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Raychem SolderTacts shielded contacts are designed to provide reliable, one-piece solder terminations for use with circular and rectangular connectors. These controlled soldering contacts help speed installation and reduce installed costs while eliminating the variables associated with hard-to-handle crimped terminations.

With Tyco Electronics' controlled soldering technology, the connections typically exceed the strength of the wire. Transparent insulation and inspection windows permit fully inspectable terminations.

SolderTacts products are available to terminate coaxial cable and twisted wire pairs in both military and commercial applications.

SolderTacts Shielded One-Piece Solder Contacts .....	2002-2010
Application Tooling .....	2011-2013

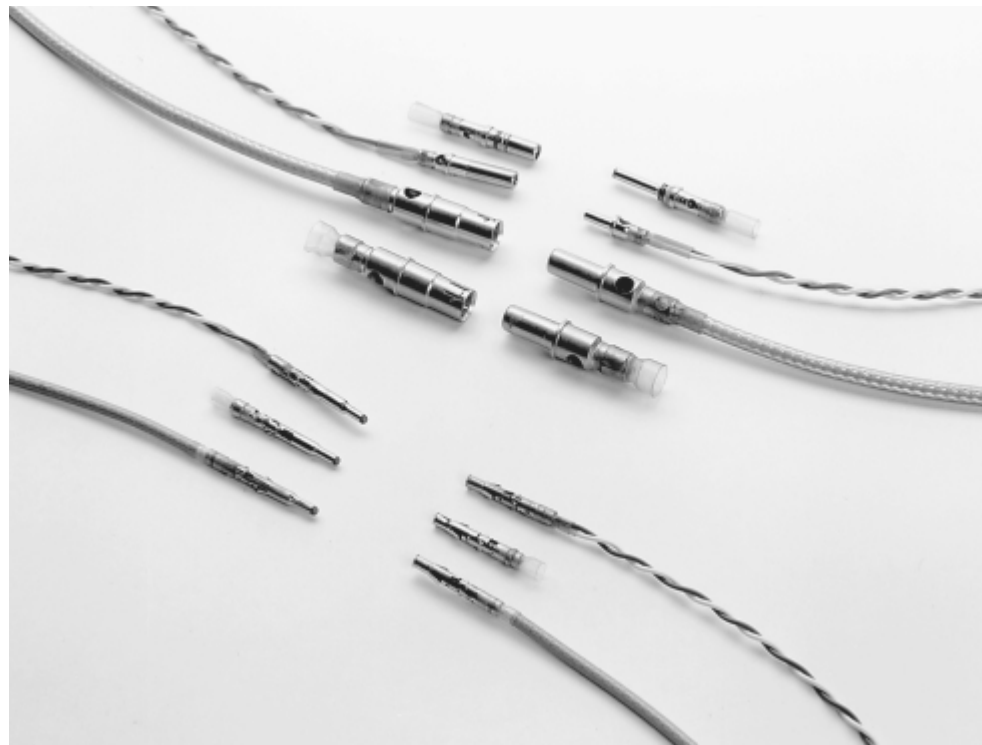


<p><b>METRIC</b></p> <p>Dimensions in this section are millimeters over inches</p>
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**Product Facts**

- Reliable one-piece solder contacts: through-connector shielding reduces cross-talk, and improves signal transmission
- One-step installation
- Solder joints are strong and reliable
- Terminations are fully inspectable
- Termination for coax cables, shielded wires, twisted pairs, triaxial cables, for a variety of commercial and military connectors

**SolderTacts Shielded One-Piece Solder Contacts**



**Applications**

One-piece controlled-soldering SolderTacts contacts 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 prefluxed 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, along with commercial aerospace, instrumentation

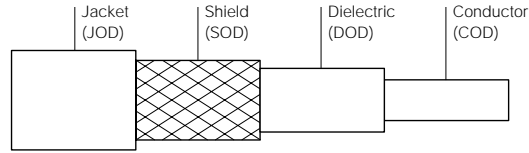
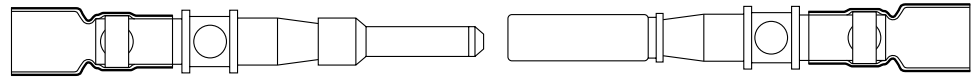
and computers. SolderTacts products are compatible with most standard connector cavities. SolderTacts contacts are intermateable and intermountable with contacts qualified to the indicated specification.

