

RUGGED

- Transparent insulation sleeve provides encapsulation, inspectability, strain relief, and insulation

VERSATILE

- Spiral copper coil grips and compresses the conductors for optimum solder connection
- Prefluxe solder preform provides a controlled soldering process
- Accommodates a wide variety of conductor types, quantities, sizes, and plating types unmatched by any other termination technique

HIGH PERFORMANCE

- Parts meet the performance requirements of MIL-T-7928G

EASY TO USE

- One-piece design for easy installation

APPLICATIONS

- Used for terminating multiple wires to terminals

SolderGrip Self-Fixturing Insulated Terminals

Product Selection Process

1. Determine the wire combination (number of wires and size) of the wire bundle you wish to terminate.
2. Use Table C to select the correct terminal for AWG wire combination.* Example: For connecting a bundle with one 12 AWG wire (1 #12) and two 18 AWG wires (+ 2 #18) to a terminal, you need an SGRT-4-XX terminal.
3. Determine the correct stud size.
4. Select the correct part number from Table A for that stud size in the terminal series and size you selected in Step 2. Example: If the stud size is 1/4, select part number SGRT-4-06.
5. Verify that the wire bundle (with wire insulation) does not exceed the maximum diameter allowed for the part you selected. Simply check the bundle’s diameter against the maximum diameter that Table A lists for that part.
6. Verify that the total amperage to be applied does not exceed the maximum amp rating for the part as specified in Table A.

*If the wire combination is not listed in Table B, use the CMA (mm²) method of determining wire bundle size (see “CMA/mm² Calculation” on page 37).

Using Table B, select the smallest size part that will fit your total wire CMA (mm²) value.

Product Option

Product Series	Environmental Protection
SGRT	Splashproof (not RoHS compliant)

Table A. Part Number Selection

SolderGrip Part No.	Stud Size	Maximum Bundle Diameter†	Maximum Amp Rating	Wire Range (Min.–Max.) CMA [mm ²]	Typical Length
SGRT-1-02	2 [2]	4.1 [.161]	12.5 A	1400–5000 [0.7–2.5]	38 [1 1/2]
SGRT-2-03	3 [6]	5.0 [.195]	15 A	2400–6000 [1.2–3.0]	38 [1 1/2]
SGRT-2-04	4 [8]	—	15 A	2400–6000 [1.2–3.0]	38 [1 1/2]
SGRT-2-05	5 [10]	—	15 A	2400–6000 [1.2–3.0]	38 [1 1/2]
SGRT-2-06	6 [1/4]	—	15 A	2400–6000 [1.2–3.0]	38 [1 1/2]
SGRT-3-06	6 [1/4]	6.5 [.255]	33 A	5000–13,200 [2.5–6.6]	44.5 [1 3/4]
SGRT-3-08	8 [5/16]	—	33 A	5000–13,200 [2.5–6.6]	51.0 [2]
SGRT-4-06	6 [1/4]	9.0 [.355]	56 A	12,000–22,400 [6.0–11.2]	44.5 [1 3/4]
SGRT-4-08	8 [5/16]	—	56 A	12,000–22,400 [6.0–11.2]	51 [2]

†Maximum bundle diameter is measured over wire insulation.



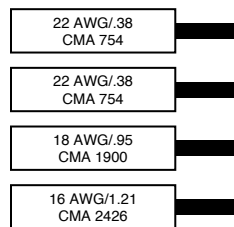
CMA/mm² Calculation

To calculate the total circular mil or mm² area of the wire bundle to be terminated, follow these steps:

1. Choose either CMA or mm² as your unit of measure for selection purposes and continue to use it for all your selection criteria. (Both measures provide the same results.)
2. In the workspace below, list the CMA or mm² for each conductor in the bundle. (Table B provides the CMA of typical conductors.)
3. Add together the values listed in the workspace below to obtain the total area.
4. Use Table A to select the smallest terminator that will fit the total CMA (mm²).

