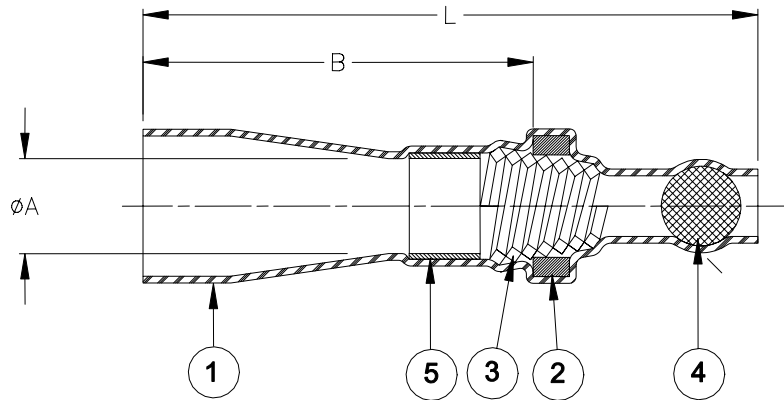


# SPECIFICATION CONTROL DRAWING



Product Name	Ball Color	Product Dimensions			Copper Cross Section		Bundle Diameter	
		L $\pm$ 3.5 (L $\pm$ 0.140)	$\phi A$	B	Min. mm <sup>2</sup> (CMA)	Max. mm <sup>2</sup> (CMA)	$\phi D$ max	M $\pm$ 1 (M $\pm$ 0.04)
SGRS-1	Green	38.3 (1.510)	3.6 $\pm$ 0.4/-0.2 (0.140 $\pm$ 0.016/-0.008)	26.0 $\pm$ 2.0 (1.025 $\pm$ 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 $\pm$ 0.7/-0.2 (0.200 $\pm$ 0.028/-0.008)	23.5 $\pm$ 2.0 (0.925 $\pm$ 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 $\pm$ 0.9/-0.2 (0.295 $\pm$ 0.035/-0.008)	26.5 $\pm$ 2.0 (1.045 $\pm$ 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 $\pm$ 0.9/-0.3 (0.370 $\pm$ 0.035/-0.012)	25.5 $\pm$ 3.0 (1.005 $\pm$ 0.118)	7.5 (15000)	12.0(24000)	9.0 (0.350)	15.0 (0.590)

These products are tested to RB109.

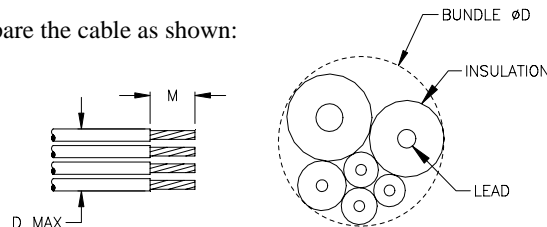
## MATERIALS

- INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
- SOLDER PREFORM WITH FLUX:  
SOLDER: TYPE Sn60 per ANSI-J-STD-006.  
FLUX: TYPE ROM1 per ANSI-J-STD-004.
- CONICAL SPRING: Square copper wire.
- END CLOSURE BALL: Tinted glass. Color: see table.
- SEALING INSERT: Hot melt adhesive.

## APPLICATION

- 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.
- Temperature range: Class 3, -40°C to +125°C.
- Vibration range: Class 1 (body).
- 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 Tyco Electronics / Raychem Specification RB109 for procedures.
- For installation procedure and application equipment, consult RPIP-820-00.

For best results, prepare the cable as shown:



		Tyco Electronics Corporation 300 Constitution Drive, Menlo Park, CA. 94025, U.S.A.		<i>Raychem</i>		TITLE: <b>SOLDERGRIP DEVICE                  STUB SPLICE</b>	
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]				DOCUMENT NO.: <b>SGRS-X</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.		REV.: <b>A</b>	
DATE: <b>29-Nov-06</b>		SCALE: <b>NTS</b>		SIZE: <b>A</b>		SHEET: <b>1 of 1</b>	
DRAWN BY: <b>P.TALLY</b>		CAGE CODE: <b>06090</b>		REPLACES: <b>D040187</b>		DCR NUMBER: <b>D060343</b>	

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