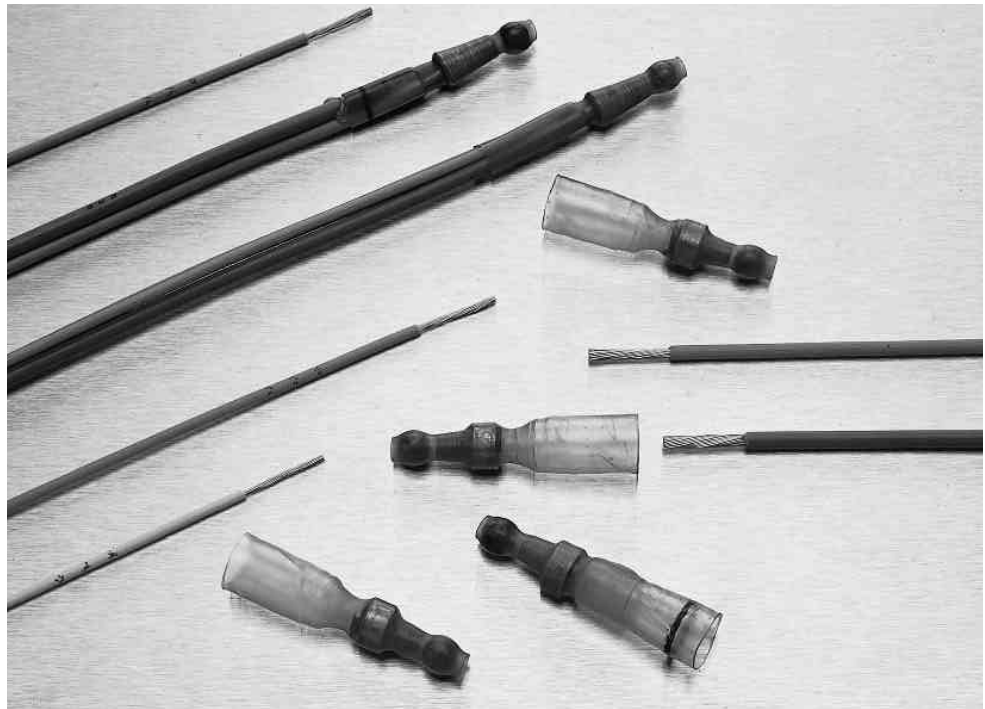


Product Facts

- Soldered connection
- Electrical insulation
- Sealed for immersion (SGRS)
- Excellent strain relief
- Simple installation

SolderGrip Closed End Connector Splices



Applications

SolderGrip heat-shrinkable solder-type closed-end connectors are designed for electrical termination of multiple-wire combinations. They provide a reliable alternative to crimping, welding, or conventional twist-on-style closed-end connectors.

Their unique combination of wire fixturing and controlled-soldering technology provides dependable electrical termination of multiple wire combinations.

SolderGrip terminators consist of a heat-shrinkable thermoplastic sleeve containing a spiral-wound copper insert. The insert is fitted with a prefluxed solder band.

This innovation design allows SolderGrip products to reliably terminate as many as 10 wires of different sizes and types in a single device.

The capability of SolderGrip terminators encompasses single or multistranded, bare or tinned copper wires with low- or high-temperature insulation.

The termination is environmentally protected and strain relieved.

SolderGrip splice terminators are color-coded for easy identification.

Product Options

Product Series	Environmental Protection	Max. Operating Temp.
SGRP	Splashproof	125°C [257°F]
SGRS	Sealed	125°C [257°F]

Available in:

- Americas ■
- Europe ■
- Asia Pacific ■

SolderGrip Closed End Connector Splices (Continued)

Product Selection Process

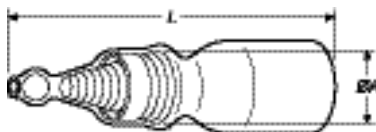
1. From the Product Options table on the previous page, select the product series appropriate for your application.
2. Determine the wire combination (number of wires and size) of the wire bundle you wish to splice.
3. Use Table C (page 8-15) to select the correct connector for AWG wire combinations.*
For mm² wire combinations use Table A to select a SolderGrip part number.

Example: For connecting a bundle with one 12 AWG wire (1 #12) and two 14 AWG wires (+2 #14), you need an SGRP-3 connector. For sealed parts, select the SGRS series.

