SPECIFICATION CONTROL DRAWING
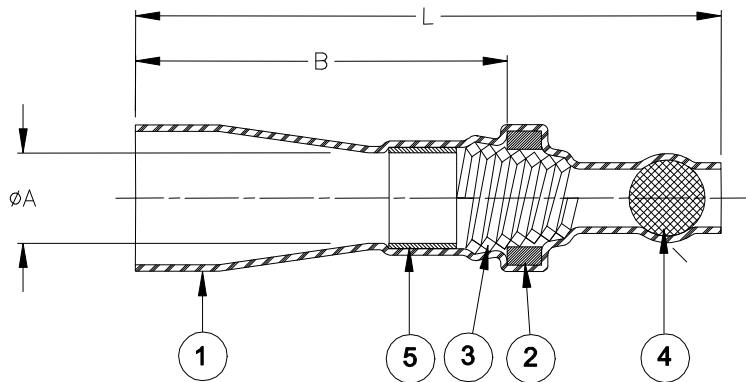
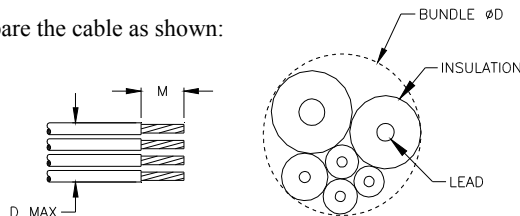| Product Name	Ball Color	Product Dimensions			Copper Cross Section		Bundle Diameter	
		L±3.5 (L±0.140)	øA	B	Min. mm^2 (CMA)	Max. mm^2 (CMA)	øD max	M±1 (M±0.04)
SGRS-1	Green	38.3 (1.510)	3.6 +0.4/-0.2 (0.140 +0.016/-0.008)	26.0±2.0 (1.025±0.079)	0.7 (1400)	2.4 (4800)	3.3 (0.130)	15.0 (0.590)
SGRS-2	Red	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.	*Raychem*	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	SHEET: 1 of 1

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