

FED. SUPPLY CLASS

5940

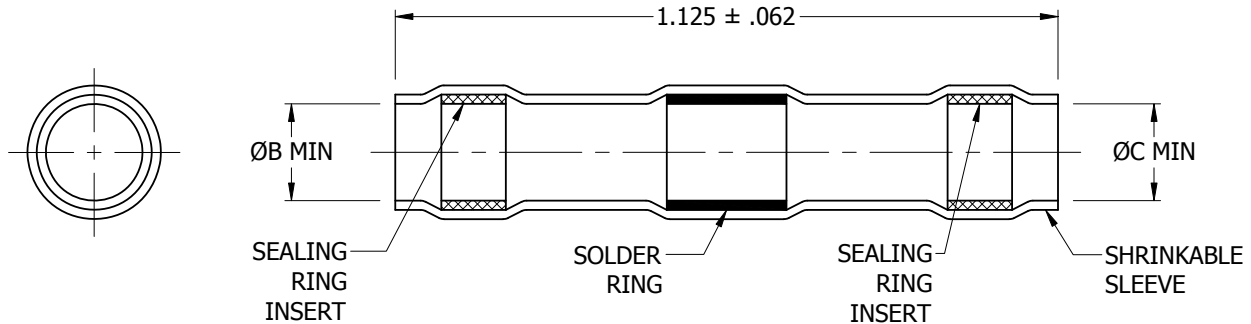


FIGURE 1

TABLE I – DIMENSIONS AND MATERIALS

DASH NUMBER	AS SUPPLIED		LAP SPLICE						CONDUCTOR COATING	SOLDER RING/ FLUX/ INSERT COLOR
	ØB	ØC	CMA OF CONDUCTORS /2/							
			2 WIRES		3 OR 4 WIRES		5 OR 6 WIRES			
			MAX	MIN	MAX	MIN	MAX	MIN		
1	.075	.095	2,000	350	1,400	900	—	—	TINNED OR SILVER	~~SN-63 SRMAP PER QQ-S-571~~ SOLDER: TYPE 63Sn PER J-STD-006 FLUX: TYPE ROL1 PER J-STD-004
2	.110	.125	4,000	2,000	2,800	1,400	2,000	1,500		
3	.180	.200	10,000	4,000	9,200	2,800	7,700	2,000		
4	.280	.300	13,000	10,000	18,000	9,200	16,000	7,700		
5	.075	.095	2,000	350	1,400	900	—	—	NICKEL	~~SN-63 SRAP PER QQ-S-571~~ SOLDER: TYPE 63Sn PER J-STD-006 FLUX: TYPE ROM1 PER J-STD-004
6	.110	.125	4,000	2,000	2,800	1,400	2,000	1,500		
7	.180	.200	10,000	4,000	9,200	2,800	7,700	2,000		
8	.280	.300	13,000	10,000	18,000	9,200	16,000	7,700		

MATERIAL:

- SEALING RING INSERT - THERMALLY STABILIZED, MELTABLE, THERMOPLASTIC.
SOLDER RING - AS TABULATED.
SHRINKABLE SLEEVE - EXPANDED, TRANSPARENT, IRRADIATED POLYVINYLIDENE FLUORIDE, BLUE TINT.

EXAMPLE OF PART NUMBER:

- NAS1744-1 = IMMERSION RESISTANT SPLICE FOR USE WITH WIRE HAVING TINNED OR SILVER PLATED CONDUCTORS WITH CONTINUOUS INSULATION TEMPERATURE RATING OF 125 °C.
NAS1744-7 = IMMERSION RESISTANT SPLICE FOR USE WITH WIRE HAVING NICKEL PLATED CONDUCTORS WITH CONTINUOUS INSULATION TEMPERATURE RATING OF 125 °C MIN.

THIRD ANGLE PROJECTION	CUSTODIAN NATIONAL AEROSPACE STANDARDS COMMITTEE	REVISION 5
		CLASSIFICATION PART STANDARD
PROCUREMENT SPECIFICATION NAS1747	TITLE SPLICE, CONDUCTOR, SOLDER STYLE, HOT AIR OR INFRARED, SHRINKABLE, INSULATED, IMMERSION RESISTANT	NAS1744 SHEET 1 OF 3

NOTES:

- (1) DIMENSIONS IN INCHES.
- /2/ THE CMS RANGE AS TABULATED SHALL NOT BE EXCEEDED. THE FIGURES ARE BASED ON TOTAL SURFACE AREA TO BE SOLDERED AND TOTAL MASS OF THE CONDUCTORS IN ORDER TO PROVIDE OPTIMUM SOLDER FLOW.
- (3) THIS STANDARD TAKES PRECEDENCE OVER DOCUMENTS REFERENCED HEREIN.
- (4) UNLESS OTHERWISE SPECIFIED, PART INVENTORY MANUFACTURED TO PREVIOUS REVISIONS OF THE APPLICABLE DRAWING OR SPECIFICATION MAY BE PROCURED AND USED UNTIL STOCK IS DEPLETED.
- ⑤ (5) UNLESS OTHERWISE SPECIFIED HEREIN, REFERENCED DOCUMENTS SHALL BE THE ISSUE IN EFFECT ON DATE OF MANUFACTURE. HOWEVER, EXISTING MATERIAL INVENTORY CERTIFIED TO A PREVIOUS REVISION OF THE APPLICABLE MATERIAL SPECIFICATION(S) IS ACCEPTABLE FOR USE UNTIL DEPLETION.
- (6) DIMENSIONING AND TOLERANCING PER ANSI Y14.5M-1982.

RECOMMENDED INSTALLATION METHOD:

HOT AIR OR INFRARED HEATER WITH HEAT REFLECTOR, IN ACCORDANCE WITH MANUFACTURERS RECOMMENDATIONS.

INSTALLED PERFORMANCE REQUIREMENTS:

TRANSPARENCY:	BEFORE THE HEAT SHRINKING AND MELTING PROCEDURE, THE SOLDER RING INSERT AND COMPONENT CONDUCTORS SHALL BE READILY VISIBLE BY THE UNAIDED EYE.
VOLTAGE DROP:	SPLICES: TABULATED.
PULL OUT STRENGTH:	TABULATED.
DIELECTRIC STRENGTH:	2000 VOLTS MIN.
VIBRATION:	10-70 CPS AT .06 INCH, DA AND 70 TO 2000 CPS AT 15G PEAK FOR 4 HOURS IN EACH PLANE. VOLTAGE DROP: TABULATED.
TEMPERATURE CYCLING:	-65 ± 3 °C TO -150 ± 3 °C, 5 CYCLES. VOLTAGE DROP: TABULATED.
ALTITUDE IMMERSION:	75,000 FT MIN, 1,000 MΩ INSULATION RESISTANCE.
FLUID RESISTANCE:	IMMUNE TO DETERIORATION IN THE FOLLOWING TYPES OF FLUIDS: MIL-PRF-5606, TT-I-735, MIL-PRF-7808, MIL-L-27502, MIL-DTL-5624, A-A-53880, AS1241, AMS1424, MIL-PRF-23699 AND MIL-C-87937.
FLAMMABILITY:	SELF EXTINGUISHING, 15 SEC MAX.
CORROSION RESISTANCE:	96 HOURS AT 35 ± 3 °C.

REVISION

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Documents

SHEET 2

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