*If the wire combination is not listed in Table C, use the CMA (mm²) method of determining wire bundle size (see "CMA/mm² Calculation" on page 8-14). Using Table B (page 8-14, select the smallest size connector that will fit your total wire CMA(mm²) value.

4. Verify that the wire bundle (with wire insulation) does not exceed the maximum diameter allowed for the connector you selected. Simply check the bundle's diameter against the maximum diameter that Table A (below) lists for that part.
5. Verify that the total amperage to be applied does not exceed the maximum amp rating for the part as specified in Table A.

Insulated Closed-End Connectors (SGRP series)



Insulated and Sealed Closed-End Connectors (SGRS series)

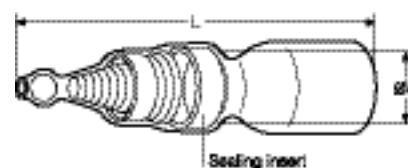


Table A - Product Dimensions and Part Number Descriptions

Part No.	Color Code	Product Dimensions (Min.)			Wire Range (Min.-Max.) CMA/mm ²
		L	ØA		
SGRP-1	Green	1.370 [34.8]	.120 [2.9]		1400 - 4800 [0.7 - 2.4]
SGRP-2	Red	1.350 [34.2]	.150 [3.7]		4000 - 8000 [2.0 - 4.0]
SGRP-3	Blue	1.610 [41.0]	.200 [5.1]		7000 - 18000 [3.5 - 8.0]
SGRP-4	Yellow	1.650 [42.0]	.270 [6.8]		15000 - 30000 [7.5 - 12.0]

Part No.	Color Code	Product Dimensions (Min.)			Wire Range (Min.-Max.) CMA/mm ²
		L	ØA		
SGRS-1	Green	1.370 [34.8]	0.130 [3.4]		1400 - 4800 [0.7 - 2.4]
SGRS-2	Red	1.350 [34.2]	0.190 [4.8]		4000 - 8000 [2.0 - 4.0]
SGRS-3	Blue	1.650 [42.0]	0.290 [7.3]		7000 - 16000 [3.5 - 8.0]
SGRS-4	Yellow	1.630 [41.5]	0.360 [9.1]		15000 - 24000 [7.5 - 12.0]

CMA/mm² Calculation

SolderGrip Closed End Connector Splices (Continued)

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

22 AWG/.38 CMA754	
22 AWG/.38 CMA754	
18 AWG/.95 CMA1900	
16 AWG/1.21 CMA2426	

Total CMA= 5834
Total mm² = 2.92
Correct part number (based on CMA of 5834 or mm² of 2.92): SGRP-2 or SGRS-2

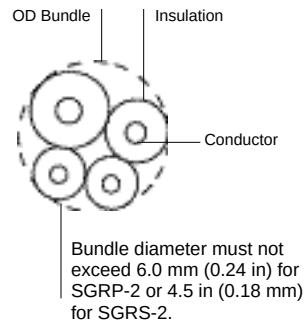


Table B. CMA of Typical Copper Conductors

AWG	30	28	26	24	22	20	18	16	14	12	10	8
CMA	112	177	304	475	754	1216	1900	2426	3831	5874	9354	16983
mm ²	0.05	0.09	0.15	0.24	0.38	0.61	0.95	1.21	1.92	2.94	4.74	8.61

