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.

<table>
<thead>
<tr>
<th>PRODUCT APPLICATION</th>
<th>PART NO.</th>
<th>L</th>
<th>OD</th>
<th>ID</th>
<th>X</th>
<th>RECOMMENDED STRANDED WIRE SIZE</th>
</tr>
</thead>
<tbody>
<tr>
<td>.020/.021 Diameter Pin Feedthrus, Headers, HMM MD Series Connectors</td>
<td>SPLC-2144</td>
<td>.140</td>
<td>.034</td>
<td>.025</td>
<td>.063</td>
<td>26 AWG</td>
</tr>
<tr>
<td>.025 Diameter Pin Feedthrus, Headers, HSMHE and HMMHE Series Connectors</td>
<td>SPLC-2544</td>
<td>.175</td>
<td>.042</td>
<td>.029</td>
<td>.080</td>
<td>24 AWG</td>
</tr>
<tr>
<td>.030 Diameter Pin Feedthrus and Headers</td>
<td>SPLC-3044</td>
<td>.175</td>
<td>.047</td>
<td>.036</td>
<td>.080</td>
<td>22 AWG</td>
</tr>
<tr>
<td>.035/.040 Diameter Pin Feedthrus and Headers</td>
<td>SPLC-4044</td>
<td>.175</td>
<td>.055</td>
<td>.044</td>
<td>.080</td>
<td>20 AWG</td>
</tr>
</tbody>
</table>

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

All dimensions are inches.
APPLICATION SEQUENCE

A
FEEDTHRU, HEADER, OR CONNECTOR

SOLDER SLEEVE

PIN

INSTALL SOLDER SLEEVE ONTO PIN

B
SOLDER SLEEVE

STRIPPED WIRE

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 SPLICES ARE COMPLETED.)