connecting two wires having 26 AWG tin or silver plated conductors and insulations rated for at least 125°C.

REQUIREMENTS:

Temperature Rating	150°C
Voltage Drop**	Initial 25 millivolts max.
Tensile Strength*	7 lbs. min.
Vibration**	MIL-STD-202, Method 204, Condition D Voltage Drop after Vibration - 32 millivolts max.
Temperature Cycling**	-63±3°C to 150±3°C, 5 cycles (Condition C) Voltage Drop after Cycling - 32 millivolts max.
Current Cycling**	Voltage Drop after Cycling - 32 millivolts max.
Heat Aging*	120±2 hours at 200±3°C.
Fluid Resistance*	20 hours at 25±3°C in fluids of MIL-H-5606, MIL-I-7808, and MIL-L-9236.
Corrosion Resistance*	96 hours at 35±3°C (Condition A). Voltage Drop after test - 32 millivolts max
Corrosive Effect*	16 hours at 121±2°C, Non-corrosive

* For test procedures, see Raychem Specification RT1404.
** For test procedures, see page 2.

Raychem Interconnect a division of tyco ELECTRONICS 300 Constitution Drive Menlo Park, CA 94025, USA		DEVICES	TITLE: **SOLDERSLEEVE** **1.47 (0.058) I.D. MINIATURE**			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS. INCHES DIMENSIONS ARE BETWEEN BRACKETS.			DOCUMENT NO.: **D-110-00**			
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: D000141		REPLACES: n/a	
DRAWN BY: M. FORONDA	DATE: 22-Mar-00	PROD. REV.: P	DOC ISSUE: 1	SCALE: None	SIZE: A	SHEET: 1 of 2

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SPECIFICATION CONTROL DRAWING

TEST PROCEDURES:

Voltage Drop: As outlined in RT-1404 with these exceptions:
Shall be measured with a 3.0 amp current imposed on splice.
Measured over a two inch length which includes the splice.

Vibration: Splices shall be mounted so that the center of the splice is 152.4±12.7 (6.0±0.5) from the vibrating member. The splice shall then be vibrated as indicated. One axis of vibration shall be parallel to the splices wires. Upon completion, the voltage drop shall be measured as outlined above.

Current Cycling: Three foot lengths of wire shall be spliced and subjected to 50 current cycles. Each cycle shall consist of 30 minutes at 3.75 amperes, followed by 15 minutes at no lead. Voltage drop shall be measures as outlined above.

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