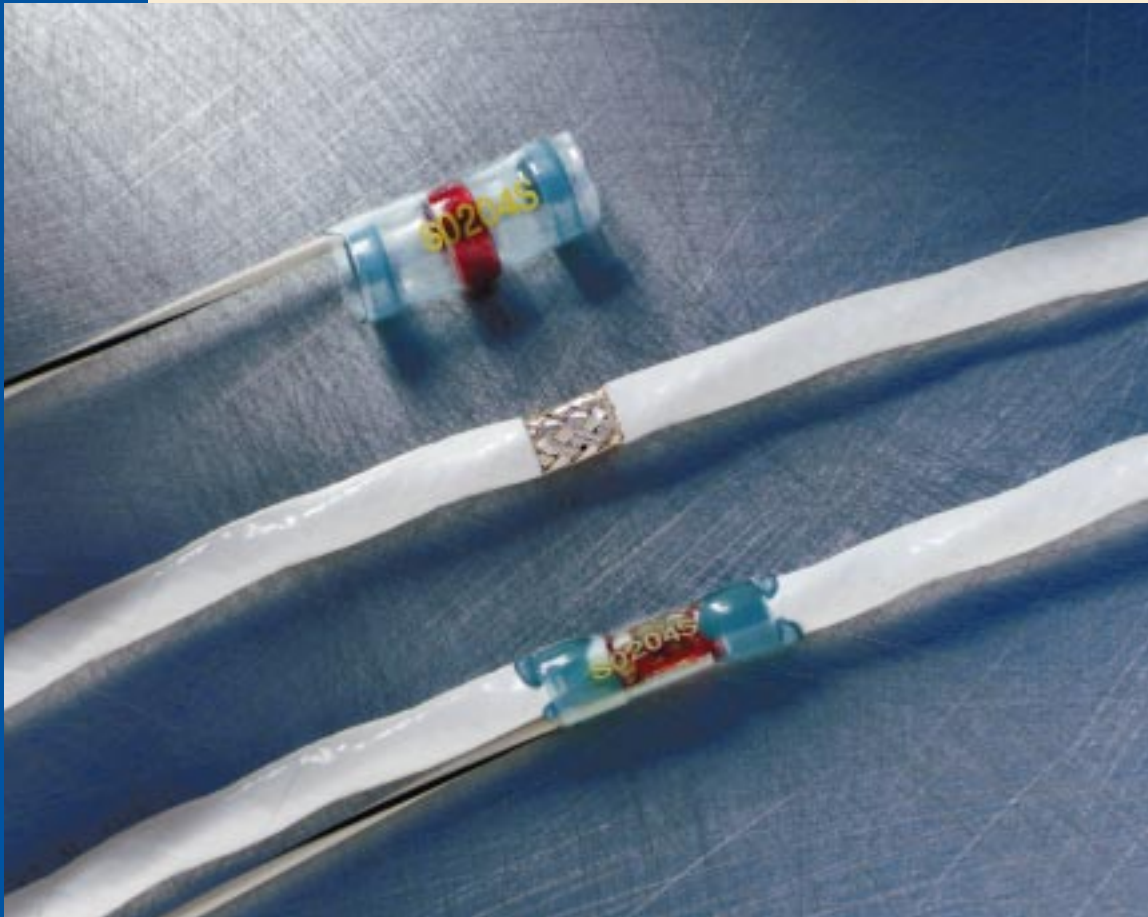


# STS

## Environmentally Sealed Shield Terminators



The Mark of  
Quality for  
Wire and  
Cable  
Terminations

Reliability and inspectability are hallmarks of the Sumitube® H-M and H-ML series shield terminators. Assembled to the rigorous standards established by SAE-AS83519, these solder terminators will provide a rugged and environmentally sealed soldered connection which is completely insulated, encapsulated and strain relieved.

In addition to the fundamental advantages provided by a soldered connection, these terminators are fully inspectable. The quality of the connection is completely visible through the transparent heat shrinkable sleeve. Also being heat shrinkable, these terminators shrink to fit. Five sizes cover a wire OD range up to 0.275".

Sumitube **S**pecial **T**ermination **S**leeves are available in a virtually unlimited range of custom designs. The same attention to quality goes into a vast range of terminators designed to meet commercial requirements including automotive, appliance, aerospace and telecommunications.

The outer heat-shrinkable jacket is a precision engineered polyvinylidene fluoride sleeve containing exactly the right amount of pre-fluxed solder to provide reliable connections time after time. Thermoplastic sealing rings at each end of the sleeve melt and flow during the shrinking process to strain-relieve and form an environmental seal that meets SAE-Spec criteria. The solder preform is coated with a special thermochromic indicator which changes color when the proper amount of heat has been applied. This serves to assist the operator during installation and inspection. All parts also have a permanent identification number marked on the exterior of the PVDF sleeves.

