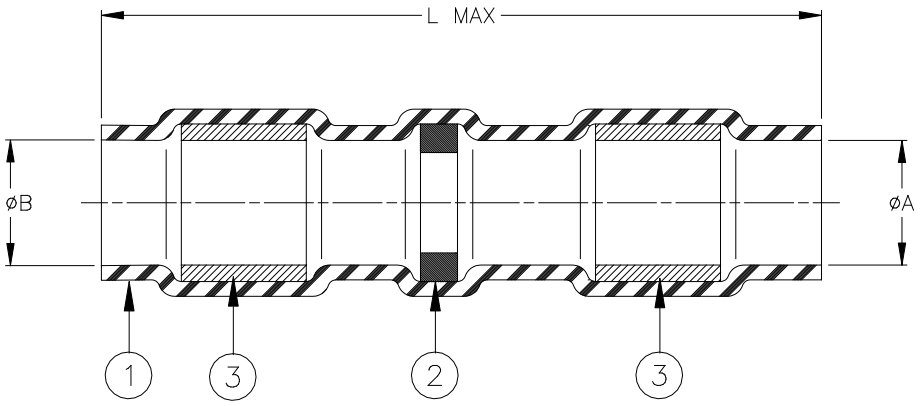
CUSTOMER DRAWING



Product Name	Product Dimensions			Solder Weight Milligrams	Recovered I.D. max	CMA Range*
	L max	øA min	øB min			
D-144-41	26.8 (1.055)	1.9 (0.075)	2.4 (0.095)	42±6	1.27 (0.050)	600 - 1600
D-144-47	26.8 (1.055)	3.8 (0.150)	4.5 (0.177)	118±16	2.16 (0.085)	2800 - 4000
D-144-48	26.8 (1.055)	3.8 (0.150)	4.5 (0.177)	176±24	2.16 (0.085)	3800 - 7500

* Not all combinations of wires equalling listed CMA's will fit in sleeve.
A and B dimensions are measured through the sealing ring closest to that end.

MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked polyvinylidene fluoride.
2. SOLDER PREFORM WITH FLUX: (see table for weights)
   SOLDER: TYPE Sn63 per ANSI J-STD-006.
   FLUX: TYPE ROL0 per ANSI J-STD-004.
3. MELTABLE RINGS: Fluorocarbon-based thermoplastic. Color: gray.

APPLICATION

1. These parts are designed for use in making in-line splices in wires having tin or silver plated conductors and insulations rated for 135°C minimum, meeting the dimensional criteria listed. See table for applicable size ranges.
2. Parts are designed for installation with TE Connectivity-approved infrared heaters. They may also be installed with convection heaters equipped with the correct reflector. The use of a holding fixture will aid in holding the assembly alignment when heating sleeve.
3. Parts will provide environmental protection on splices having no more than 2 wires per side.
4. For ease of inspection, it is recommended that the splice contain no more than 4 wires.
5. All wires are to be stripped 12.7±1.27 (.50±.05) and overlapped under solder preform.

	Raychem THERMOFIT DEVICES		TITLE: **SOLDERSLEEVE* SPLICE**		
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]			DOCUMENT NO.: **D-144-41/-47/-48**		
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: 2	DATE: 09-Mar-2020	
DRAWN BY: M. FORONDA	DATE: 27-Sept-2000	ECO: ECO-20-003687	SCALE: NTS	SIZE: A	SHEET: 1 of 1