Table C. SolderGrip Wire Combinations

Wire Combinations	Splash-proof	Sealed
1 # 8 + 1 # 12	SGRP-4	SGRS-4
1 # 8 + 1 # 16	SGRP-4	SGRS-4
2 # 8 + 2 # 16	SGRP-4	SGRS-4
1 # 8 + 1 # 14	SGRP-4	SGRS-4
1 # 8 + 1 # 14 + 1 # 16	SGRP-4	SGRS-4
1 # 10 + 1 # 18	SGRP-3	SGRS-3
1 # 10 + 2 # 18	SGRP-3	SGRS-3
1 # 10 + 3 # 18	SGRP-3	SGRS-3
1 # 10 + 1 # 16	SGRP-3	SGRS-3
1 # 10 + 1 # 16 + 1 # 18	SGRP-3	SGRS-3
1 # 10 + 1 # 16 + 2 # 18	SGRP-3	SGRS-3
1 # 10 + 2 # 16	SGRP-3	SGRS-3
1 # 10 + 3 # 16	SGRP-4	SGRS-4
1 # 10 + 4 # 16	SGRP-4	SGRS-4
1 # 10 + 5 # 16	SGRP-4	SGRS-4
1 # 10 + 1 # 14	SGRP-3	SGRS-3
1 # 10 + 1 # 14 + 1 # 18	SGRP-3	SGRS-3
1 # 10 + 1 # 14 + 1 # 16	SGRP-3	SGRS-3
1 # 10 + 1 # 14 + 2 # 16	SGRP-3	SGRS-3
1 # 10 + 1 # 14 + 3 # 16	SGRP-4	SGRS-4
1 # 10 + 2 # 14	SGRP-4	SGRS-4
1 # 10 + 3 # 14	SGRP-4	SGRS-4
1 # 10 + 1 # 12	SGRP-3	SGRS-3
1 # 10 + 1 # 12 + 1 # 14	SGRP-4	SGRS-4
1 # 10 + 2 # 12	SGRP-4	SGRS-4
2 # 10	SGRP-4	SGRS-4
2 # 10 + 1 # 16	SGRP-4	SGRS-4
1 # 12 + 1 # 18	SGRP-2	SGRS-2
1 # 12 + 2 # 18	SGRP-3	SGRS-3
1 # 12 + 3 # 18	SGRP-3	SGRS-3
1 # 12 + 4 # 18	SGRP-3	SGRS-3
1 # 12 + 5 # 18	SGRP-3	SGRS-3
1 # 12 + 1 # 16	SGRP-3	SGRS-3
1 # 12 + 1 # 16 + 1 # 18	SGRP-3	SGRS-3
1 # 12 + 1 # 16 + 2 # 18	SGRP-3	SGRS-3
1 # 12 + 1 # 16 + 3 # 18	SGRP-3	SGRS-3
1 # 12 + 1 # 16 + 4 # 18	SGRP-4	SGRS-4
1 # 12 + 2 # 16	SGRP-3	SGRS-3

Wire Combinations	Splash-proof	Sealed
1 # 14 + 3 # 20	SGRP-2	SGRS-2
1 # 14 + 4 # 20	SGRP-3	SGRS-3
1 # 14 + 1 # 18	SGRP-2	SGRS-2
1 # 14 + 1 # 18 + 1 # 20	SGRP-2	SGRS-2
1 # 14 + 2 # 18	SGRP-2	SGRS-2
1 # 14 + 3 # 18	SGRP-3	SGRS-3
1 # 14 + 4 # 18	SGRP-3	SGRS-3
1 # 14 + 5 # 18	SGRP-3	SGRS-3
1 # 14 + 1 # 16	SGRP-2	SGRS-3
1 # 14 + 1 # 16 + 1 # 20	SGRP-2	SGRS-2
1 # 14 + 1 # 16 + 1 # 18	SGRP-3	SGRS-3
1 # 14 + 1 # 16 + 2 # 18	SGRP-3	SGRS-3
1 # 14 + 1 # 16 + 3 # 18	SGRP-3	SGRS-3
1 # 14 + 1 # 16 + 4 # 18	SGRP-3	SGRS-3
1 # 14 + 2 # 16	SGRP-3	SGRS-3
1 # 14 + 2 # 16 + 1 # 18	SGRP-3	SGRS-3
1 # 14 + 2 # 16 + 2 # 18	SGRP-3	SGRS-3
1 # 14 + 2 # 16 + 3 # 18	SGRP-3	SGRS-3
1 # 14 + 3 # 16	SGRP-3	SGRS-3
1 # 14 + 3 # 16 + 1 # 18	SGRP-3	SGRS-3
1 # 14 + 3 # 16 + 2 # 18	SGRP-3	SGRS-3
1 # 14 + 4 # 16	SGRP-3	SGRS-3
1 # 14 + 4 # 16 + 1 # 18	SGRP-3	SGRS-3
1 # 14 + 5 # 16	SGRP-3	SGRS-3
2 # 14	SGRP-2	SGRS-2
2 # 14 + 1 # 16	SGRP-3	SGRS-3
2 # 14 + 1 # 16	SGRP-3	SGRS-3
2 # 14 + 1 # 16	SGRP-3	SGRS-3
2 # 14 + 1 # 16	SGRP-3	SGRS-3
2 # 14 + 2 # 16	SGRP-3	SGRS-3
2 # 14 + 2 # 16	SGRP-3	SGRS-3
2 # 14 + 3 # 16	SGRP-3	SGRS-3
2 # 14 + 4 # 16	SGRP-4	SGRS-4
3 # 14	SGRP-3	SGRS-3
3 # 14 + 1 # 16	SGRP-3	SGRS-3
3 # 14 + 2 # 16	SGRP-4	SGRS-4
3 # 14 + 3 # 16	SGRP-4	SGRS-4
4 # 14	SGRP-3	SGRS-3

