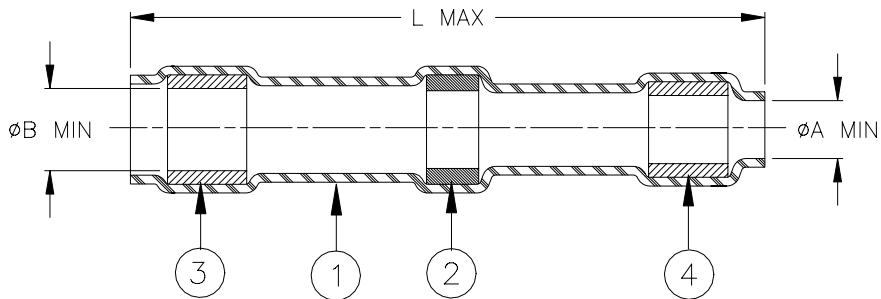


# SPECIFICATION CONTROL DRAWING



Product Revision	Product Name	Product Dimensions			CMA Range
		L max	øA min	øB min	
D-1744-05	B	30.15 (1.187)	1.9 (0.075)	2.4 (0.095)	350 to 2000
D-1744-06	B	30.15 (1.187)	2.8 (0.110)	3.15 (0.125)	2000 to 4000
D-1744-07	B	30.15 (1.187)	4.6 (0.180)	5.1 (0.200)	4000 to 10000
D-1744-08	B	30.15 (1.187)	7.11 (0.280)	7.62 (0.300)	10000 to 13000

## MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked polyvinylidene fluoride.

2. SOLDER PREFORM WITH FLUX:

SOLDER: TYPE Sn63 per ANSI/J-STD-006.

FLUX: TYPE ROM1 per ANSI/J-STD-004.

3. MELTABLE RING: Thermally stabilized thermoplastic. Color: blue.

4. MELTABLE RING: Thermally stabilized thermoplastic. Color: gray.

## APPLICATION

1. These parts are designed to provide an environment resistant in-line splice in wires having nickel-plated conductors and insulation rated for at least 125°C.
2. These parts conform to National Aerospace Standard NAS-1744. When properly installed, they will meet the performance requirements of Tyco Electronics/Raychem RT-1404 and NAS-1747 for splices.
3. Part selection: Determine total CMA of wires to be spliced and select appropriate sleeve. Splice should contain no more than 3 wires per side.
4. Wire is to be stripped to exposed  $12.5 \pm 1.5$  (0.500±0.060) of conductor.
5. Parts may be installed using Tyco Electronics/Raychem approved convection or infrared heating tool. Tools must be equipped with a suitable reflector. For detailed assembly instructions, see Tyco Electronics/Raychem RPIP-850-00.
6. Temperature range: -55°C to +150°C.

<b>tyco</b> <hr/> Electronics		Tyco Electronics Corp. 300 Constitution Drive, Menlo Park, CA. 94025, U.S.A.		<b>Raychem</b>	TITLE: <b>SOLDERSLEEVE WIRE SPLICE</b>		
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]			DOCUMENT NO.: <b>D-1744-05/-06/-07/-08</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.			DOC. ISSUE: 3	DATE: 20-May-03	
DRAWN BY: M. FORONDA	CAGE CODE: 06090	REPLACES: D981010	DCR NUMBER: D030266	PROD. REV.: SEE TABLE	SCALE: None	SIZE: A	SHEET: 1 of 1

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