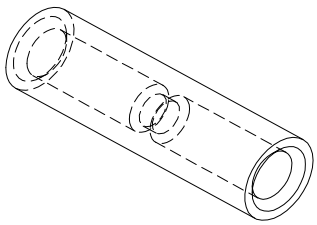
SPECIAL HERMETIC PRODUCTS, INC.
Hi-Rel By Design

39 Souhegan Street - P.O. Box 269, Wilton, New Hampshire 03086
TEL (603) 654-2002 FAX (603) 654-2533
email: sales@shp-seals.com - website: www.shp-seals.com

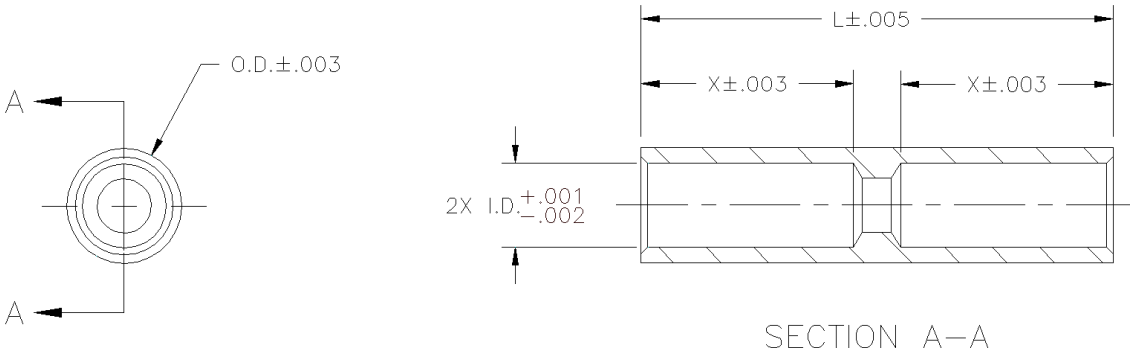
ISO 9001 Certified

SOLDER SLEEVE



These solder sleeves provide a convenient method for making in line splices for attaching wires to feedthru, header or connector pins. They are self fixturing on the pin and both the wire and the pin solder joints are made in a single solder operation (refer to page 2 for application sequence). Shrink sleeving can then be slid into place and shrunk to prevent pin to pin shorts.

PRODUCT APPLICATION	PART NO.	L	OD	ID	X	RECOMMEDED STRANDED WIRE SIZE
.020/.021 Diameter Pin Feedthrus, Headers, HMMD Series Connectors	SPLC-2144	.140	.034	.025	.063	26 AWG
.025 Diameter Pin Feedthrus, Headers, HSMHE and HMMHE Series Connectors	SPLC-2544	.175	.042	.029	.080	24 AWG
.030 Diameter Pin Feedthrus and Headers	SPLC-3044	.175	.047	.036	.080	22 AWG
.035/.040 Diameter Pin Feedthrus and Headers	SPLC-4044	.175	.055	.044	.080	20 AWG



NOTES: (1) Material is Brass.
(2) Standard plating is 300 microinches minimum matte, TIN/LEAD per AMS-P-81728 over 100-200 microinches Electroless NICKEL per SAE AMS-C-26074.

All dimensions are inches.

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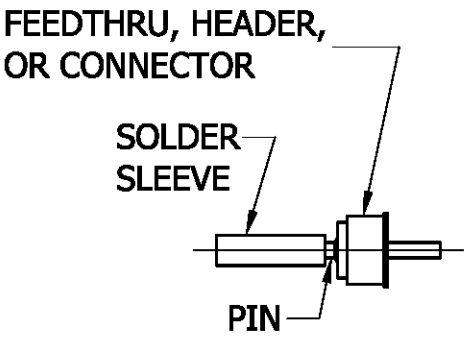
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SOLDER SLEEVE

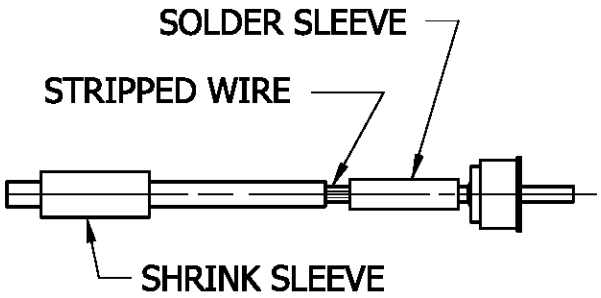
APPLICATION SEQUENCE

A



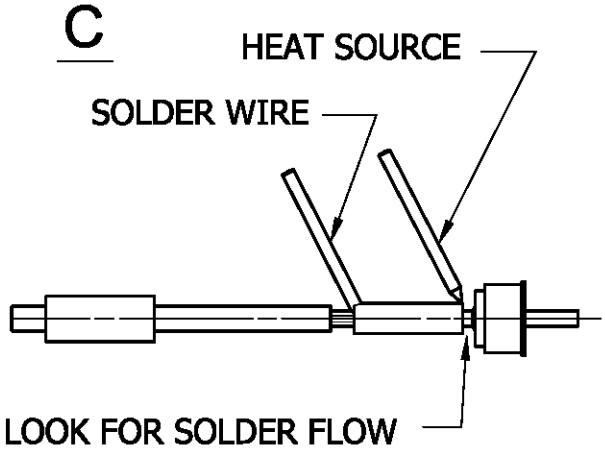
INSTALL SOLDER SLEEVE ONTO PIN

B



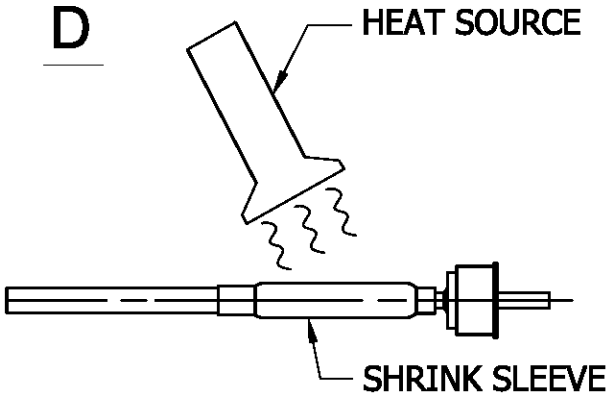
INSTALL SHRINK SLEEVE ONTO WIRE, AND INSERT STRIPPED WIRE INTO SOLDER SLEEVE UNTIL IT STOPS

C



APPLY HEAT TO PIN END OF SOLDER SLEEVE . APPLY SOLDER TO WIRE END OF SOLDER SLEEVE UNTIL SOLDER APPEARS AT PIN END.

D



CLEAN SOLDER JOINTS, SLIDE SHRINK SLEEVE FORWARD AND HEAT TO SHRINK.

(IF THERE ARE MULTIPLE PINS TO BE SPLICED, STEP "D" MIGHT BE UNDERTAKEN AFTER ALL SOLDER SPLICES ARE COMPLETED.)