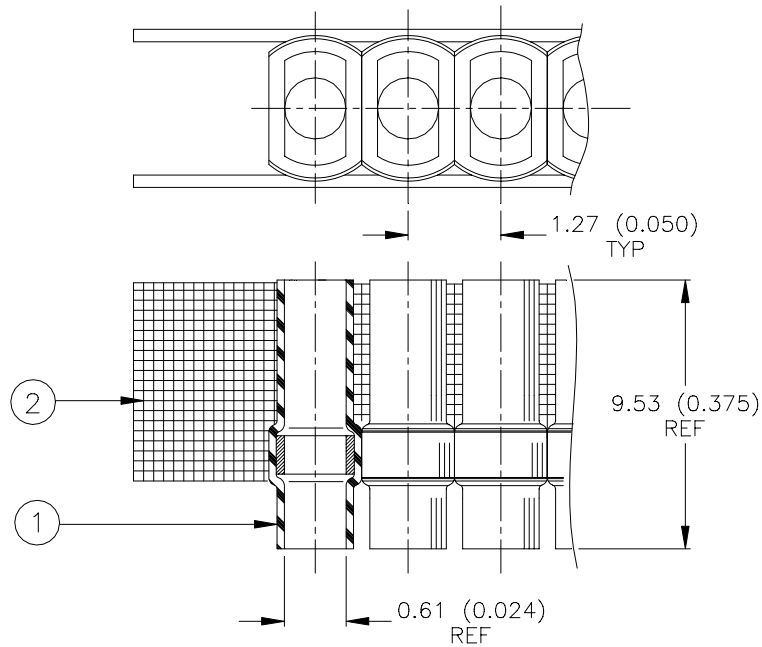


# SPECIFICATION CONTROL DRAWING



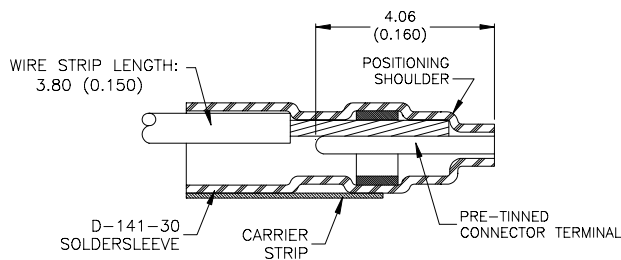
**MATERIALS**

1. SOLDERSLLEEVE: D-141-30. Quantity Per Assembly: 1000
2. CARRIER STRIPS: Adhesive Coated High Temperature Tape

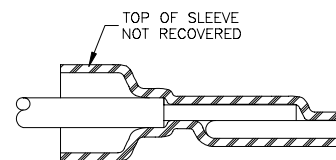
**APPLICATION**

1. This assembly is designed to terminate a single 26, 28, or 30 AWG PVC insulated wire to micro-miniature connectors with terminals on 1.27 (0.050) center spacing.
2. Sleeves are to be installed using Raychem-approved convection or infrared heating tools.
3. Strip wires to 3.81 (0.150).
4. Trim connector terminals, if required to 4.06 (0.160) 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. 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.

*SolderSleeve and Lead in Position for Assembly*



*Terminated Assembly*



<b>tyco</b> <i>Electronics</i>		<b>Raychem</b>		Tyco Electronics Corporation 300 Constitutional Drive Menlo Park, CA 94025 USA		TITLE: <b>SOLDERPAK ASSEMBLY, MICRO-MINIATURE CONNECTOR</b> 1.27 (0.100) Center Spacing									
Unless otherwise specified dimensions are in millimeters. Inches dimensions are in between brackets.						DOCUMENT NO.: <b>D-713-03</b>									
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:  25-Jun-01		DOC ISSUE:  1							
DRAWN BY: M. FORONDA		CAGE CODE: 06090		REPLACES: N/A		DCR NUMBER: D001338		PROD. REV.: A		SCALE: None		SIZE: A		SHEET: 1 of 1	

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