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.

**Specifications/Approvals**

Series	Raychem
D-602	D-6002

SolderTacts Shielded One-Piece Solder Contacts (Continued)



SolderTacts Product Construction, MIL-C-26482 Series

SolderTacts Series:  
MIL-C-26482

Contact Military Specification	Cable Diameter				Wire (AWG)	Raychem SolderTacts Part No.	Size	Polarity	Cable Type
	JOD	SOD	DOD	COD					
MIS-20067/5-001†	1.78-4.70 [.070-.185]	1.65-2.79 [.065-.110]	.76-2.03 [.030-.080]	.23-.51 [.009-.020]	24-32	D-602-16	12	S	Coaxial
MIS-20067/6-001†	1.78-4.70 [.070-.185]	1.65-2.79 [.065-.110]	.76-2.03 [.030-.080]	.23-.51 [.009-.020]	24-32	D-602-17	12	P	Coaxial
—	1.52-3.30 [.060-.130]	1.68-2.13 [.066-.089]	.91-1.75 [.036-.069]	.30-.66 [.012-.026]	24-30	D-602-46	16	P	Coaxial
—	1.52-3.30 [.060-.130]	1.68-2.13 [.066-.089]	.91-1.75 [.036-.069]	.30-.66 [.012-.026]	26-32	D-602-47	16	S	Coaxial
—	—	—	.76-1.24 [.030-.049]	.28-.79 [.011-.031]	24-30	D-602-56	16	P	Twinax
—	—	—	.76-1.24 [.030-.049]	.28-.79 [.011-.031]	24-30	D-602-57	16	S	Twinax

†These SolderTacts contacts are on qualified parts list for indicated specification.

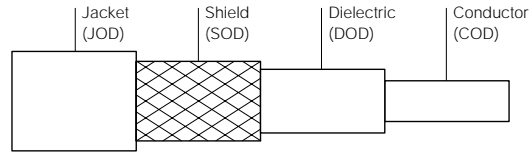
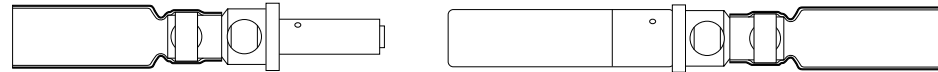
Tooling Selection Guide

Part Numbers	Engineering Standard (Termination Instructions)	Convection (Hot Air) Heating AT-1319 Adapter	Repair Wand	IR1004 Infrared Semiautomatic Heater Tool Set	Contact Insertion Tool	Contact Removal Tool
D-602-46/47	ES61137	AT-1319-17	*	*	AD-1525	AD-1526
D-602-56/57	ES61138	—	—	—	(M81969/17-04)	(M81969/19-08)
D-602-16/17	ES61161	—	—	—	—	—

\*Could be developed.

SolderTacts Shielded One-Piece Solder Contacts (Continued)