The use of H-ML series parts with pre-installed ground leads means there is only one part to handle eliminating the need to spend time on positioning components. This ease of handling can reduce labor costs, give higher production yields, and eliminate the need to inventory wire or braid.

## SIZE SELECTION

To determine which size terminator best meets your requirements:

1. Determine cable dimensions, either "center strip" or "end strip", using the diagrams figures A and B.
2. Refer to cable dimension table below.

SIZE	CABLE DIMENSIONS							
	G MIN.	F MIN.	E MAX.	H MAX.	MARKING CODE AS83519/1	PART #	MARKING CODE AS83519/2	PART #
1	.020	.035	.105	.075	S0101S	H-M-1	S02XXS	H-ML-1,6,11,16
2	.030	.055	.145	.105	S0102S	H-M-2	S02XXS	H-ML-2,7,12,17
3	.050	.085	.200	.170	S0103S	H-M-3	S02XXS	H-ML-3,8,13,18
4	.070	.130	.255	.235	S0104S	H-M-4	S02XXS	H-ML-4-9-14-19
5	.100	.170	.300	.275	S0105S	H-M-5	S02XXS	H-ML-5,10,15,20

## INSTALLATION INSTRUCTIONS

Preparation of ground lead (if required)  
Strip insulation as shown in figure C

Preparation of shielded cable  
Strip insulation as shown in figure D center strip  
or figure E end strip

## TERMINATION ASSEMBLY

Assemble components as shown in figure F  
Make sure no loose strands are present  
Ground lead may be front or rear entry

## HEATING OF ASSEMBLY

1. Use one of your preferred heating tools with appropriate reflector.
2. Direct heat, either infrared or conventional, at solder preform until substrates have wet and a proper fillet is obtained.
3. If necessary apply heat to remainder of device to assure proper installation.

## MARKING CODE SYSTEM (SEE CHART)

- SO AS83519/1 and AS83519/2  
X - With Lead installed: 2  
- Without lead installed: 1  
XX - Terminator size indicator  
Numerical portion of H-M or H-ML part number  
S - Manufacturer's designator

## X OR XX = TERMINATOR PART NUMBER:

- Refer to drawing H-M-1 thru -5 for AS83519/1 applications.
- Refer to drawing H-ML-1 thru -20 for AS83519/2 applications with 22759/32 (irradiated ETFE) pre-installed lead.

Figure A

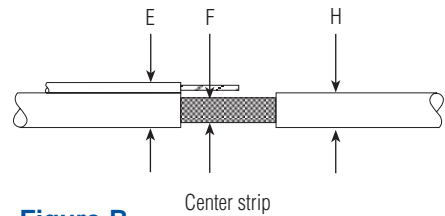


Figure B

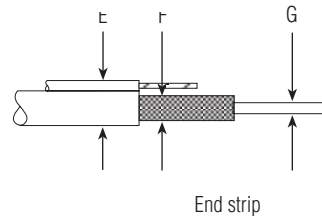


Figure C

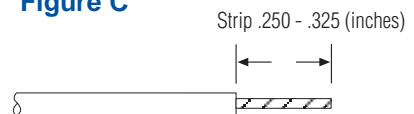


Figure D

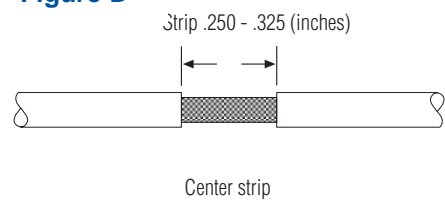


Figure E

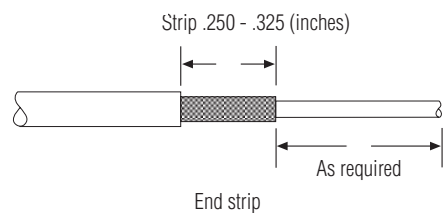
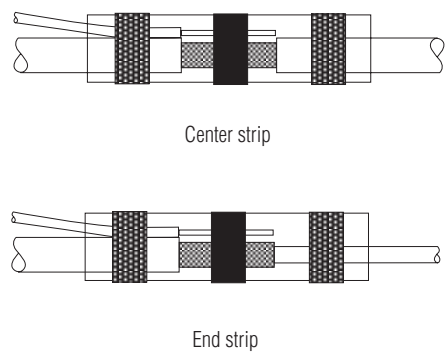