Wire Number	CMA	mm ²	
1	_____	_____	
2	_____	_____	
3	_____	_____	
4	_____	_____	
5	_____	_____	
6	_____	_____	
7	_____	_____	
8	_____	_____	
9	_____	_____	
10	_____	_____	
Total			Solder Grip Part No.

CMA/mm² Example



Total CMA = 5834
 Total mm² = 2.92
 Correct part number (based on CMA of 5834 or mm² of 2.92): SGR-T-2-XX if bundle OD is less than 5.0 mm (0.195 in).

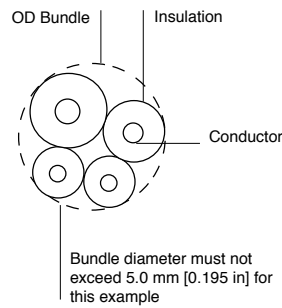




Table B. CMA of Typical Copper Conductors

Strands	7	19	19	19	19	19	19	19	37
AWG	28	26	24	22	20	18	16	14	12
CMA	177	304	475	754	1216	1900	2426	3831	5874
mm ²	0.09	0.15	0.24	0.38	0.61	0.95	1.21	1.92	2.94

Table C. SolderGrip Wire Combinations (see Table A for Terminal Size [-XX])

Wire Combinations	Part No.	Wire Combinations	Part No.	Wire Combinations	Part No.
1 # 8	SGRT-4-XX	1 # 12 + 1 # 16 + 4 # 18	SGRT-4-XX	1 # 14 + 4 # 20	SGRT-3-XX
1 # 8 + 1 # 16	SGRT-4-XX	1 # 12 + 2 # 16	SGRT-3-XX	1 # 14 + 1 # 18	SGRT-2-XX
2 # 8 + 2 # 16	SGRT-4-XX	1 # 12 + 2 # 16 + 1 # 18	SGRT-3-XX	1 # 14 + 1 # 18 + 1 # 20	SGRT-3-XX
1 # 8 + 1 # 14	SGRT-4-XX	1 # 12 + 2 # 16 + 2 # 18	SGRT-4-XX	1 # 14 + 2 # 18	SGRT-3-XX
1 # 10	SGRT-3-XX	1 # 12 + 3 # 16	SGRT-4-XX	1 # 14 + 3 # 18	SGRT-3-XX
1 # 10 + 1 to 3 # 18	SGRT-3-XX	1 # 12 + 4 # 16	SGRT-4-XX	1 # 14 + 4 # 18	SGRT-3-XX
1 # 10 + 2 # 18	SGRT-3-XX	1 # 12 + 5 # 16	SGRT-4-XX	1 # 14 + 5 # 18	SGRT-4-XX
1 # 10 + 3 # 18	SGRT-4-XX	1 # 12 + 1 # 14 + 1 # 18	SGRT-3-XX	1 # 14 + 1 # 16	SGRT-3-XX
1 # 10 + 1 # 16	SGRT-3-XX	1 # 12 + 1 # 14 + 2 # 18	SGRT-4-XX	1 # 14 + 1 # 16 + 1 # 20	SGRT-3-XX
1 # 10 + 1 # 16 + 1 # 18	SGRT-4-XX	1 # 12 + 1 # 14 + 3 # 18	SGRT-4-XX	1 # 14 + 1 # 16 + 1 # 18	SGRT-3-XX
1 # 10 + 1 # 16 + 2 # 18	SGRT-4-XX	1 # 12 + 1 # 14 + 1 # 16	SGRT-3-XX	1 # 14 + 1 # 16 + 2 # 18	SGRT-3-XX
1 # 10 + 2 # 16	SGRT-4-XX	1 # 12 + 1 # 14 + 2 # 16	SGRT-4-XX	1 # 14 + 1 # 16 + 3 # 18	SGRT-3-XX
1 # 10 + 3 # 16	SGRT-4-XX	1 # 12 + 1 # 14 + 3 # 16	SGRT-4-XX	1 # 14 + 1 # 16 + 4 # 18	SGRT-4-XX