SolderTacts Series:  
MIL-C-28748 Series



SolderTacts product construction, MIL-C-28748 Series

Contact Military Specification	Cable Diameter				Wire (AWG)	Raychem SolderTacts Part No.	Size	Polarity	Cable Type
	JOD	SOD	DOD	COD					
MIS-20067/2-002 <sup>a</sup>	1.52-3.35 [.060-.132]	1.68-2.13 [.066-.084]	.91-1.78 [.036-.070]	.23-.89 [.009-.035]	26-32	D-602-44	16	P	Coaxial
MIS-20067/1-001 <sup>a</sup>	1.52-3.35 [.060-.132]	1.68-2.13 [.066-.084]	.91-1.78 [.036-.070]	.23-.89 [.009-.035]	26-32	D-602-45	16	S	Coaxial
MIS-20067/4-001 <sup>a</sup>	—	—	.76-1.24 [.030-.049]	.28-.79 [.011-.031]	24-30	D-602-54	16	P	Twisted pair
MIS-20067/3-001 <sup>a</sup>	—	—	.76-1.24 [.030-.049]	.28-.79 [.011-.031]	24-30	D-602-55	16	S	Twisted pair
M39029/79 <sup>b</sup>	1.52-3.35 [.060-.132]	1.68-2.13 [.066-.084]	.91-1.68 [.036-.066]	.30-.66 [.012-.026]	26-32	D-602-72	16	P	Coaxial
M39029/80 <sup>b</sup>	1.52-3.35 [.060-.132]	1.68-2.13 [.066-.084]	.91-1.68 [.036-.066]	.30-.66 [.012-.026]	26-32	D-602-73	16	S	Coaxial
M39029/40 <sup>b</sup>	1.52-3.35 [.060-.132]	1.68-2.13 [.066-.084]	.91-1.68 [.036-.066]	.30-.66 [.012-.026]	26-32	D-602-76	16	P	Coaxial
M39029/41 <sup>b</sup>	1.52-3.35 [.060-.132]	1.68-2.13 [.066-.084]	.91-1.68 [.036-.066]	.30-.66 [.012-.026]	26-32	D-602-77	16	S	Coaxial
—	—	—	.76-1.24 [.030-.049]	.28-.79 [.011-.031]	24-30	D-602-0126	16	P	Twisted pair <sup>c</sup>
—	—	—	.76-1.24 [.030-.049]	.28-.79 [.011-.031]	24-30	D-602-0127	16	S	Twisted pair <sup>c</sup>
—	1.52-3.35 [.060-.132]	1.68-2.13 [.066-.084]	.91-1.78 [.036-.070]	.23-.46 [.009-.018]	28-32	D-602-0172	16	P	Coaxial
MIS-20067/2-001, 003 <sup>a</sup>	1.52-3.35 [.060-.132]	1.68-2.13 [.066-.084]	.91-1.78 [.036-.070]	.23-.46 [.009-.018]	28-32	D-602-0173	16	S	Coaxial
MIS-20067/8-001 <sup>a</sup>	—	—	1.40-3.15 [.055-.124]	.64-1.57 [.025-.062]	16-20	D-610-09	16	P	Power
MIS-20067/7-001 <sup>a</sup>	—	—	1.40-3.15 [.055-.124]	.64-1.57 [.025-.062]	16-20	D-610-10	16	S	Power

a These SolderTacts contacts are on the qualified parts list for indicated specification.

b These SolderTacts contacts are intermateable and intermountable with contacts qualified to the indicated specification; they replace crimp-style termination.

c These SolderTacts contacts are designed for twisted-pair cable per MIL-STD-1553B.

SolderTacts Shielded One-Piece Solder Contacts (Continued)

Tooling Selection Guide:  
MIL-C-28748 Series

SolderTacts Series	Part No.	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)

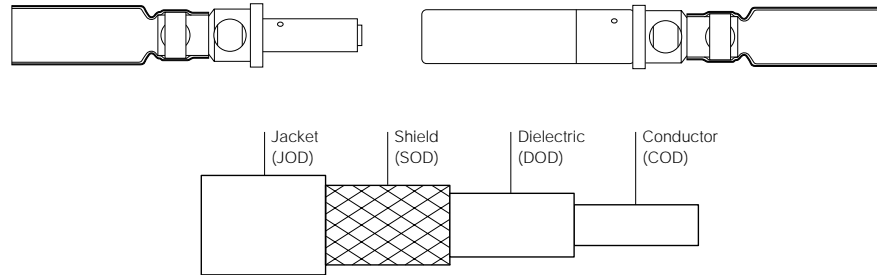
\*Not applicable.

