



Shielded Contacts

SolderTacts shielded one-piece solder contacts



Applications

One-piece controlled-soldering SolderTacts contacts 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 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.

Features and benefits

- 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.

Available in:

Americas

Europe

Asia Pacific



Specifications/approvals

Series

Raychem

D-602

D-6002

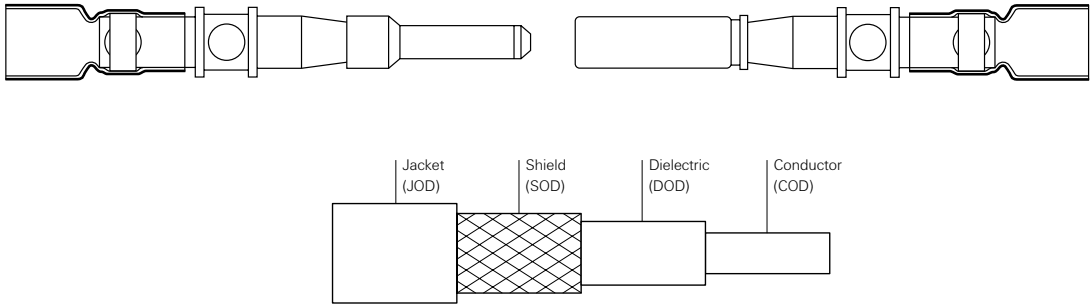
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SolderTacts product construction, MIL-C-26482 Series



SolderTacts series: MIL-C-26482

Contact military specification	Cable diameter (in inches)				Wire (AWG)	Raychem SolderTacts			
	JOD	SOD	DOD	COD		part number	Size	Polarity	Cable type
MIS-20067/5-001†	.070-.185	.065-.110	.030-.080	.009-.020	24-32	D-602-16	12	S	Coaxial
MIS-20067/6-001†	.070-.185	.065-.110	.030-.080	.009-.020	24-32	D-602-17	12	P	Coaxial
	.060-.130	.066-.089	.036-.069	.012-.026	24-30	D-602-46	16	P	Coaxial
	.060-.130	.066-.084	.036-.069	.012-.026	26-32	D-602-47	16	S	Coaxial
			.030-.049	.011-.031	24-30	D-602-56	16	P	Twinax
		.030-.049	.011-.031	24-30	D-602-57	16	S	Twinax	

†These SolderTact 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					

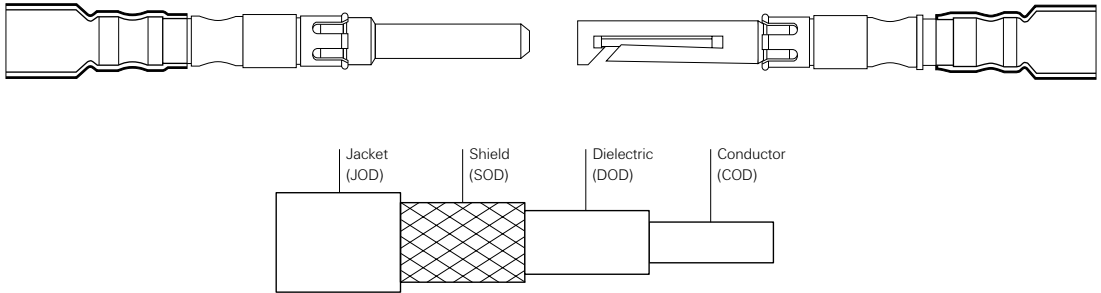
*Could be developed.

Users should independently evaluate the suitability of the product for their application. Before ordering check with factory for most current data.

Shielded Contacts

SolderTacts shielded one-piece solder contacts (cont'd.)

SolderTacts product construction, MIL-C-28748 Series



SolderTacts Series: MIL-C-28748 Series

Contact military specification	Cable diameter (in inches)				Wire (AWG)	Raychem SolderTacts			
	JOD	SOD	DOD	COD		part number	Size	Polarity	Cable type
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

^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.

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Visit our website at www.tycoelectronics.com**Tooling selection guide: MIL-C-28748 Series**

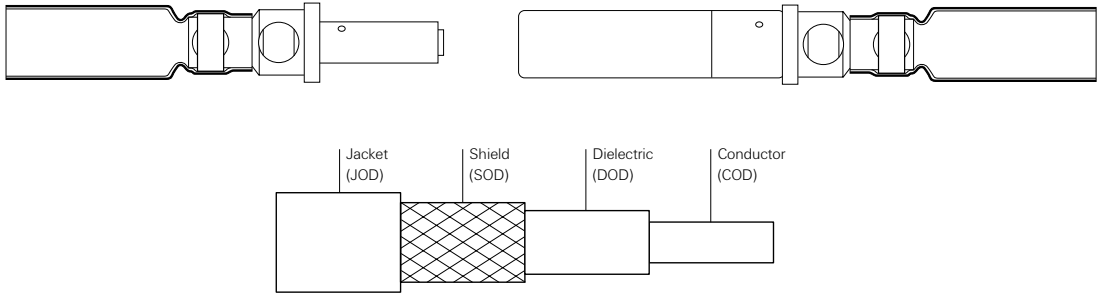
SolderTacts series	Part numbers	Engineering standard (termination instructions)	Convection (hot air) heating AT-1319 adapter	Repair wand	IR1004 infrared semiautomatic heater tool set
748	D-602-44/45	ES61133	AT-1319-14	AD-1480	Tool Set #2
	D-602-0172/0173	ES61240			
	D-602-54/55	ES61132			
	D-602-0126/0127	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.