1 # 10 + 4 # 16	SGRT-4-XX	1 # 12 + 1 # 14 + 4 # 16	SGRT-4-XX	1 # 14 + 2 # 16	SGRT-3-XX
1 # 10 + 5 # 16	SGRT-4-XX	1 # 12 + 2 # 14	SGRT-4-XX	1 # 14 + 2 # 16 + 1 # 18	SGRT-3-XX
1 # 10 + 1 # 14	SGRT-3-XX	1 # 12 + 2 # 14 + 1 # 18	SGRT-4-XX	1 # 14 + 2 # 16 + 2 # 18	SGRT-3-XX
1 # 10 + 1 # 14 + 1 # 18	SGRT-4-XX	1 # 12 + 2 # 14 + 1 # 16	SGRT-4-XX	1 # 14 + 2 # 16 + 3 # 18	SGRT-4-XX
1 # 10 + 1 # 14 + 1 # 16	SGRT-4-XX	1 # 12 + 2 # 14 + 2 # 16	SGRT-4-XX	1 # 14 + 3 # 16	SGRT-3-XX
1 # 10 + 1 # 14 + 2 # 16	SGRT-3-XX	1 # 12 + 2 # 14 + 3 # 16	SGRT-4-XX	1 # 14 + 3 # 16 + 1 # 18	SGRT-3-XX
1 # 10 + 1 # 14 + 3 # 16	SGRT-4-XX	1 # 12 + 3 # 14	SGRT-4-XX	1 # 14 + 3 # 16 + 2 # 18	SGRT-4-XX
1 # 10 + 2 # 14	SGRT-4-XX	1 # 12 + 3 # 14 + 1 # 16	SGRT-4-XX	1 # 14 + 4 # 16	SGRT-4-XX
1 # 10 + 3 # 14	SGRT-4-XX	1 # 12 + 4 # 14	SGRT-4-XX	1 # 14 + 4 # 16 + 1 # 18	SGRT-4-XX
1 # 10 + 1 # 12	SGRT-4-XX	2 # 12 + 1 # 18	SGRT-4-XX	1 # 14 + 5 # 16	SGRT-4-XX
1 # 10 + 1 # 12 + 1 # 14	SGRT-4-XX	2 # 12 + 1 # 16	SGRT-4-XX	2 # 14	SGRT-3-XX
1 # 10 + 2 # 12	SGRT-4-XX	2 # 12 + 2 # 16 + 1 # 18	SGRT-4-XX	2 # 14	SGRT-3-XX
2 # 10	SGRT-4-XX	2 # 12 + 3 # 16	SGRT-4-XX	2 # 14	SGRT-3-XX
2 # 10 + 1 # 16	SGRT-4-XX	2 # 12 + 1 # 14 + 1 # 18	SGRT-4-XX	2 # 14	SGRT-3-XX
1 # 12	SGRT-3-XX	2 # 12 + 1 # 14 + 1 # 16	SGRT-4-XX	2 # 14	SGRT-3-XX
1 # 12 + 1 # 18	SGRT-3-XX	2 # 12 + 2 # 14	SGRT-4-XX	2 # 14 + 1 # 16	SGRT-3-XX
1 # 12 + 2 # 18	SGRT-3-XX	3 # 12 + 1 # 18	SGRT-4-XX	2 # 14 + 1 # 16	SGRT-3-XX
1 # 12 + 3 # 18	SGRT-3-XX	3 # 12 + 1 # 16	SGRT-4-XX	2 # 14 + 1 # 16	SGRT-3-XX
1 # 12 + 4 # 18	SGRT-4-XX	3 # 12 + 1 # 14	SGRT-4-XX	2 # 14 + 1 # 16	SGRT-3-XX
1 # 12 + 5 # 18	SGRT-4-XX	1 # 14	SGRT-2-XX	2 # 14 + 2 # 16	SGRT-3-XX
1 # 12 + 1 # 16	SGRT-3-XX	1 # 14 + 1 # 22	SGRT-2-XX	2 # 14 + 2 # 16	SGRT-3-XX
1 # 12 + 1 # 16 + 1 # 18	SGRT-3-XX	1 # 14 + 1 # 20	SGRT-2-XX	2 # 14 + 3 # 16	SGRT-4-XX
1 # 12 + 1 # 16 + 2 # 18	SGRT-3-XX	1 # 14 + 2 # 20	SGRT-3-XX	2 # 14 + 4 # 16	SGRT-4-XX
1 # 12 + 1 # 16 + 3 # 18	SGRT-4-XX	1 # 14 + 3 # 20	SGRT-3-XX	3 # 14	SGRT-3-XX