2  
Shielded Contacts

SolderTacts Shielded One-Piece Solder Contacts (Continued)

SolderTacts Series:  
MIL-C-38999, Series I, II,  
III, IV Circular Connectors

SolderTacts Product Construction, MIL-C-38999 Series



Contact Military Specification	United States Air Force Drawing No.	Cable Diameter				Wire (AWG)	Raychem SolderTacts Part Number	Size	Polarity	Cable Type
		JOD	SOD	DOD	COD					
<b>Series I, III, and IV</b>										
M39029/60	—	3.81–5.94 [.150-.234]	3.10–4.32 [.150-.170]	1.52–3.84 [.060-.151]	.48–1.09 [.019-.043]	22–24	D-602-0122	8	P	Coaxial
M39029/59	—	3.81–5.94 [.150-.234]	3.10–4.32 [.150-.170]	1.52–3.84 [.060-.151]	.48–1.09 [.019-.043]	22–24	D-602-0123	8	S	Coaxial
M39029/76	915304-1	1.27–2.62 [.050-.103]	1.68–2.13 [.066-.084]	.91–1.73 [.036-.068]	.23–.58 [.009-.023]	26–30	D-602-0140	16	P	Coaxial
M39029/77	915305-1	1.27–2.62 [.050-.103]	1.68–2.13 [.066-.084]	.91–1.73 [.036-.068]	.23–.58 [.009-.023]	26–30	D-602-0141	16	S	Coaxial
M39029/76	915304-2	—	—	.64–1.09 [.025-.043]	.23–.58 [.009-.023]	26–30	D-602-0142	16	P	Twisted pair
M39029/77	915305-2	—	—	.64–1.09 [.025-.043]	.23–.58 [.009-.023]	26–30	D-602-0143	16	S	Twisted pair
M39029/28	915307-1	1.47–3.10 [.058-.122]	1.68–2.39 [.066-.094]	1.12–2.03 [.044-.080]	.48–.89 [.019-.035]	24–32	D-602-0144	12	P	Coaxial
M39029/75	915308-1	1.47–3.10 [.058-.122]	1.68–2.39 [.066-.094]	1.12–2.03 [.044-.080]	.48–.89 [.019-.035]	24–32	D-602-0145	12	S	Coaxial
M39029/28	915307-3	—	—	.74–1.45 [.029-.057]	.48–.89 [.019-.035]	22–26	D-602-0146	12	P	Twisted pair
M39029/75	915308-3	—	—	.74–1.45 [.029-.057]	.48–.89 [.019-.035]	22–26	D-602-0147	12	S	Twisted pair
M39029/28	915307-2	1.90–3.81 [.075-.150]	2.54–2.97 [.100-.117]	1.27–2.62 [.050-.103]	.48–.89 [.019-.035]	22, 28	D-602-0150	12	P	Coaxial
M39029/75	915308-2	1.90–3.81 [.075-.150]	2.54–2.97 [.100-.117]	1.27–2.62 [.050-.103]	.48–.89 [.019-.035]	22, 28	D-602-0151	12	S	Coaxial
—	8340712-OS-01	2.49–3.42 [.098-.135]	1.68–3.05 [.066-.120]	.76–1.24 [.030-.049]	.27–.79 [.011-.031]	24–26	D-602-1108	8	S	Twisted pair <sup>b</sup>
—	8340713-OS-01	2.49–3.42 [.098-.135]	1.68–3.05 [.066-.120]	.76–1.24 [.030-.049]	.27–.79 [.011-.031]	24–26	D-602-1109	8	P	Twisted pair <sup>b</sup>
—	—	2.49–3.76 [.098-.148]	1.68–3.30 [.066-.130]	.91–1.78 [.036-.070]	.23–.89 [.009-.035]	22–26	D-602-1110	8	S	Triaxial
—	—	2.49–3.76 [.098-.148]	1.68–3.30 [.066-.130]	.91–1.78 [.036-.070]	.23–.89 [.009-.035]	22–26	D-602-1111	8	P	Triaxial
—	8340712-OL-01	2.49–3.42 [.098-.135]	1.68–3.05 [.066-.120]	.76–1.24 [.030-.049]	.27–.79 [.011-.031]	24–26	D-602-1112	8	S	Twisted pair <sup>b</sup>
—	8340713-OL-01	2.49–3.42 [.098-.135]	1.68–3.05 [.066-.120]	.76–1.24 [.030-.049]	.27–.79 [.011-.031]	24–26	D-602-1113	8	P	Twisted pair <sup>b</sup>
M39029/90	8912020-OS-01	3.68 [.145] Max.	—	.64–1.29 [.029-.051]	.27–.74 [.011-.029]	24–26	DK-602-0156-N-1	8	P	Twinaxial <sup>c</sup>
M39029/90	8912020-DL-01	4.11 [.162] Max.	—	.64–1.29 [.029-.051]	.27–.74 [.011-.029]	24–26	DK-602-0156-N-2	8	P	Twinaxial <sup>c</sup>

a These SolderTacts contacts are intermateable and intermountable with contacts qualified to indicated specification; they replace crimp-style termination.

