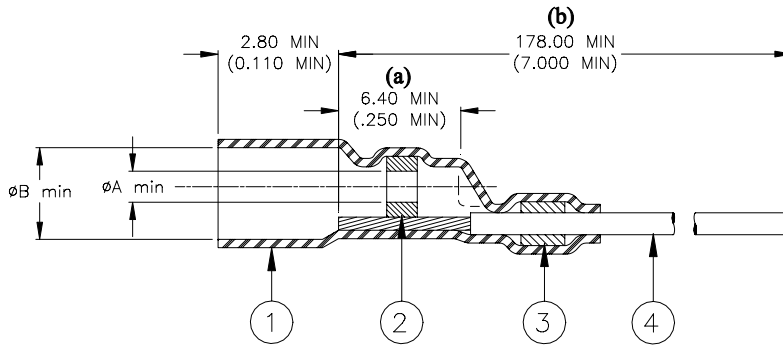


SPECIFICATION CONTROL DRAWING



Product Revision		(4) Wire Designation	ϕA min	ϕB min	Usable Wire or Component Diameters	
Product Name					ϕC	ϕD
D-112-1222-9	N/C	MIL-W-22759/32-22-9	0.71 (0.028)	2.33 (0.092)	0.25 to 0.60 (0.010 to 0.025)	0.75 to 2.30 (0.030 to 0.090)
D-112-1224-9	N/C	MIL-W-22759/32-24-9				
D-112-1622	N/C	Solder Plated Bus Wire				
D-112-1830-9	N/C	MIL-W-81822/13-30-9	1.11 (0.044)	3.00 (0.118)	0.50 to 1.07 (0.020 to 0.042)	0.75 to 3.00 (0.030 to 0.118)
D-112-2222-9	N/C	MIL-W-22759/32-22-9				
D-112-2622	N/C	Solder Plated Bus Wire				
D-112-2830-9	N/C	MIL-W-81822/13-30-9	1.24 (0.050)	3.94 (0.155)	0.80 to 1.14 (0.032 to 0.045)	1.40 to 3.90 (0.055 to 0.153)
D-112-3222-9	N/C	MIL-W-22759/32-22-9				
D-112-3622	N/C	Solder Plated Bus Wire				
D-112-3830-9	N/C	MIL-W-81822/13-30-9				

Dimensional Notes:

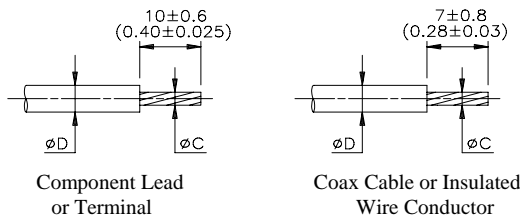
- (a) Dimension is to top shoulder (wire stop) of sleeve. Position of lead relative to solder preform and shoulder may vary from diagram.
- (b) Lead length for sleeves with bus wire is 27.94 min. (1.10 min.) overall with 12.7 min. (0.50 min) extension from end of sleeve.

MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
2. SOLDER PREFORM WITH FLUX:
 - SOLDER: TYPE Sn63 per ANSI/J-STD-006.
 - FLUX: TYPE ROL1 per ANSI/J-STD-004.
3. MELTABLE INSERT: Polyolefin-based thermoplastic. Color: blue.
4. PRE-INSTALLED LEAD: See table.

APPLICATION

1. The parts covered by this document are used to attach the pre-installed lead to another electrical conductor such as component leads, coaxial cable primary, insulated wire or connector terminals. Insulated leads and coax dielectric must be rated for at least 125°C.
2. Spliced assemblies will meet the performance requirements of Tyco Electronics/Raychem specification RT-1404 when installed on solderable components using a Tyco Electronics/Raychem approved convection or infrared heater and reflector. For best results, prepare the wire(s) as shown:



tyco <i>Electronics</i>		Raychem Products 305 Constitution Drive, Menlo Park, CA. 94025, USA		TITLE: SOLDERSLEEVE SPLICES WITH PRE-INSTALLED LEADS, SERIES D-112				
Unless otherwise specified dimensions are in millimeters. Inches dimensions are shown in brackets.				DOCUMENT NO.: D-112-1XXX / -3XXX Series				
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.		PROD. REV.: SEE TABLE	DOC. ISSUE: 3	DATE: 18-Feb-03		
PREPARED BY: mforonda		DCR NUMBER: D030064		REPLACES: D020199		SCALE: None	SIZE: A	SHEET: 1 of 1

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