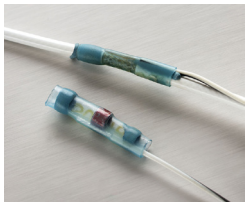
H-ML SERIES (AS83519/2)

SOLDER TERMINATION SLEEVES WITH PRE-INSTALLED 26 AWG LEAD, IMMERSION RESISTANT

PRODUCT FEATURES;



- IMMERSION RESISTANT SOLDER TERMINATION SLEEVE WITH PRE-INSTALLED LEAD WIRE (PER MIL-W-22759/32-26-90); ENVIRONMENT RESISTANT
- SAE AS83519/2 QUALIFIED
- CONTINUOUS OPERATING TEMPERATURE: -55 °C TO +150 °C
- Sn63 SOLDER PREFORM WITH RED THERMOCHROMIC INDICATOR, EUTECTIC AT 183 °C
- NOT ROHS COMPLIANT

BASIC PROPERTIES

- INSULATION SLEEVE : HEAT-SHRINKABLE, RADIATION CROSSLINKED, MODIFIED POLYVINYLIDENE FLUORIDE (TRANSPARENT BLUE)
- MELTABLE SEALING RINGS : THERMALLY STABILIZED THERMOPLASTIC (BLUE)
- SOLDER PREFORM : Sn63 WITH RED THERMOCHROMIC INDICATOR, EUTECTIC AT 183 °C, PER IPC-J-STD-006
- FLUX : ROL1 TYPE RMA FLUX FOR SILVER OR TIN APPLICATIONS, PER IPC-J-STD-004
- PRE-INSTALLED WIRE LEAD : PER MIL-W-22759/32-26-90
- SHRINK RATIO : N/A; SHRINK TEMPERATURE : N/A; FLAMMABILITY : PER AS83519
- ENVIRONMENTAL COMPLIANCE : NOT ROHS COMPLIANT
- INDUSTRY : AEROSPACE, SOLDER TERMINATION
- SPECIFICATIONS / APPROVALS : SAE-AS83519/2

STS DIMENSIONS (INCHES) :

SAE AS83519/2 PART NUMBER	SUMITOMO PART NUMBER	L ±.070	L1 MIN	ØD MIN	ØD1 MIN
M83519/2-1	H-ML-1	.650	.325	.075	.105
M83519/2-2	H-ML-2	.650	.325	.105	.145
M83519/2-3	H-ML-3	.650	.325	.170	.200
M83519/2-4	H-ML-4	.750	.325	.235	.255
M83519/2-5	H-ML-5	.750	.325	.275	.300
M83519/2-6	H-ML-6	.650	.325	.075	.105
M83519/2-7	H-ML-7	.650	.325	.105	.145
M83519/2-8	H-ML-8	.650	.325	.170	.200
M83519/2-9	H-ML-9	.750	.325	.235	.255
M83519/2-10	H-ML-10	.750	.325	.275	.300
M83519/2-11	H-ML-11	.650	.325	.075	.105
M83519/2-12	H-ML-12	.650	.325	.105	.145
M83519/2-13	H-ML-13	.650	.325	.170	.200
M83519/2-14	H-ML-14	.750	.325	.235	.255
M83519/2-15	H-ML-15	.750	.325	.275	.300
AS83519/2-16	H-ML-16	.650	.325	.075	.105
AS83519/2-17	H-ML-17	.650	.325	.105	.145
AS83519/2-18	H-ML-18	.650	.325	.170	.200
AS83519/2-19	H-ML-19	.750	.325	.235	.255
AS83519/2-20	H-ML-20	.750	.325	.275	.300

*For reference use only. PART NUMBERS H-ML-1 TO -15 ARE AS LISTED IN THE PRODUCT OVERVIEW (M83519/2 PREFIX); H-ML-16 TO -20 ARE AS LISTED ON THE DRAWING (AS83519/2 PREFIX).

H-ML SERIES (AS83519/2)

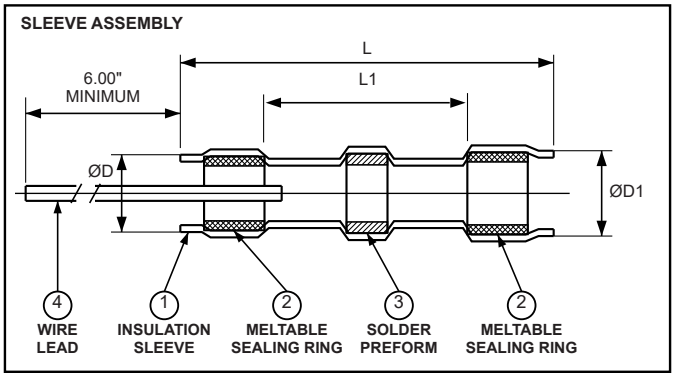
SOLDER TERMINATION SLEEVES WITH PRE-INSTALLED 26 AWG LEAD, IMMERSION RESISTANT

MATERIALS

1. INSULATION SLEEVE	HEAT-SHRINKABLE, RADIATION CROSSLINKED, MODIFIED POLYVINYLIDENE FLUORIDE. COLOR = TRANSPARENT BLUE.
2. MELTABLE SEALING RING	THERMALLY STABILIZED THERMOPLASTIC. COLOR = BLUE.
3. SOLDER PREFORM	ALLOY - Sn63 WITH RED THERMOCHROMIC INDICATOR, EUTECTIC AT 183 °C, PER IPC-J-STD-006. FLUX - ROL1 TYPE RMA FLUX FOR SILVER OR TIN APPLICATIONS, PER IPC-J-STD-004.
4. PRE-INSTALLED WIRE LEAD	PER MIL-W-22759/32-26-90.

APPLICATION NOTES

1. H-ML-16 THROUGH H-ML-20 ARE TESTED AND QUALIFIED TO SAE AS83519/2 STANDARDS AND ARE LISTED ON THE QPL (CLASS I), PER THE DRAWING.
2. PLEASE REFER TO THE SUMITOMO ELECTRIC STS INSTALLATION GUIDE FOR RECOMMENDED ASSEMBLY INFORMATION.
3. TEMPERATURE RANGE: -55 °C TO +150 °C.



SLEEVE PROFILE ILLUSTRATIVE. H-ML-X (1-20) SAE AS83519/2, REV. B.

ORDERING INFORMATION

SUMITOMO PART NUMBERS	H-ML-1 THROUGH H-ML-20
SAE PART NUMBERS	M83519/2-1 THROUGH M83519/2-15; AS83519/2-16 THROUGH AS83519/2-20
MARKING CODES (1-20)	S0201S THROUGH S0220S

SUMITOMO ELECTRIC INTERCONNECT PRODUCTS, INC.

915 ARMORLITE DR. SAN MARCOS, CA 92069

760-761-0600 **info@SEIPUSA.COM**

SUMITOMO ELECTRIC GROUP

DIMENSIONS ARE SHOWN FOR REFERENCE PURPOSES AND SUBJECT TO CHANGE WITHOUT NOTICE.

2026/10