

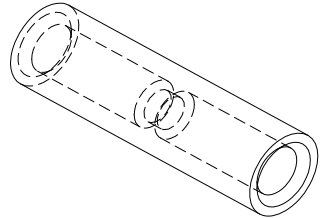


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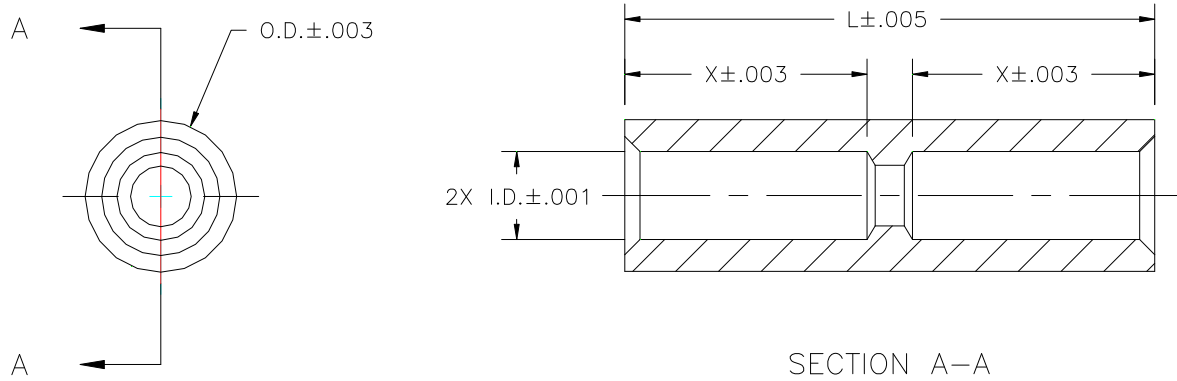
email: sales@shp-seals.com - website: www.shp-seals.com

SOLDER SLEEVE



These solder sleeves provide a convenient method for making in line splices for attaching wires to feedthru, header or connector pins. They are self fixturing on the pin and both the wire and the pin solder joints are made in a single solder operation (refer to page 2 for application sequence). Shrink sleeving can then be slid into place and shrunk to prevent pin to pin shorts.

PRODUCT APPLICATION	PART NO.	L	OD	ID	X	MAX WIRE SIZE
.020/.021 Diameter Pin Feedthrus, Headers, HMMD Series Connectors	SPLC-2144	.140	.034	.025	.063	24 AWG
.025 Diameter Pin Feedthrus, Headers, HSMHE and HMMHE Series Connectors	SPLC-2544	.175	.042	.029	.080	22 AWG
.030 Diameter Pin Feedthrus and Headers	SPLC-3044	.175	.047	.036	.080	22 AWG
.035 - .040 Diameter Pin Feedthrus and Headers	SPLC-4044	.175	.057	.045	.080	18 AWG



- NOTES: (1) Material is Brass.
 (2) Standard plating is 300 microinches minimum matte, TIN/LEAD per AMS-P-81728 over 100-200 microinches Electroless NICKEL per MIL-C-26074.

All dimensions are inches.



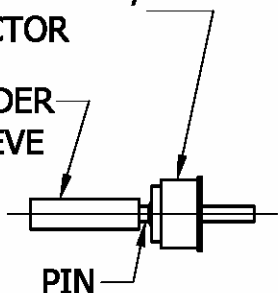
SOLDER SLEEVE

APPLICATION SEQUENCE

A

**FEEDTHRU, HEADER,
OR CONNECTOR**

**SOLDER
SLEEVE**



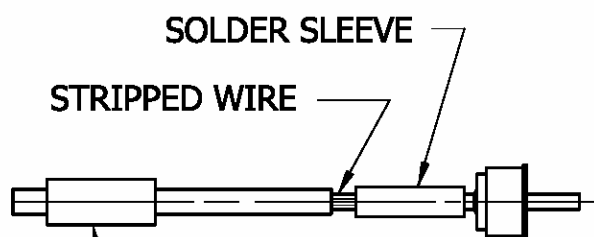
INSTALL SOLDER SLEEVE ONTO PIN

B

SOLDER SLEEVE

STRIPPED WIRE

SHRINK SLEEVE

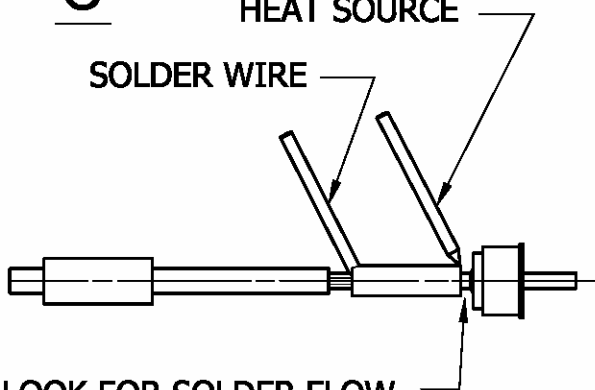


**INSTALL SHRINK SLEEVE ONTO
WIRE, AND INSERT STRIPPED
WIRE INTO SOLDER SLEEVE
UNTIL IT STOPS**

C

HEAT SOURCE

SOLDER WIRE



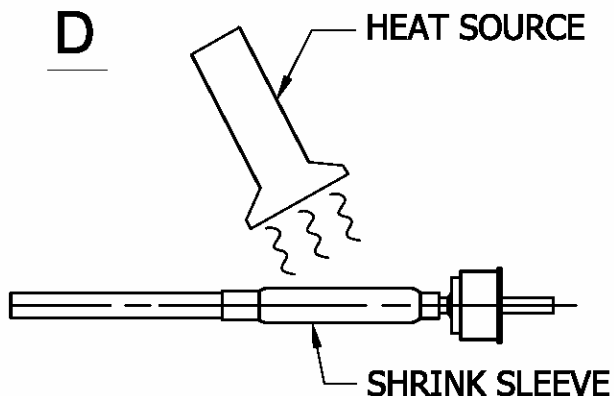
LOOK FOR SOLDER FLOW

**APPLY HEAT TO PIN END OF
SOLDER SLEEVE . APPLY
SOLDER TO WIRE END OF
SOLDER SLEEVE UNTIL
SOLDER APPEARS AT PIN END.**

D

HEAT SOURCE

SHRINK SLEEVE



**CLEAN SOLDER JOINTS, SLIDE
SHRINK SLEEVE FORWARD AND
HEAT TO SHRINK.
(IF THERE ARE MULTIPLE PINS TO
BE SPLICED, STEP "D" MIGHT BE
UNDERTAKEN AFTER ALL SOLDER
SPICES ARE COMPLETED.)**