Table C. SolderGrip Wire Combinations (see Table A for Terminal Size [-XX]) (Continued)

Wire Combinations	Part No.	Wire Combinations	Part No.	Wire Combinations	Part No.
3 # 14 + 1 # 16	SGRT-4-XX	2 # 16 + 4 # 20	SGRT-3-XX	1 # 18 + 1 # 20 + 2 # 22	SGRT-2-XX
3 # 14 + 2 # 16	SGRT-4-XX	2 # 16 + 1 # 18	SGRT-3-XX	1 # 18 + 2 # 20	SGRT-2-XX
3 # 14 + 3 # 16	SGRT-4-XX	2 # 16 + 1 # 18 + 1 # 20	SGRT-3-XX	1 # 18 + 3 # 20	SGRT-2-XX
4 # 14	SGRT-4-XX	2 # 16 + 1 # 18 + 2 # 20	SGRT-3-XX	1 # 18 + 4 # 20	SGRT-3-XX
4 # 14 + 1 # 16	SGRT-4-XX	2 # 16 + 1 # 18 + 3 # 20	SGRT-3-XX	1 # 18 + 5 # 20	SGRT-3-XX
4 # 14 + 2 # 16	SGRT-4-XX	2 # 16 + 2 # 18	SGRT-3-XX	2 # 18	SGRT-2-XX
5 # 14	SGRT-4-XX	2 # 16 + 2 # 18 + 1 # 20	SGRT-3-XX	2 # 18 + 1 # 22	SGRT-2-XX
5 # 14 + 1 # 16	SGRT-4-XX	2 # 16 + 2 # 18 + 2 # 20	SGRT-3-XX	2 # 18 + 1 # 20	SGRT-2-XX
1 # 16	SGRT-2-XX	2 # 16 + 3 # 18	SGRT-3-XX	2 # 18 + 2 # 20	SGRT-3-XX
1 # 16 + 1 # 22	SGRT-2-XX	2 # 16 + 3 # 18 + 1 # 20	SGRT-3-XX	2 # 18 + 3 # 20	SGRT-3-XX
1 # 16 + 2 # 22	SGRT-2-XX	2 # 16 + 4 # 18	SGRT-3-XX	2 # 18 + 4 # 20	SGRT-3-XX
1 # 16 + 3 # 22	SGRT-2-XX	3 # 16	SGRT-3-XX	3 # 18	SGRT-2-XX
1 # 16 + 1 # 20	SGRT-2-XX	3 # 16 + 1 # 20	SGRT-3-XX	3 # 18 + 1 # 20	SGRT-3-XX
1 # 16 + 1 # 20 + 1 # 22	SGRT-2-XX	3 # 16 + 2 # 20	SGRT-3-XX	3 # 18 + 2 # 20	SGRT-3-XX
1 # 16 + 2 # 20	SGRT-2-XX	3 # 16 + 3 # 20	SGRT-3-XX	3 # 18 + 3 # 20	SGRT-3-XX
1 # 16 + 3 # 20	SGRT-3-XX	3 # 16 + 1 # 18	SGRT-3-XX	4 # 18	SGRT-3-XX
1 # 16 + 4 # 20	SGRT-3-XX	3 # 16 + 1 # 18 + 1 # 20	SGRT-3-XX	4 # 18 + 1 # 20	SGRT-3-XX
1 # 16 + 5 # 20	SGRT-3-XX	3 # 16 + 1 # 18 + 2 # 20	SGRT-3-XX	4 # 18 + 2 # 20	SGRT-3-XX
1 # 16 + 1 # 18	SGRT-2-XX	3 # 16 + 2 # 18	SGRT-3-XX	5 # 18	SGRT-3-XX
1 # 16 + 1 # 18 + 1 # 20	SGRT-2-XX	3 # 16 + 2 # 18 + 1 # 20	SGRT-3-XX	5 # 18 + 1 # 20	SGRT-3-XX
1 # 16 + 1 # 18 + 2 # 20	SGRT-3-XX	3 # 16 + 3 # 18	SGRT-3-XX	6 # 18	SGRT-3-XX
1 # 16 + 1 # 18 + 3 # 20	SGRT-3-XX	4 # 16	SGRT-3-XX	1 # 20 + 2 # 22	SGRT-2-XX
1 # 16 + 1 # 18 + 4 # 20	SGRT-3-XX	4 # 16 + 1 # 20	SGRT-3-XX	1 # 20 + 3 # 22	SGRT-2-XX