Wire Combinations	Splash-proof	Sealed
2 # 16 + 1 # 18 + 3 # 20	SGRP-3	SGRS-3
2 # 16 + 1 # 18 + 2 # 20	SGRP-3	SGRS-3
2 # 16 + 1 # 18 + 1 # 20	SGRP-2	SGRS-2
2 # 16 + 1 # 18	SGRP-2	SGRS-2
2 # 16 + 4 # 20	SGRP-3	SGRS-3
2 # 16 + 3 # 20	SGRP-3	SGRS-3
2 # 16 + 2 # 20	SGRP-2	SGRS-2
2 # 16 + 1 # 20	SGRP-2	SGRS-2
2 # 16	SGRP-2	SGRS-2
1 # 16 + 5 # 18	SGRP-3	SGRS-3
1 # 16 + 4 # 18 + 1 # 20	SGRP-3	SGRS-3
1 # 16 + 4 # 18	SGRP-3	SGRS-3
1 # 16 + 3 # 18 + 2 # 20	SGRP-3	SGRS-3
1 # 16 + 3 # 18 + 1 # 20	SGRP-3	SGRS-3
1 # 16 + 2 # 18 + 3 # 20	SGRP-3	SGRS-3
1 # 16 + 2 # 18 + 1 # 20	SGRP-2	SGRS-2
1 # 16 + 2 # 18	SGRP-2	SGRS-2
1 # 16 + 1 # 18 + 4 # 20	SGRP-3	SGRS-3
1 # 16 + 1 # 18 + 3 # 20	SGRP-2	SGRS-2
1 # 16 + 1 # 18 + 2 # 20	SGRP-2	SGRS-2
1 # 16 + 1 # 18 + 1 # 20	SGRP-2	SGRS-2
1 # 16 + 1 # 18	SGRP-1	SGRS-1
1 # 16 + 4 # 20	SGRP-2	SGRS-2
1 # 16 + 3 # 20	SGRP-2	SGRS-2
1 # 16 + 1 # 20 + 1 # 22	SGRP-1	SGRS-1
1 # 16 + 1 # 20	SGRP-1	SGRS-1
1 # 16 + 3 # 22	SGRP-1	SGRS-1
1 # 16 + 2 # 22	SGRP-1	SGRS-1
1 # 16 + 1 # 22	SGRP-1	SGRS-1
1 # 18 + 1 # 22	SGRP-1	SGRS-1
1 # 18 + 3 # 22	SGRP-1	SGRS-1
1 # 18 + 1 # 20	SGRP-1	SGRS-1
1 # 18 + 1 # 20 + 1 # 22	SGRP-1	SGRS-1
1 # 18 + 1 # 20 + 2 # 22	SGRP-1	SGRS-1
1 # 18 + 2 # 20	SGRP-1	SGRS-1
1 # 18 + 3 # 20	SGRP-2	SGRS-2
1 # 18 + 4 # 20	SGRP-2	SGRS-2

SolderGrip Closed End Connector Splices (Continued)

Table C. SolderGrip Wire Combinations (Continued)

