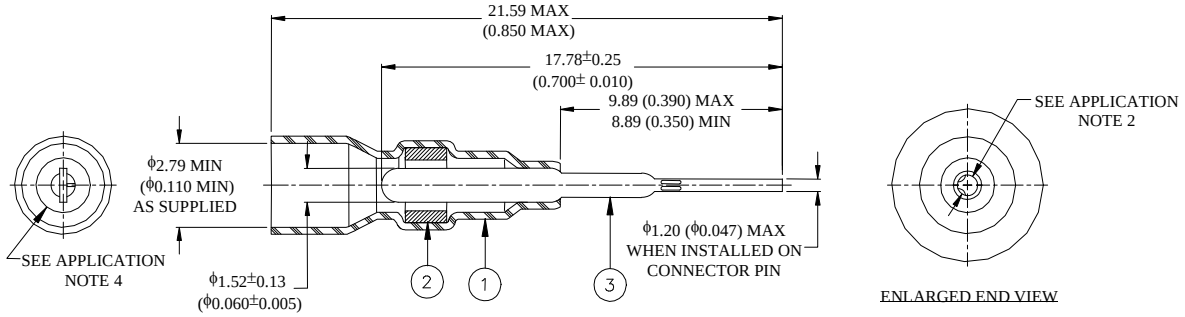


MATERIALS

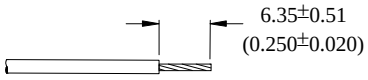
1. INSULATION SLEEVE: Heat-shrinkable, transparent blue, radiation cross-linked polyvinylidene fluoride.
2. SOLDER PREFORM WITH FLUX:
   SOLDER: TYPE Sn63 per ANSI-J-STD-006.
   FLUX: TYPE ROL1 per ANSI-J-STD-004.
3. TERMINATION SOCKET: Base Metal: Beryllium Copper, Alloy 172 per QQ-C-533.
   Plating: Gold plated per MIL-DTL-45204D, TYPE II over Nickel plated per SAE-AMS-QQ-N-290.

APPLICATION

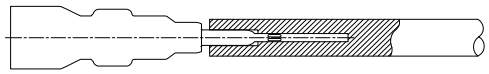
1. Solder joint shall withstand 15 lbs. axial tensile pull or wire shall break outside of soldered area.
2. Socket bore to provide firm grip on a 0.516/0.494 (0.02034/0.01946) dia. gold plated connector pin. Maximum engagement force onto a 0.516 +0.000/-0.005 (0.0203 +0.0000/-0.0002) dia. polished steel pin with a spherical tip shall be 8 lbs. Minimum separation force from a 0.495 +0.005/-0.000 (0.0195 +0.0002/-0.0000) dia. polished steel test pin shall be 4 ozs. Engagement and separation force tests shall be run on separate test samples.
3. If tab is to be bent following termination, terminated assembly must be fully inserted into AD-1446 holding fixture while bend is being made.
4. Rear entry to accommodate one 20 AWG or one 22 AWG tin or silver plated stranded conductor. Two 22 AWG conductors may be terminated to the socket provided both conductors are pre-tinned. Other wire combinations, gauge sizes, and conductor platings should be submitted to Raychem for evaluation.
5. Electrical characteristics:
   a) Contact resistance between points A and B shall be 8 milliohms maximum when tested at 1 amp. D.C. with a single 22 AWG wire terminated to the socket per Fig. 1.

TERMINATION PROCEDURE

1. Strip end of wire to length shown.



2. Insert termination socket into holding fixture (AD-1446).



3. Insert wire(s) into termination socket until conductor bottoms
4. Heat with Raychem IR-500 infra-red heating device until solder ring flows. See application note 1.
5. Remove from heating device and allow to cool for approximately 5 to 10 seconds prior to removing from holding fixture.

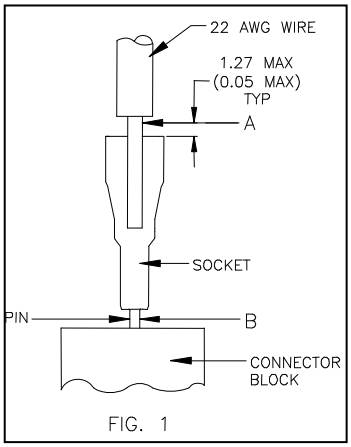


FIG. 1

Raychem Devices

CUSTOMER DRAWING

TE Connectivity			TITLE: **TERMINATOR SOCKET FOR 0.51 (0.020) DIAMETER PIN**			
Unless otherwise specified dimensions are in millimeters. Inches dimensions are in between brackets.			DOCUMENT NO.: **D-607-18**			
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.	REVISED PER: ECO-15-005581			
DRAWN BY: L. RODRIGUEZ	DATE: 10-April-15	APPROVED: R. ARNEL	REVISION: C2	SCALE: N/A	SIZE: A	SHEET: 1 of 1