b These SolderTacts contacts are designed for shielded twisted pair cable per MIL-STD-1553B.

c These SolderTacts contacts are designed for databus contacts per MIL-STD-1553B.

SolderTacts Shielded One-Piece Solder Contacts (Continued)

SolderTacts Series:  
MIL-C-38999, Series I, II,  
III, IV Circular Connectors

(Continued)

Contact Military Specification	United States Air Force Drawing No.	Cable Diameter (in inches)				Wire (AWG)	Raychem SolderTacts Part Number	Size	Polarity	Cable Type
		JOD	SOD	DOD	COD					
<b>Series I, III, and IV</b>										
M39029/90	8912020-EL-01	4.50 max. [.177]	—	.74-1.30 [.029-.051]	.24-.74 [.011-.029]	24-26	DK-602-0156-N-3	8	P	Twinaxial <sup>c</sup>
M39029/91	8912019-OS-01	3.68 max. [.145]	—	.74-1.30 [.029-.051]	.24-.74 [.011-.029]	24-26	DK-602-0157-N-1	8	S	Twinaxial <sup>c</sup>
M39029/91	8912019-DL-01	4.12 max. [.162]	—	.74-1.30 [.029-.051]	.24-.74 [.011-.029]	24-26	DK-602-0157-N-2	8	S	Twinaxial <sup>c</sup>
M39029/91	8912019-EL-01	4.50 max. [.177]	—	.74-1.30 [.029-.051]	.24-.74 [.011-.029]	24-26	DK-602-0157-N-3	8	S	Twinaxial <sup>c</sup>
M39029/90	8912020-OL-01	4.67 max. [.184]	—	—	—	20	DK-602-0169-1	8	P	Twinaxial <sup>c</sup>
M39029/91	8912019-OL-01	4.67 max. [.184]	—	—	—	20	DK-602-0170-1	8	S	Twinaxial <sup>c</sup>
<b>Series II</b>										
M39029/76	915304-1	1.27-2.62 [.050-.103]	1.68-2.13 [.066-.084]	.91-1.73 [.036-.068]	.23-.58 [.009-.023]	26-30	D-602-0140	16	P	Coaxial
M39029/77	915306-1	1.27-2.62 [.050-.103]	1.68-2.13 [.066-.084]	.91-1.73 [.036-.068]	.23-.58 [.009-.023]	26-30	D-602-0171	16	S	Coaxial
M39029/76	915304-2	—	—	.64-1.09 [.025-.043]	.23-.58 [.009-.023]	26-30	D-602-0142	16	P	Twisted pair
M39029/77	915306-2	—	—	.64-1.07 [.025-.042]	.23-.58 [.009-.023]	26-30	D-602-0174	16	S	Twisted pair

a These SolderTacts contacts are intermateable and intermountable with contacts qualified to indicated specification; they replace crimp-style termination.

b These SolderTacts contacts are designed for shielded twisted pair cable per MIL-STD-1553B.

c These SolderTacts contacts are designed for databus contacts per MIL-STD-1553B.

