

**THIS PRODUCT MANUFACTURED
WITH LEAD-FREE PROCESSING**

DO NOT
SCALE FROM
THIS PRINT

ACP-12-XX-X-XX.XX-X-XX-O-X

LEAD STYLE
 -01: 4 POS (1.0 TERM/SKT), 24 AWG
 -02: 5 POS (1.0 TERM/SKT), 24 AWG
 -03: 6 POS (0.5 TERM/SKT), 28 AWG
 -04: 8 POS (0.5 TERM/SKT), 28 AWG
 -05: 6 POS COMBO (2x1.0 TERM/SKT), 24 AWG (4x0.5 TERM/SKT), 28 AWG

PLATING
 -G: 10µ" GOLD IN CONTACT AREA
 -H: 30µ" GOLD IN CONTACT AREA

ASSEMBLED LENGTH
 XX.XX (IN METERS)
 (00.25 METER MIN TO 50.00 METER MAX)

KEYING FEATURE (SEE NOTE 5) (SEE SHEET 2)
 -1: ORANGE
 -2: GREEN
 -3: BLUE
 -4: YELLOW

STYLE
 -O: OVERMOLDED PLASTIC

END 2
 -T: TERMINAL
 -S: SOCKET
 -BC: BLUNT CUT

END 1
 -T: TERMINAL
 -S: SOCKET (NOT AVAILABLE WITH END 2 -T)

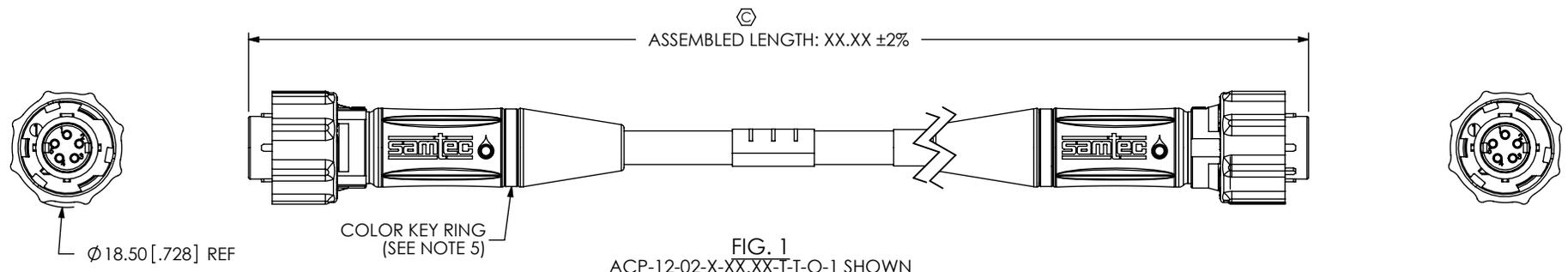
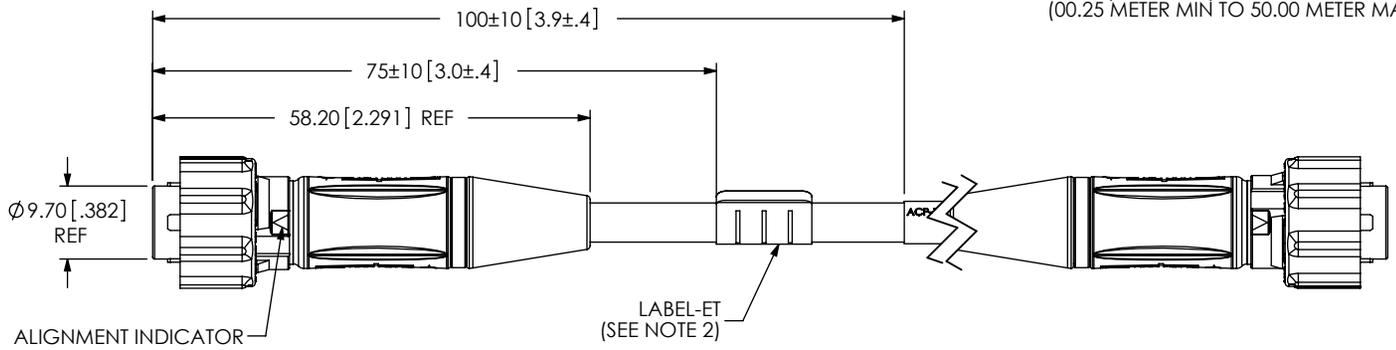


FIG. 1
ACP-12-02-X-XX.XX-T-T-O-1 SHOWN

NOTES:

- ⊕ REPRESENTS A CRITICAL DIMENSION.
- ⊕ ASSEMBLY TO BE 100% TESTED FOR CONTINUITY, ISOLATION, & HI-POT AT 300V. (1) LABEL-ET TO BE APPLIED AFTER FINAL ELECTRICAL TEST.
- SAMTEC LOGO SHALL APPEAR AT TWO EQUALLY SPACED LOCATIONS ON SURFACE SHOWN, APPROXIMATELY 16.33[.643] x 3.96[.156] x 0.20[.008] DEEP.
- ASSEMBLIES TO BE BULK PACKAGED.
- KEYING FEATURE DETERMINES COLOR OF KEY RING AND DUSTCAP LANYARD IF APPLICABLE.
- SIGNAL MAPPING IS: 1 TO 1, 2 TO 2, 3 TO 3, etc..
- REFER TO DCA-ACP-12-P-X PRINT FOR DUST CAP.
- PLACE HDRL-11 (LABEL) ON CABLE WHERE SHOWN. LABEL TO CONTAIN:
 LINE 1 - PART NUMBER "ACP-12-XX-X-XX.XX-X-XX-O-X"
 LINE 2 - SHOP ORDER NUMBER "XXXXXX"
 LINE 3 - DATE CODE "XXXXXX"
- ⊕ ASSEMBLY TO BE 100% TESTED FOR CONTINUITY, ISOLATION, & HI-POT AT 300V BEFORE OVERMOLDING.
 10. ORIENTATION OF END 1 AND END 2 MAY VARY.
 11. PARTS TO BE BUILT & INSPECTED TO IPC-A-620 CLASS 2.

