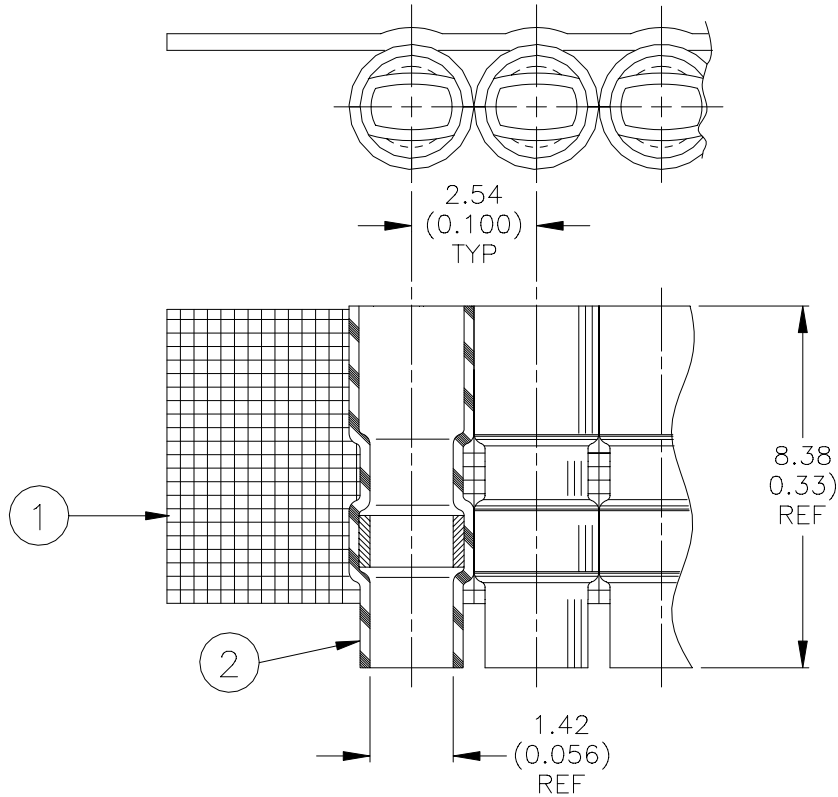


## SPECIFICATION CONTROL DRAWING



### MATERIALS

1. SOLDER SLEEVE: D-129-05. Quantity Per Assembly: 1000
2. CARRIER STRIP: Adhesive Coated High Temperature Tape

### APPLICATION

1. This assembly is designed for use on PCB connectors having eyelet terminals parallel longitudinally with the face of the connector on 2.54 (0.100) center spacing.
2. Sleeves are to be installed using AD-1323 wire holding fixture, AD-1325 connector holding fixture, AD-1324 Bandolier cutter and IR-1012 infrared heater.
3. For certain applications, the CV-4505 shop air heater and AD-1327 connector and wire holding fixture may be used.
4. See page 2 for assembly procedure.

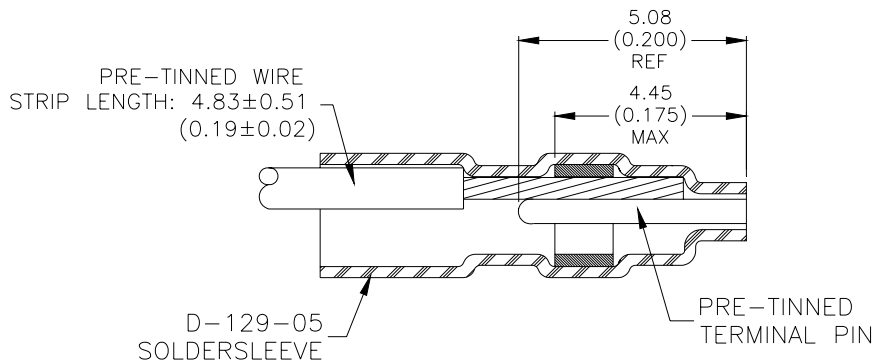
<b>tyco</b> <i>Electronics</i>		<b>Raychem</b>		Tyco Electronics Corporation 300 Constitutional Drive Menlo Park, CA 94025 USA		TITLE: <b>SOLDERPAK ASSEMBLY, PCB CONNECTOR</b> 1.42x0.23x5.08 (0.056x0.009x0.200) Terminals with 2.54 (0.100) center spacing			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS. INCHES DIMENSIONS ARE BETWEEN BRACKETS.						DOCUMENT NO.: <b>D-714-01</b>			
TOLERANCES: 0.00 N/A 0.0 N/A 0 N/A		ANGLES: N/A  ROUGHNESS IN MICRON		Tyco reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.		DATE:  18-July-00		DOC ISSUE:  1	
DRAWN BY: M. FORONDA		CAGE CODE: 06090		REPLACES: N/A	DCR NUMBER: D000405	PROD. REV.: D	SCALE: None	SIZE: A	SHEET: 1 of 2

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# SPECIFICATION CONTROL DRAWING

## THERMOFIT ASSEMBLY PROCEDURE

### SolderSleeve and Lead in Position for Assembly



#### INSTALLATION PROCEDURE:

1. Terminals must be tinned prior to placement of sleeves.
2. Cut the correct number of sleeves from the reel.
3. Position sleeves onto connector terminals as shown above and remove carrier tape.
4. Strip wire 4.83±0.51 (0.19±0.02) and pre-tin.
5. Insert wires onto sleeves. Wires should be straight and parallel to terminal.
6. Heating Technique:
  - a. Infrared Heater IR-1012: Position connector into holding fixture. Place leads to be connected into correct sleeve, (Sleeve will accept up to two 24 AWG leads). Position heater and energize, after setting timer for correct cycle. Refer to IR-1012 Solder Pak Operating Instructions for detailed procedure and maintenance instructions.
  - b. Convection Heater CV4505: Position connector into holding fixture. Place leads to be connected into correct sleeve. Regulate airflow through the nozzle to achieve an air temperature of 600° - 650°F at a point 7.62 (0.30) from the nozzle, (about 2.5 to 3 psi). Apply heat until solder flow is noted.

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