Tooling Selection Guide

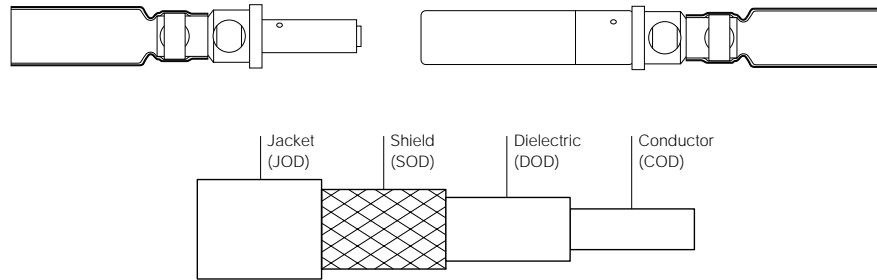
SolderTacts Series	Part Numbers (D-602-)	Engineering Standard (Termination Instructions)	Convection (Hot Air) Heating AT-1319 Adapter	Repair Wand	IR1004 Infrared Semiautomatic Heater Tool Set	Contact Insertion Tool	Contact Removal Tool*
999 Size 16	0140/0141	ES61226	AT-1319-78	AD-1565	AT-1044-70 (P)	M81969/8-07 or M81969/14-03	M81869/8-08 or M81969/14-03
	0142/0143	ES61224	—	—	AT-1044-69 (S)		
	0171	ES61226	AT-1319-27	AD-1572	—		
	0174	ES61224	—	—	—		
999 Size 12	0144/0145	ES61206	AT-1319-24	AD-1566	AT-1044-72 (P)	M81969/8-09 or M81969/14-04	M81969/8-10 or M81969/14-04
	0146/0147	ES61218	—	—	AT-1044-71 (S)		
	0150/0151	ES61223	—	—	—		
999 Size 8	0122/0123	ES61179	AT-1319-22	AD-1568	—	—	M81969/14-06 or Astro ATBX-2277
	1108/1109	ES61172	—	—	—		
	1110/1111	ES61172	—	—	—		
	1112/1113	ES61184	AT-1319-22 and AT-1319-14	AD-1568 and AD-1480	—		
	0156/0157-X	ES61231	—	—	—		
	0169/0170-X	ES61235	—	—	—		

\*Tyco Electronics does not provide this tool. See connector manufacturer.

SolderTacts Shielded One-Piece Solder Contacts (Continued)

SolderTacts Series:  
Subminiature\*

SolderTacts Product Construction, Submin Series



Raychem Cable Diameter

SolderTacts	Size	Polarity	Cable Type	Cable Diameter				(AWG)
				JOD	SOD	DOD	COD	
D-602-0278	16	P	Coaxial	1.52-2.92 [.060-.115]	1.85-2.18 [.073-.086]	.64-1.91 [.025-.075]	.23-.74 [.009-.029]	24-32
D-602-0279	16	S	Coaxial	1.52-2.92 [.060-.115]	1.85-2.18 [.073-.086]	.64-1.91 [.025-.075]	.23-.74 [.009-.029]	24-32
D-602-0288	16	P	Twisted pair	—	—	.74-1.40 [.029-.055]	.23-.74 [.009-.029]	24-32
D-602-0289	16	S	Twisted pair	—	—	.74-1.40 [.029-.055]	.23-.74 [.009-.029]	24-32

\*These SolderTacts contacts belong to the Raychem "Subminiature" series of contacts, which are designed for use in commercial connectors.

Tooling Selection Guide

SolderTacts Series	Part Numbers (D-602-)	Engineering Standard (Termination Instructions)	Convection (hot air) Heating AT-1319 Adapter	Repair Wand	IR1004 infrared Semiautomatic Heater Tool Set	Contact Insertion Tool	Contact Removal Tool	Special Tools
Submin	0278/0279	ES61170	AT-1319-12	AD-1481	Tool Set #9	*	AD-1503	AA-400-140
—	0288/0289	ES61169	—	—	(AT-1044-11)	—	—	(magnifier)

\*Not applicable.



SolderTacts Shielded One-Piece Solder Contacts (Continued)