Shielded Contacts

SolderTacts shielded one-piece solder contacts (cont'd.)

SolderTacts product construction, MIL-C-38999 Series



SolderTacts Series: MIL-C-38999, Series I, II, III, IV circular connectors

Contact military specification	United States Air Force drawing no.	Cable diameter (in inches)				Raychem		Size	Polarity	Cable type
		JOD	SOD	DOD	COD	Wire (AWG)	SolderTacts part number			
Series I, III, and IV										
M39029/60		.150-.234	.150-.170	.060-.151	.019-.043	22-24	D-602-0122	8	P	Coaxial
M39029/59		.150-.234	.150-.170	.060-.151	.019-.043	22-24	D-602-0123	8	S	Coaxial
M39029/76	915304-1	.050-.103	.066-.084	.036-.068	.009-.023	26-30	D-602-0140	16	P	Coaxial
M39029/77	915305-1	.050-.103	.066-.084	.036-.068	.009-.023	26-30	D-602-0141	16	S	Coaxial
M39029/76	915304-2	n/a	n/a	.025-.043	.009-.023	26-30	D-602-0142	16	P	Twisted pair
M39029/77	915305-2	n/a	n/a	.025-.043	.009-.023	26-30	D-602-0143	16	S	Twisted pair
M39029/28	915307-1	.058-.122	.066-.094	.044-.080	.019-.035	24-32	D-602-0144	12	P	Coaxial
M39029/75	915308-1	.058-.122	.066-.094	.044-.080	.019-.035	24-32	D-602-0145	12	S	Coaxial
M39029/28	915307-3	n/a	n/a	.029-.057	.019-.035	22-26	D-602-0146	12	P	Twisted pair
M39029/75	915308-3	n/a	n/a	.029-.057	.019-.035	22-26	D-602-0147	12	S	Twisted pair
M39029/28	915307-2	.075-.150	.100-.117	.050-.103	.019-.035	22, 28	D-602-0150	12	P	Coaxial
M39029/75	915308-2	.075-.150	.100-.117	.050-.103	.019-.035	22, 28	D-602-0151	12	S	Coaxial
	8340712-OS-01	.098-.135	.066-.120	.030-.049	.011-.031	24-26	D-602-1108	8	S	Twisted pair ^b
	8340713-OS-01	.098-.135	.066-.120	.030-.049	.011-.031	24-26	D-602-1109	8	P	Twisted pair ^b
		.098-.148	.066-.130	.036-.070	.009-.035	22-26	D-602-1110	8	S	Triaxial
		.098-.148	.066-.130	.036-.070	.009-.035	22-26	D-602-1111	8	P	Triaxial
	8340712-OL-01	.098-.135	.066-.120	.030-.049	.011-.031	24-26	D-602-1112	8	S	Twisted pair ^b
	8340713-OL-01	.098-.135	.066-.120	.030-.049	.011-.031	24-26	D-602-1113	8	P	Twisted pair ^b
M39029/90	8912020-OS-01	.145 max.		.029-.051	.011-.029	24-26	DK-602-0156-N-1	8	P	Twinaxial ^c
M39029/90	8912020-DL-01	.162 max.		.029-.051	.011-.029	24-26	DK-602-0156-N-2	8	P	Twinaxial ^c

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SolderTacts Series: MIL-C-38999, Series I, II, III, IV circular connectors (cont'd.)

Contact	United States					Raychem				
military specification	Air Force drawing no.	Cable diameter (in inches)				Wire (AWG)	SolderTacts part number	Size	Polarity	Cable type
		JOD	SOD	DOD	COD					
Series I, III, and IV										
M39029/90	8912020-EL-01	.177 max.		.029-.051	.011-.029	24-26	DK-602-0156-N3	8	P	Twinaxial ^c
M39029/91	8912019-OS-01	.145 max.		.029-.051	.011-.029	24-26	DK-602-0157-N1	8	S	Twinaxial ^c
M39029/91	8912019-DL-01	.162 max.		.029-.051	.011-.029	24-26	DK-602-0157-N2	8	S	Twinaxial ^c
M39029/91	8912019-EL-01	.177 max.		.029-.051	.011-.029	24-26	DK-602-0157-N3	8	S	Twinaxial ^c
M39029/90	8912020-OL-01	.184 max.				20	DK-602-0169-1	8	P	Twinaxial ^c
M39029/91	8912019-OL-01	.184 max. 2				20	DK-602-0170-1	8	S	Twinaxial ^c

