

- Reliable one-piece solder contacts
- One-step installation
- Termination for coax cables, shielded wires, twisted pairs, triaxial cables

SolderTacts

Shielded contacts for MIL-C-28748 connectors

One-piece controlled-soldering SolderTacts contacts for MIL-C-28748 connectors are designed to terminate coaxial cables, shielded wires, and twisted pairs faster and more reliably than any other method. SolderTacts contacts eliminate the variables associated with hard-to-handle crimping. Their one-step installation accelerates production while reducing handling and installed costs.

Controlled soldering

SolderTacts contacts provide the optimum amount and type of solder and flux in pre-fluxed solder preforms to control soldering

and reduce operator sensitivity. The geometry of the coaxial cable is carried through the connector to eliminate separate pins, help reduce cross talk, and improve shielding effectiveness and signal transmission.

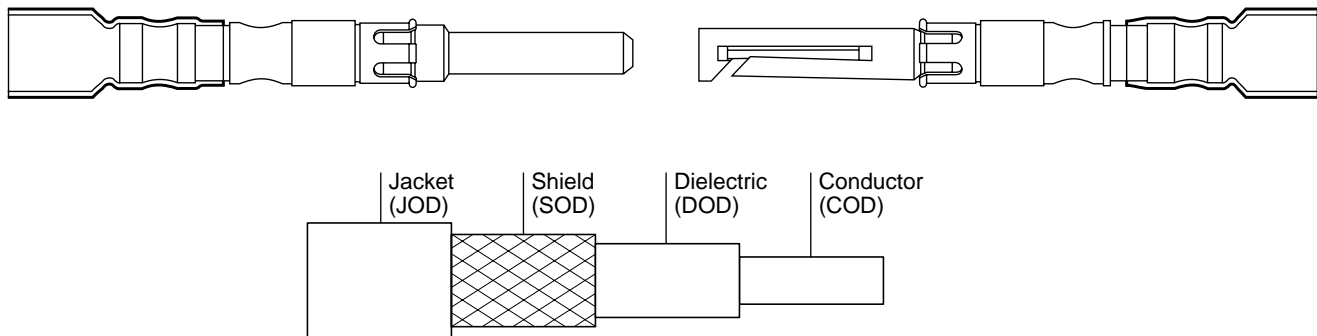
SolderTacts contacts provide simultaneous electrical connection and strain relief. Heat-shrinkable tubing insulations eliminate stress concentration on the wire within the contact. Because the insulation is transparent and inspection windows are provided, terminations are fully inspectable.

Compatibility

The design versatility of SolderTacts contacts makes them exceptionally well suited to military applications.

SolderTacts shielded contacts can be terminated with standard Raychem heating tools. Once terminated, they can be installed into connector cavities with standard insertion and extraction tools. They are replaceable without cutting and restripping or shortening the cable.

SolderTacts product construction



SolderTacts series: MIL-C-28748

| Contact military specification | Cable diameter (in inches) | | | | Wire (AWG) | Raychem SolderTacts part number | Size | Polarity | Cable type |
|----------------------------------|----------------------------|-----------|-----------|-----------|------------|---------------------------------|------|----------|---------------------------|
| | JOD | SOD | DOD | COD | | | | | |
| MIS-20067/2-002 ^a | .060-.132 | .066-.084 | .036-.070 | .009-.035 | 26-32 | D-602-44 | 16 | P | Coaxial |
| MIS-20067/1-001 ^a | .060-.132 | .066-.084 | .036-.070 | .009-.035 | 26-32 | D-602-45 | 16 | S | Coaxial |
| MIS-20067/4-001 ^a | n/a | n/a | .030-.049 | .011-.031 | 24-30 | D-602-54 | 16 | P | Twisted pair |
| MIS-20067/3-001 ^a | n/a | n/a | .030-.049 | .011-.031 | 24-30 | D-602-55 | 16 | S | Twisted pair |
| M39029/79 ^b | .060-.130 | .066-.084 | .036-.066 | .012-.026 | 26-32 | D-602-72 | 16 | P | Coaxial |
| M39029/80 ^b | .060-.130 | .066-.084 | .036-.066 | .012-.026 | 26-32 | D-602-73 | 16 | S | Coaxial |
| M39029/40 ^b | .060-.130 | .066-.084 | .036-.066 | .012-.026 | 26-32 | D-602-76 | 16 | P | Coaxial |
| M39029/41 ^b | .060-.130 | .066-.084 | .036-.066 | .012-.026 | 26-32 | D-602-77 | 16 | S | Coaxial |
| | | | .030-.049 | .011-.031 | 24-30 | D-602-0126 | 16 | P | Twisted pair ^c |
| | | | .030-.049 | .011-.031 | 24-30 | D-602-0127 | 16 | S | Twisted pair ^c |
| | .060-.132 | .066-.084 | .036-.070 | .009-.018 | 28-32 | D-602-0172 | 16 | P | Coaxial |
| MIS-20067/2-001,003 ^a | .060-.132 | .066-.084 | .036-.070 | .009-.018 | 28-32 | D-602-0173 | 16 | S | Coaxial |
| MIS-20067/8-001 ^a | | | .055-.124 | .025-.062 | 16-20 | D-610-09 | 16 | P | Power |
| MIS-20067/7-001 ^a | | | .055-.124 | .025-.062 | 16-20 | D-610-10 | 16 | S | Power |

^aThese SolderTacts contacts are on the qualified parts list for indicated specification.

^bThese SolderTacts contacts are interchangeable and intermountable with contacts qualified to the indicated specification; they replace crimp-style termination.

^cThese SolderTacts contacts are designed for twisted-pair cable per MIL-STD-1553B.

Tooling selection guide

| SolderTacts series | Part numbers | Engineering standard (termination instructions) | Convection (hot air) heating | | IR1004 infrared semiautomatic heater tool set |
|--------------------|-----------------|--|------------------------------|-----------------------------|---|
| | | | AT-1319 adapter | Repair wand | |
| 748 | D-602-44/45 | ES61133 | AT-1319-14 | AD-1480 | Tool Set #2 |
| | D-602-0172/0173 | ES61240 | | | |
| | D-602-54/55 | ES61132 | | | |
| | D-602-0126/0127 | ES61199 | | | |
| | D-610-09/10 | ES61187 | AT-1319-15 | AD-1571 | Tool Set #10 (AT-1044-12) |
| D-602-72/73 | ES61135 | AT-1319-18 | AD-1486 | Tool Set #5 (AT-1044-63) | |
| D-602-76/77 | ES61164 | AT-1319-20 | AD-1554 | Tool Set #6 (AT-1044-64) | |

| SolderTacts series | Contact insertion tool | Contact removal tool | Special tools | | |
|--------------------|---------------------------|-------------------------|----------------------------|---------------------------------------|--|
| 748 | * | AD-1447 | AD-1457A (bushing tool) | AD-1464 (flex tip removal tool) | AD-1496 (twisted pair cut-to- length tool) |

*Not applicable.

Performance

The performance of SolderTacts contacts is defined by the applicable Raychem specification control drawing (SCD) and Raychem Specification D-6002. Products on qualified product lists meet the requirements of the base specification.

Termination

Termination of SolderTacts contacts is defined in the appropriate Raychem Engineering Standard. To obtain a copy, contact your Raychem representative.

SolderTacts is a trademark of Raychem Corporation.

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