1 # 16 + 2 # 18	SGRT-3-XX	4 # 16 + 2 # 20	SGRT-3-XX	1 # 20 + 4 # 22	SGRT-2-XX
1 # 16 + 2 # 18 + 1 # 20	SGRT-3-XX	4 # 16 + 1 # 18	SGRT-3-XX	2 # 20	SGRT-2-XX
1 # 16 + 2 # 18 + 2 # 20	SGRT-3-XX	4 # 16 + 1 # 18 + 1 # 20	SGRT-3-XX	2 # 20 + 1 # 22	SGRT-2-XX
1 # 16 + 2 # 18 + 3 # 20	SGRT-3-XX	4 # 16 + 2 # 18	SGRT-4-XX	2 # 20 + 2 # 22	SGRT-2-XX
1 # 16 + 3 # 18	SGRT-3-XX	5 # 16	SGRT-3-XX	2 # 20 + 3 # 22	SGRT-2-XX
1 # 16 + 3 # 18 + 1 # 20	SGRT-3-XX	5 # 16 + 1 # 20	SGRT-4-XX	3 # 20	SGRT-2-XX
1 # 16 + 3 # 18 + 2 # 20	SGRT-3-XX	5 # 16 + 1 # 18	SGRT-4-XX	3 # 20 + 1 # 22	SGRT-2-XX
1 # 16 + 4 # 18	SGRT-3-XX	6 # 16	SGRT-4-XX	4 # 20	SGRT-2-XX
1 # 16 + 4 # 18 + 1 # 20	SGRT-3-XX	1 # 18 + 1 # 22	SGRT-2-XX	5 # 20	SGRT-3-XX
1 # 16 + 5 # 18	SGRT-3-XX	1 # 18 + 2 # 22	SGRT-2-XX	6 # 20	SGRT-3-XX
2 # 16	SGRT-2-XX	1 # 18 + 3 # 22	SGRT-2-XX	4 # 22	SGRT-2-XX
2 # 16 + 1 # 20	SGRT-3-XX	1 # 18 + 1 # 20	SGRT-2-XX	5 # 22	SGRT-2-XX
2 # 16 + 2 # 20	SGRT-3-XX	1 # 18 + 1 # 20 + 1 # 22	SGRT-2-XX	6 # 22	SGRT-2-XX
2 # 16 + 3 # 20	SGRT-3-XX	—	—	—	—



Installation Requirements

The SolderGrip product is pushed onto the conductors with a twisting motion. With the product in place, installation can be completed with the proper selection and use of heating tools and reflectors.

Refer to TE installation procedure RPIP-820-01 for detailed instructions and recommended reflector attachments.

Either of the following TE heating tools is recommended:

- HL1920E/HL2020E
- CV-1981

Product Characteristics

Material	
Insulation	Radiation-crosslinked, heat-shrinkable polyvinylidene fluoride (Kynar®)
Solder and flux	Sn60 Pb40 with RA flux
Typical Performance	
Tensile strength	Exceeds strength of individual wires
Temperature rating	-55°C to +150°C [-67°F to +302°F]
Voltage Drop	Not to exceed that of equivalent length of wire by more than 1 mV
Dielectric Withstanding Voltage	Current leakage less than 2 mA (1.5 kV)

Kynar is a trademark of Arkema, Inc.