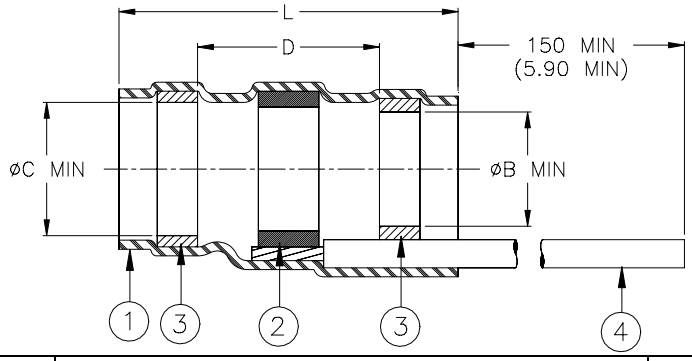
SPECIFICATION CONTROL DRAWING



Product Revisions		Component Dimensions					Shall Accommodate Cable With Dimensions		
Part Name		Ident. Code	L±1.75 (L±0.07)	B min	C min	D min	E max	F min	H max
ST18-1-55-GA-CL	*	ST181R	16.5 (0.650)	1.9 (0.075)	2.65 (0.105)	8.25 (0.325)	2.65 (0.105)	0.90 (0.035)	1.9 (0.075)
ST18-2-55-GA-CL	*	ST182R	16.5 (0.650)	2.65 (0.105)	3.68 (0.145)	8.25 (0.325)	3.68 (0.145)	1.40 (0.055)	2.65 (0.105)
ST18-3-55-GA-CL	*	ST183R	16.5 (0.650)	4.3 (0.170)	5.08 (0.200)	8.25 (0.325)	5.08 (0.200)	2.15 (0.085)	4.3 (0.170)
ST18-4-55-GA-CL	*	ST184R	19.1 (0.750)	5.95 (0.235)	6.45 (0.255)	8.25 (0.325)	6.45 (0.255)	3.30 (0.130)	5.95 (0.235)
ST18-5-55-GA-CL	*	ST185R	19.1 (0.750)	7.0 (0.275)	7.6 (0.300)	8.25 (0.325)	7.6 (0.300)	4.30 (0.170)	7.0 (0.275)

*For Prod. Revisions: see individual MCD's.

MATERIAL

1. INSULATION SLEEVE: Heat-shrinkable, radiation cross-linked modified polyvinylidene fluoride. Transparent blue.
2. SOLDER PREFORM WITH FLUX:
   SOLDER: TYPE Cd18 per ANSI J-STD-006.
   FLUX: TYPE ROL1 per ANSI J-STD-004.
3. MELTABLE RINGS: Stabilized thermoplastic. Color: blue.
4. PRE-INSTALLED LEAD: RAYCHEM 55A0111 in accordance with MIL-W-22759/32. Stranded tin plated copper.
   Color: see "CL": lead colors available below.

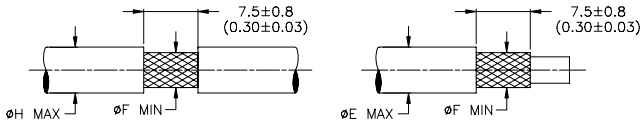
APPLICATION

1. These parts are designed to provide an environment protected shield termination on cables, rated for 105°C minimum, meeting the dimensional criteria listed and having tin or silver plated shields.
2. Temperature range: -55°C to +125°C.
3. When installed in accordance with Raychem Process Standard RCPS-100-70 assemblies will meet performance requirements of Raychem Specification RT-1404.

Complete part number is defined as shown:

ST18-X — Size 1 to 5
55 — Lead type M22759/32
GA — Lead Wire Gauge (AWG) 20, 22,24,26
CL — Lead color designation per MIL-STD-681.
Colors available:
20AWG-black, green, white
22AWG-black, green, white
24AWG-black, green, blue, white
26AWG-black, green, white
All gauges: White with a single black stripe.

For best results, prepare the cable as shown:



Raychem Interconnect a division of tyco ELECTRONICS, 300 Constitution Drive, Menlo Park, CA 94025, USA	THERMOFIT DEVICES	TITLE: **SOLDERSLEEVE DEVICE TERMINATION WITH LEADS, LOW TEMPERATURE**				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MILLIMETERS. INCHES DIMENSIONS ARE BETWEEN BRACKETS.			DOCUMENT NO.: **ST18-X-55-GA-CL**			
TOLERANCES: 0.00 N/A, 0.0 N/A, 0 N/A	ANGLES: N/A; ROUGHNESS IN MICRON	Raychem reserves the right to amend this drawing at any time. Users should evaluate the suitability of the product for their application.	DCR NUMBER: D000227		REPLACES: D981079	
DRAWN BY: M. FORONDA	DATE: 06-June-00	PROD. REV. SEE TABLE	DOC ISSUE: 5	SCALE: None	SIZE: A	SHEET: 1 of 1

If this document is printed it becomes uncontrolled. Check for the latest revision