Wire Combinations	Splash-proof	Sealed
1 # 12 + 2 # 16 + 1 # 18	SGRP-3	SGRS-3
1 # 12 + 2 # 16 + 2 # 18	SGRP-3	SGRS-3
1 # 12 + 3 # 16	SGRP-3	SGRS-3
1 # 12 + 4 # 16	SGRP-3	SGRS-3
1 # 12 + 5 # 16	SGRP-4	SGRS-4
1 # 12 + 1 # 14 + 1 # 18	SGRP-3	SGRS-3
1 # 12 + 1 # 14 + 2 # 18	SGRP-3	SGRS-3
1 # 12 + 1 # 14 + 3 # 18	SGRP-3	SGRS-3
1 # 12 + 1 # 14 + 1 # 16	SGRP-3	SGRS-3
1 # 12 + 1 # 14 + 2 # 16	SGRP-3	SGRS-3
1 # 12 + 1 # 14 + 3 # 16	SGRP-4	SGRS-4
1 # 12 + 1 # 14 + 4 # 16	SGRP-4	SGRS-4
1 # 12 + 2 # 14	SGRP-3	SGRS-3
1 # 12 + 2 # 14 + 1 # 18	SGRP-3	SGRS-3
1 # 12 + 2 # 14 + 1 # 16	SGRP-4	SGRS-4
1 # 12 + 2 # 14 + 2 # 16	SGRP-4	SGRS-4
1 # 12 + 2 # 14 + 3 # 16	SGRP-4	SGRS-4
1 # 12 + 3 # 14	SGRP-4	SGRS-4
1 # 12 + 3 # 14 + 1 # 16	SGRP-4	SGRS-4
1 # 12 + 4 # 14	SGRP-4	SGRS-4
2 # 12	SGRP-4	SGRS-4
2 # 12 + 1 # 18	SGRP-3	SGRS-3
2 # 12 + 1 # 16	SGRP-3	SGRS-3
2 # 12 + 1 # 14	SGRP-3	SGRS-3
2 # 12 + 2 # 16 + 1 # 18	SGRP-4	SGRS-4
2 # 12 + 3 # 16	SGRP-4	SGRS-4
2 # 12 + 1 # 14 + 1 # 18	SGRP-4	SGRS-4
2 # 12 + 1 # 14 + 1 # 16	SGRP-4	SGRS-4
3 # 12 + 1 # 14	SGRP-4	SGRS-4
2 # 12 + 2 # 14	SGRP-4	SGRS-4
3 # 12 + 1 # 18	SGRP-4	SGRS-4
3 # 12 + 1 # 16	SGRP-4	SGRS-4
1 # 14 + 1 # 22	SGRP-1	SGRS-1
1 # 14 + 1 # 20	SGRP-2	SGRS-2
1 # 14 + 2 # 20	SGRP-2	SGRS-2

Wire Combinations	Splash-proof	Sealed
4 # 14 + 1 # 16	SGRP-4	SGRS-4
4 # 14 + 2 # 16	SGRP-4	SGRS-4
5 # 14	SGRP-4	SGRS-4
5 # 14 + 1 # 16	SGRP-4	SGRS-4
1 # 16 + 3 # 18	SGRP-3	SGRS-3
1 # 16 + 2 # 18 + 2 # 20	SGRP-3	SGRS-3
1 # 16 + 5 # 20	SGRP-3	SGRS-3
1 # 16 + 2 # 20	SGRP-2	SGRS-2
6 # 16	SGRP-3	SGRS-3
5 # 16 + 1 # 18	SGRP-3	SGRS-3
5 # 16 + 1 # 20	SGRP-3	SGRS-3
5 # 16	SGRP-3	SGRS-3
4 # 16 + 2 # 18	SGRP-3	SGRS-3
4 # 16 + 1 # 18 + 1 # 20	SGRP-3	SGRS-3
4 # 16 + 1 # 18	SGRP-3	SGRS-3
4 # 16 + 2 # 20	SGRP-3	SGRS-3
4 # 16 + 1 # 20	SGRP-3	SGRS-3
4 # 16	SGRP-3	SGRS-3
3 # 16 + 3 # 18	SGRP-3	SGRS-3
3 # 16 + 2 # 18 + 1 # 20	SGRP-3	SGRS-3
3 # 16 + 2 # 18	SGRP-3	SGRS-3
3 # 16 + 1 # 18 + 2 # 20	SGRP-3	SGRS-3
3 # 16 + 1 # 18 + 1 # 20	SGRP-3	SGRS-3
3 # 16 + 1 # 18	SGRP-3	SGRS-3
3 # 16 + 3 # 20	SGRP-3	SGRS-3
3 # 16 + 2 # 20	SGRP-3	SGRS-3
3 # 16 + 1 # 20	SGRP-3	SGRS-3
3 # 16	SGRP-2	SGRS-2
2 # 16 + 4 # 18	SGRP-3	SGRS-3
2 # 16 + 3 # 18 + 1 # 20	SGRP-3	SGRS-3
2 # 16 + 3 # 18	SGRP-3	SGRS-3
2 # 16 + 2 # 18 + 2 # 20	SGRP-3	SGRS-3
2 # 16 + 2 # 18 + 1 # 20	SGRP-3	SGRS-3
2 # 16 + 2 # 18	SGRP-3	SGRS-3
—	—	—

