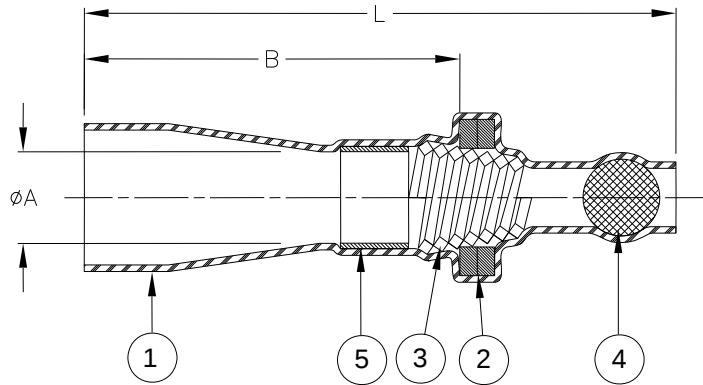


CUSTOMER DRAWING



Product Name	Ball Color (item 4)	Product Dimensions			Copper Cross Section		Bundle Diameter ØD max	Qty: Item 2 (Solder)
		L±3.5 [L±0.140]	ØA	B	Min. mm ² [CMA]	Max. mm ² [CMA]		
SGRS-1-58	Green	38.3 [1.510]	3.6 +0.4/-0.2 [0.140 +0.016/-0.008]	26.0±2.0 [1.025±0.079]	0.7 [1400]	2.4 [4800]	3.3 [0.130]	1
SGRS-2-58	Red	37.7 [1.485]	5.0 +0.7/-0.2 [0.200 +0.028/-0.008]	23.5±2.0 [0.925±0.079]	2.0 [4000]	4.0 [8000]	4.5 [0.175]	2
SGRS-3-58	Blue	45.5 [1.790]	7.5 +0.9/-0.2 [0.295 +0.035/-0.008]	26.5±2.0 [1.045±0.079]	3.5 [7000]	8.0 [16000]	7.0 [0.275]	2
SGRS-4-58	Yellow	45.0 [1.770]	9.4 +0.9/-0.3 [0.370 +0.035/-0.012]	25.5±3.0 [1.005±0.118]	7.5 [15000]	12.0 [24000]	9.0 [0.350]	3

These products are tested to RB109.

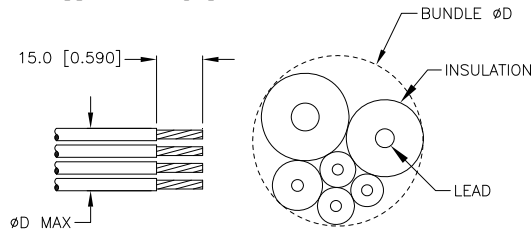
MATERIALS

1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked modified polyvinylidene fluoride.
2. SOLDER PREFORM WITH FLUX: Qty: see table.
SOLDER: TYPE Sn42Bi58 per ANSI / J-STD-006.
FLUX: TYPE ROM1 per ANSI / J-STD-004.
3. CONICAL SPRING: Square copper wire.
4. END CLOSURE BALL: Tinted glass. Color: see table.
5. SEALING INSERT: Hot melt adhesive.

APPLICATION

1. 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.
2. Temperature range: Class 3, -40°C to +125°C.
3. Vibration range: Class 1 (body).
4. 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.
5. For installation procedure and application equipment, consult RPIP-820-00.

For best results, prepare the cable as shown:



		Raychem Devices		TITLE: SOLDERGRIP DEVICE STUB SEALED SPLICE		
Unless otherwise specified dimensions are in millimeters. [Inches dimensions are shown in brackets]				DOCUMENT NO.: SGRS-X-58		
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.: B1	DATE: 12-Apr-2017	
DRAWN BY: P.TALLY	CAGE CODE: 06090	REPLACES: D060344	ECO NUMBER: ECO-17-005227	SCALE: NTS	SIZE: A	SHEET: 1 of 1

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