SolderTacts Series:  
MIL-C-83723

Contact Military Specification*	Cable Diameter				Wire (AWG)	Raychem SolderTacts	Size	Polarity	Cable Type
	JOD	SOD	DOD	COD					
M39029/74-400	2.39-3.56 [.094-.140]	1.96-2.49 [.077-.098]	1.32-2.06 [.052-.081]	.28-.74 [.011-.029]	24-32	D-602-0094	12	P	Coaxial
M39029/73-397	2.39-3.56 [.094-.140]	1.96-2.49 [.077-.098]	1.32-2.06 [.052-.081]	.28-.74 [.011-.029]	24-32	D-602-0095	12	S	Coaxial
M39029/74-401	—	—	.74-1.45 [.029-.057]	.28-.74 [.011-.029]	24-32	D-602-0104	12	P	Twisted pair
M39029/73-398	—	—	.74-1.45 [.029-.057]	.28-.74 [.011-.029]	24-32	D-602-0105	12	S	Twisted pair
M39029/74-399	3.05-3.68 [.120-.145]	3.10-3.15 [.122-.124]	2.36-2.67 [.093-.105]	.28-.74 [.011-.029]	24-32	D-602-0106	12	P	Large coaxial
M39029/73-396	3.05-3.68 [.120-.145]	3.10-3.15 [.122-.124]	2.36-2.67 [.093-.105]	.28-.74 [.011-.029]	24-32	D-602-0107	12	S	Large coaxial

\* These SolderTacts contacts are on qualified parts list for indicated specification.

Tooling Selection Guide

Raychem SolderTacts Part Number	Engineering Standard (Termination Instructions)	Convection (Hot Air) Heating AT-1319 Adapter	Repair Wand	IR1004 infrared Semiautomatic Heater Tool Set	Contact Insertion Tool	Contact Removal Tool	Special Tools
D-602-0094/0095	ES61128	AT-1319-19	AD-1494	AT-1044-67 (P)	AD-1527	AD-1527	AD-1496
D-602-0106/0107	ES61134	Rev. D	Rev. C	AT-1044-68 (S)	(M81969/14-04)	(M81969/14-04)	(twisted)
D-602-0104/0105	ES61129	—	—	—	—	—	—

SolderTacts Series:  
DOD-C-83527

Raychem SolderTacts Reference	Size	Polarity	Cable Type	Contact Military Specification
D-602-0185	16	socket	Coaxial	—
D-602-0094	12	pin	Coaxial	M39029/74
D-602-0093	12	socket	Coaxial	M39029/73
D-602-0106	12	pin	Coax (large)	M39029/74
D-602-0189	12	socket	Coax (large)	M39029/73

SolderTacts Series: DOD-C-83527 (data bus contacts)\*

Raychem SolderTacts Reference	Size	Polarity	Cable Type	Contact Military Specification
D-602-0186	8	pin	Twisted pair	M39029/96
D-602-0187	8	socket	Twisted pair	M39029/95
DK-602-0186-2	8	pin	Sh. twisted pair	M39029/96
DK-602-0187-2	8	socket	Sh. twisted pair	M39029/95

\* These SolderTacts contacts are on designed for shielded twisted pair cable per MIL-STD-1553B.

**SolderTacts Series:  
Grommets****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 Tyco Electronics.

**SolderTacts Shielded One-Piece Solder Contacts (Continued)**

Raychem SolderTacts Reference	Size	Polarity
D-600-0071	—	For shielded twisted pair
D-600-0116	For size 8 DOD-C-83527 series	—
D-600-0125	For size 8 MIL-C-38999 series, for twisted pair	—

Holding Fixture Tool AD-1319-9

**Product Facts**

- AD-1319-9 comes with two lateral wire clamps as standard
- Secures wire or cable, enabling easy installation of products

**Applications**

Simplifies and speeds installation of Raychem SolderSleeve terminators or splices and SolderTacts shielded contacts.



**Specifications and Dimensions**

Dimensions	18 cm [7.07 in] W x 15 cm [5.91 in] L
Weight	300 g [.67 lb]

**Product Range Covered**

SolderSleeve splices	MiniSeal, CWT-9XXX, D-1744, D-110
Shield terminators	D-100-XX
SolderTacts contacts	D-602-XX

**Ordering Information**

Model	Description	Part No.
Holding fixture	AD-1319-9	993850-000
38999 size 8 SolderTacts adapter	AT-1319-22	395241-000
38999 size 16 SolderTacts adapter	AT-1319-78	413186-000
Submin SolderTacts adapter	AT-1319-12	993872-000
748 SolderTacts adapter	AT-1319-14	993877-000
723 SolderTacts adapter	AT-1319-19	993938-000
482 size 16 SolderTacts adapter	AT-1319-17	993917-000

Note: Additional tooling for SolderTacts can be found under SolderTacts contacts, see page 2007.

