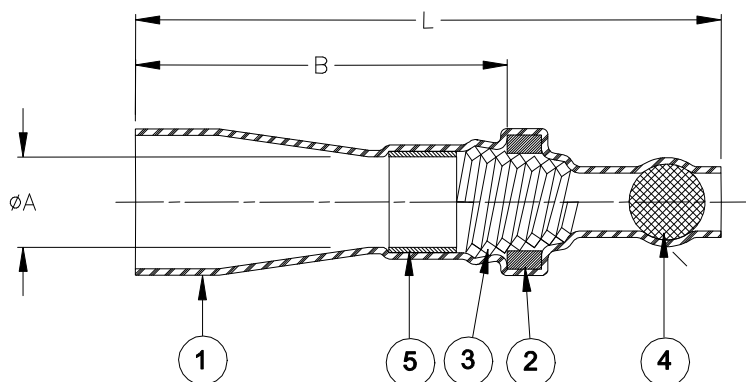


SPECIFICATION CONTROL DRAWING



Product Name	Ball Color	Product Dimensions			Copper Cross Section		Bundle Diameter	
		$L \pm 3.5$ ($L \pm 0.140$)	ϕA	B	Min. mm^2 (CMA)	Max. mm^2 (CMA)	ϕD max	$M \pm 1$ ($M \pm 0.04$)
SGRS-1	Green	38.3 (1.510)	$3.6 + 0.4/-0.2$ ($0.140 + 0.016/-0.008$)	26.0 ± 2.0 (1.025 ± 0.079)	0.7 (1400)	2.4 (4800)	3.3 (0.130)	15.0 (0.590)
SGRS-2	Red	37.7 (1.485)	$5.0 + 0.7/-0.2$ ($0.200 + 0.028/-0.008$)	23.5 ± 2.0 (0.925 ± 0.079)	2.0 (4000)	4.0 (8000)	4.5 (0.175)	15.0 (0.590)
SGRS-3	Blue	45.5 (1.790)	$7.5 + 0.9/-0.2$ ($0.295 + 0.035/-0.008$)	26.5 ± 2.0 (1.045 ± 0.079)	3.5 (7000)	8.0 (16000)	7.0 (0.275)	15.0 (0.590)
SGRS-4	Yellow	45.0 (1.770)	$9.4 + 0.9/-0.3$ ($0.370 + 0.035/-0.012$)	25.5 ± 3.0 (1.005 ± 0.118)	7.5 (15000)	12.0 (24000)	9.0 (0.350)	15.0 (0.590)

These products are tested to RB109.

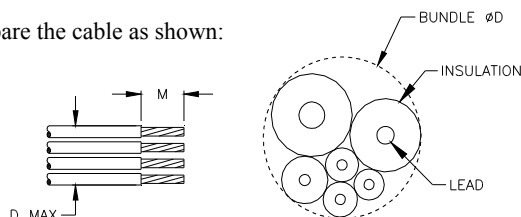
MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
2. SOLDER PREFORM WITH FLUX:
SOLDER: TYPE Sn60 per ANSI-J-STD-006.
FLUX: TYPE ROM1 per ANSI-J-STD-004.
3. CONICAL SPRING: Square copper wire.
4. END CLOSURE BALL: Tinted glass. Color: see table.
5. SEALING INSERT: Hot melt adhesive.

APPLICATION

1. These controlled soldering devices are designed for stub splicing of stranded wires, with bare copper conductors and an insulation rated for 85°C minimum and 125°C continuous maximum.
2. Temperature range: Class 3, -40°C to +125°C.
3. Vibration range: Class 1 (body).
4. Seal range: Class 2 (watertight against immersion). Immersion resistant sealing is dependent on the wire combinations used. The user should test specific wire combinations. Refer to TE Connectivity / Raychem Specification RB109 for procedures.
5. For installation procedure and application equipment, consult RPIP-820-00.

For best results, prepare the cable as shown:



		TE Connectivity 300 Constitution Drive, Menlo Park, CA. 94025, U.S.A.		<i>Raychem</i>		TITLE: SOLDERGRIP DEVICE STUB SPLICE							
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]						DOCUMENT NO.: SGRS-X							
TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A		ANGLES: N/A ROUGHNESS IN MICRON		TE Connectivity reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.		REV.: A1		DATE: 16-Apr-11					
DRAWN BY: P.TALLY		CAGE CODE: 06090				REPLACES: D040187		DCR NUMBER: D060343		SCALE: NTS		SIZE: A	

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