Wire Combinations	Splash-proof	Sealed
1 # 18 + 5 # 20	SGRP-2	SGRS-2
2 # 18	SGRP-1	SGRS-1
2 # 18 + 1 # 22	SGRP-1	SGRS-1
2 # 18 + 1 # 20	SGRP-2	SGRS-2
2 # 18 + 2 # 20	SGRP-2	SGRS-2
2 # 18 + 3 # 20	SGRP-2	SGRS-2
2 # 18 + 4 # 20	SGRP-3	SGRS-3
3 # 18	SGRP-2	SGRS-2
3 # 18 + 1 # 20	SGRP-2	SGRS-2
3 # 18 + 2 # 20	SGRP-3	SGRS-3
3 # 18 + 3 # 20	SGRP-3	SGRS-3
4 # 18	SGRP-2	SGRS-2
4 # 18 + 1 # 20	SGRP-3	SGRS-3
4 # 18 + 2 # 20	SGRP-3	SGRS-3
5 # 18	SGRP-3	SGRS-3
5 # 18 + 1 # 20	SGRP-3	SGRS-3
6 # 18	SGRP-3	SGRS-3
1 # 20 + 1 # 22	SGRP-1	SGRS-1
1 # 20 + 2 # 22	SGRP-1	SGRS-1
1 # 20 + 3 # 22	SGRP-1	SGRS-1
1 # 20 + 4 # 22	SGRP-1	SGRS-1
2 # 20	SGRP-1	SGRS-1
2 # 20 + 1 # 22	SGRP-1	SGRS-1
2 # 20 + 2 # 22	SGRP-1	SGRS-1
2 # 20 + 3 # 22	SGRP-1	SGRS-1
3 # 20	SGRP-1	SGRS-1
3 # 20 + 1 # 22	SGRP-1	SGRS-1
4 # 20	SGRP-2	SGRS-2
5 # 20	SGRP-2	SGRS-2
6 # 20	SGRP-2	SGRS-2
3 # 22	SGRP-1	SGRS-1
4 # 22	SGRP-1	SGRS-1
5 # 22	SGRP-1	SGRS-1
6 # 22	SGRP-1	SGRS-1
—	—	—

SolderGrip Closed End Connector Splices (Continued)

Product Characteristics

Material			
Insulation	Radiation-crosslinked, transparent heat-shrinkable polyvinylidene fluoride		
Solder preform with flux	Sn 60, Pb 40, ROM1 flux per ANSI-J-STD-004 (RAflux).		
Sealing insert (SGRS)	Hot melt adhesive		
Spiral wound insert	Copper alloy		
Physical	Unit	Method of test	Requirement
Dimensions	inches	RB-109	See product dimensions.
Electromechanical	Unit	Method of test	Typical values
Dielectric withstand voltage	kilovolts	RB-109	2.0
Static heating	degrees	RB-109	Less than 50°C rise
Environmental*	Unit	Method of test	Requirement
Insulation resistance after water immersion (SGRS only)	megohms	RB-109	100
Contact resistance after exposure	milliohms	RB-109	Less than 6 milliohms
Operating condition	Unit	Method of test	Value
Temperature rating	—	—	-55°C to 125°C [-67°F to 257°F]
Voltage rating	volts	—	600

*Immersion resistance sealing is dependent on the wire combinations used. The user should test specific wire combinations. Refer to RB-109 Raychem specification for procedures.

Approvals and Reference Documents

Agency Approvals	UL, CUL E87681
Reference documents	Raychem Specification RB-109 for splices Specification Control Drawings Splices—Non Sealed (SGRP-X), Splices—Sealed (SGRS-X)

Installation

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. Either of the following Raychem heating tools is recommended:

- HL1802E
- CV-1981

Refer to Raychem installation procedure RPIP 820-00 for detailed instructions and recommended reflector attachments.

You will find ordering information for these tools in Section 10.