Infrared Heating Tool IR-550 Mark II

Product Facts

- Lightweight, portable unit with pedestal base for benchtop operation
- Foot switch, so both hands can be free to hold parts
- Commercially available tungsten-halogen lamp
- Fan-cooled housing
- Instant on/off heat
- Viewing window that allows parts to be inspected during installation
- Quiet, focused IR operation

Applications

Used for installing small and large Solder Sleeve devices and SolderTacts contacts.



Specifications

Input power	105–120 V, 50–60 Hz, 4.5 A
Normal lamp life	More than 100 hours of intermittent use
Weight	Approximately 2.5 kg [5.5 lb]
Duty cycle	80%, 90-second max. heating times

**Note:** For 230V CE-approved version, contact Tyco Electronics

Ordering Information

Model	Description	Part No.
IR-550 heating tool* (120 V) with RG-2 reflector, viewing window, and foot switch	IR-550-50-MARKII-HT-TOOL	994350-000

Accessories and Replacement Parts

IR-550 foot switch (included with tool assembly 994350)	IR-550-216	994375-000
RG-6 reflector for large-diameter Solder Sleeve terminations; aperture is 25.4 [1.0] wide	IR-550-19	994590-000
RG-11 reflector; aperture is 12.7 [.5] wide	IR-550-41	993695-000
RG-9 reflector; aperture is 9.525 [.375] wide	IR-550-39	993693-000
RG-2 reflector, included with 994350; aperture is 19.05 [.75] wide	IR-550-24	993770-000
Lamp (120 V)	IR-1000-P-N-13	993020-000
Optical filter	IR-550-237	118902-000
Viewing window (frame not included)	IR-550-238	007510-000

\*IR tools are not recommended for use with black wire or cable insulations.

**Product Facts**

- Small, lightweight, fan-cooled unit
- Small profile for installation where space is restricted
- Handheld operation
- Focused heat
- Quiet, efficient IR operation
- CE approved

**Applications**

Used for installing SolderSleeve devices and SolderTacts contacts.

**Infrared Heating Tool IR-1759 MiniRay**



**Specifications and Dimensions**

Lamp	Tungsten-halogen Nominal power 250 W, 24 Vac, 50–60 Hz
Fan	12 Vac (supplied through control unit)
Weight	.73 kg [1.6 lb]
Cable length	2 m [6.5 ft]
<b>Electronic Control Unit</b>	
Main supply	110/230 Vac, 50/60 Hz, 11 A/5.5A universal
Weight	3.4 kg [7.6 lb]
Dimensions	16.3 x 12.2 x 12.2 cm [6.4 x 4.8 x 4.8 in.]

**Ordering Information**

	Description	Part No.
Complete kit consisting of: Handtool/Reflector/Control Box (Dual voltage)	IR1759-MK3-AT3130-EDCont	898738-000

**Accessories and Replacement Parts**

Handtool, standard aperture	IR-1759-MK3/A	986899-000
Handtool, large aperture	IR-3104-MK3/A	035343-000
Control Box with time control-230 V	ED-7-001-MK2-230V-50HZ	869233-000
Control Box with time control-110 V	ED-7-002-MK2-110V-60HZ	903553-000
Control Box with manual control-110/230V	ED-7-CONT-230/110V	684886-000
Battery Box	ED-7-Batterybox-230/110V	448969-000
Conversion kit (AE-897) for adapting standard-aperture MiniRay heating tool to wide-aperture MiniRay tool (includes reflector)	AT-313/AE-897	934630
Inner reflector (standard aperture)	AE-424	547918-000
Inner reflector (wide aperture)	AE-153	988285-000
Lamp (250 W, 24 V)	NAE-143-3	988208-000
Filter (standard aperture) US	AES-IR1759-100	431468-000 (US only)
Filter (standard aperture) UK	NAE-144-2	988128-000
Filter (wide aperture)	NAE-144-3	988293-000

\*IR tools are not recommended for use with black wire or cable insulations.