Series II

M39029/76	915304-1	.050-.103	.066-.084	.036-.068	.009-.023	26-30	D-602-0140	16	P	Coaxial
M39029/77	915306-1	.050-.103	.066-.084	.036-.068	.009-.023	26-30	D-602-0171	16	S	Coaxial
M39029/76	915304-2	n/a	n/a	.025-.043	.009-.023	26-30	D-602-0142	16	P	Twisted pair
M39029/77	915306-2			.025-.042	.009-.023	26-30	D-602-0174	16	S	Twisted pair

a These SolderTacts contacts are interchangeable 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 Series: MIL-C-38999 (cont'd.)

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	M81869/8-08
	0142/0143	ES61224			AT-1044-69 (S)	or	or
	0171	ES61226	AT-1319-27	AD-1572		M81969/14-03	M81969/14-03
	0174	ES61224					
999 Size 12	0144/0145	ES61206	AT-1319-24	AD-1566	AT-1044-72 (P)	M81969/8-09	M81969/8-10
	0146/0147	ES61218			AT-1044-71 (S)	or	or
	0150/0151	ES61223				M81969/14-04	M81969/14-04
999 Size 8	0122/0123	ES61179	AT-1319-22	AD-1568			M81969/14-06
	1108/1109	ES61172	AT-1319-22	AD-1568			or
	1110/1111	ES61172	and	and			Astro ATBX-2277
	1112/1113	ES61184	AT-1319-14	AD-1480			
	0156/0157-X	ES61231					
	0169/0170-X	ES61235					

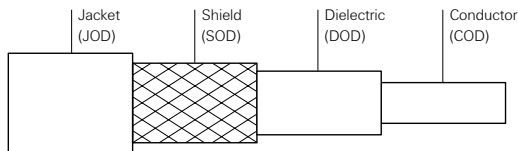
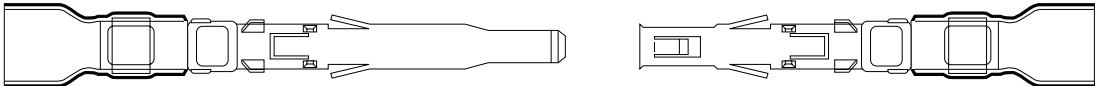
*Tyco Electronics does not provide this tool. See connector manufacturer.

Users should independently evaluate the suitability of the product for their application. Before ordering check with factory for most current data.

Shielded Contacts

SolderTacts shielded one-piece solder contacts (cont'd.)

SolderTacts product construction, Submin Series



SolderTacts Series: Subminiature*

Raychem Cable diameter (in inches)				Wire				
SolderTacts	Size	Polarity	Cable type	JOD	SOD	DOD	COD	(AWG)
D-602-0278	16	P	Coaxial	.060-.115	.073-.086	.025-.075	.009-.029	24-32
D-602-0279	16	S	Coaxial	.060-.115	.073-.086	.025-.075	.009-.029	24-32
D-602-0288	16	P	Twisted pair			.029-.055	.009-.029	24-32
D-602-0289	16	S	Twisted pair			.029-.055	.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-13 19 adapter	Repair AD-1481 wand	IR1004 infrared semiautomatic heater tool set	Contact insertion tool	Contact removal tool	Special tools
Submin	0278/0279 0288/0289	ES61170 ES61169	AT-1319-12	AD-1481	ToolSet #9 (AT-1044-11)	*	AD-1503	AA-400-140 (magnifier)

*Not applicable.

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Contact

military specification*	Cable diameter (in inches)				Wire (AWG)	Raychem				
	JOD	SOD	DOD	COD		SolderTacts	Size	Polarity	Cable type	
M39029/74-400	.094-.140	.077-.098	.052-.081	.011-.029	24-32	D-602-0094	12	P	Coaxial	
M39029/73-397	.094-.140	.077-.098	.052-.081	.011-.029	24-32	D-602-0095	12	S	Coaxial	
M39029/74-401			.029-.057	.011-.029	24-32	D-602-0104	12	P	Twisted pair	
M39029/73-398			.029-.057	.011-.029	24-32	D-602-0105	12	S	Twisted pair	
M39029/74-399	.120-.145	.122-.124	.093-.105	.011-.029	24-32	D-602-0106	12	P	Large coaxial	
M39029/73-396	.120-.145	.112-.124	.093-.105	.011-.029	24-32	D-602-0107	12	S	Large coaxial	

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

Users should independently evaluate the suitability of the product for their application.
Before ordering check with factory for most current data.

Shielded Contacts

SolderTacts shielded one-piece solder contacts (cont'd.)

SolderTacts Series: Grommets

Raychem SolderTacts reference	Size	Polarity	Cable type	Contact military specification
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			

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 Tyco Electronics product representative.

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