Figure F



## Product Cross Reference

### Raychem Part Number

Raychem P/N.	Sumitomo Cross Reference	Raychem P/N.	Sumitomo Cross Reference	Raychem P/N.	Sumitomo Cross Reference
D - 144 - 25	H - C - 1	D - 144 - 31	H - C4 - 7 *	SO207X	H - ML - 7
D - 100 - 00	H - C - 2	D - 144 - 32	H - C4 - 8 *	SO208X	H - ML - 8
D - 101 - 00	H - C - 3	D - 144 - 26	H - C5 - 5 *	SO209X	H - ML - 9
D - 107 - 00	H - C - 4	D - 100 - 31	H - C5 - 6 *	SO210X	H - ML - 10
D - 103 - 00	H - C - 5	D - 101 - 31	H - C5 - 7 *	SO211X	H - ML - 11
D - 104 - 00	H - C - 6	D - 103 - 31	H - C5 - 8 *	SO212X	H - ML - 12
D - 105 - 00	H - C - 7	D - 107 - 31	H - C5 - 20 *	SO213X	H - ML - 13
D-108-09	H-HC-1*	D - 104 - 31	H - C5 - 21 *	SO214X	H - ML - 14
D-108-10	H-HC-2*	D - 105 - 31	H - C5 - 22 *	SO215X	H - ML - 15
D-108-11	H-HC-3*	D-100-34	H-CL-7-03	SO216X	H - ML - 16
D-108-12	H-HC-5*	D-101-34	H-CL-8-03	SO217X	H - ML - 17
D-108-00	H-HC-6	D-103-34	H-CL-10-03	SO218X	H - ML - 18
D-108-01	H-HC-7	D-142-72	L-CL-7	SO219X	H - ML - 19
D-108-02	H-HC-8	D-142-73	L-CL-8	SO220X	H - ML - 20
D-108-03	H-HC-10	D-142-74	L-CL-10	SO301R	H - MB - 106T
D - 142 - 83	L - C - 1	D-181-1222-90/9	H - CL - 181 - 1222 - 90/9	SO302R	H - MB - 206T
D - 142 - 50	L - C - 2	D-181-1224-90/9	H - CL - 181 - 1224 - 90/9	SO303R	H - MB - 306T
D - 142 - 51	L - C - 3	D-181-1226-90/9	H - CL - 181 - 1226 - 90/9	SO304R	H - MB - 406T
D - 142 - 56	L - C - 4	SO101X	H - M - 1	SO305R	H - MB - 506T
D - 142 - 52	L - C - 5	SO102X	H - M - 2	SO306R	H - MB - 106N
D - 142 - 65	L - C - 6	SO103X	H - M - 3	SO307R	H - MB - 206N
D - 142 - 66	L - C - 7	SO104X	H - M - 4	SO308R	H - MB - 306N
D - 144 - 25	H - I - 1	SO105X	H - M - 5	SO309R	H - MB - 406N
D - 144 - 00	H - I - 2	101S	H - M - 1 - C2	SO310R	H - MB - 506N
D - 144 - 01	H - I - 3	102S	H - M - 2 - C2	ST63 - x - 00	H - C - x
D - 144 - 46	H - I - 4	103S	H - M - 3 - C2	ST18 - x - 00	L - C - x
D - 144 - 02	H - I - 5	104S	H - M - 4 - C2	ST96 - x - 00	H - HC - x
D - 144 - 15	H - C4 - 1	105S	H - M - 5 - C2	ST63 - x - bb	Available
D - 144 - 12	H - C4 - 2	SO201X	H - ML - 1	ST18 - x - bb	on
D - 144 - 13	H - C4 - 3	SO202X	H - ML - 2	ST96 - x - bb	request
D - 144 - 14	H - C4 - 4	SO203X	H - ML - 3	SO63 - x - bb	""
D - 144 - 29	H - C4 - 5 *	SO204X	H - ML - 4	CWT - xxxx	""
D - 144 - 30	H - C4 - 6 *	SO205X	H - ML - 5	D-110-0071	H-C-249-8
		SO206X	H - ML - 6		
				All others RMA	* = RA Flux

**OTHER AVAILABLE STS SERIES:**

NAS 1744

NAS 1745

NAS 1746

High Temperature Infrared 125°C

High Temperature Convection 125°C

Low Temperature Convection 105°C

STS with Sealing Inserts

STS with Preinstalled Leads

STS with Preinstalled Braid

STS Coaxial Terminators

STS Splicing Sleeves

STS Wire To Pin Sleeves

Special Designs By Request



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