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UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN MILLIMETERS. TOLERANCES ARE:
 DECIMALS ANGLES
 X.X: ±0.3 [.01] 2°
 X.XX: ±0.13 [.005]
 X.XXX: ±0.051 [.0020]

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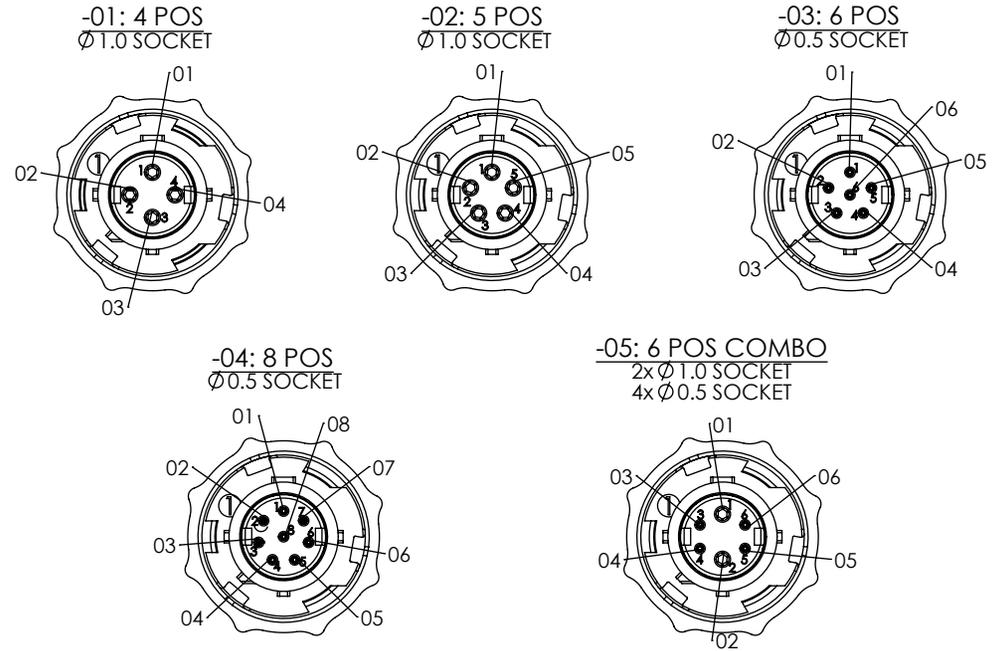
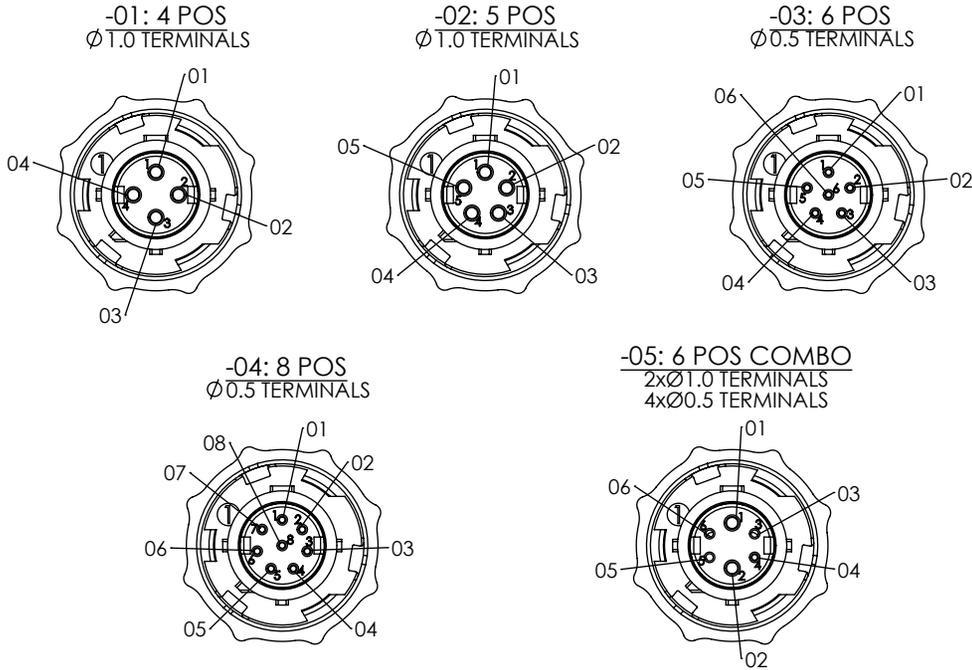
samtec
 520 PARK EAST BLVD, NEW ALBANY, IN 47150
 PHONE: 812-944-6733 FAX: 812-948-5047
 e-Mail: info@SAMTEC.com code 53322

MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 1:1
 SHELL/LOCKING SLEEVE: NYLON, COLOR: BLACK
 INSULATOR: PBT, COLOR: BLACK
 OVERMOLD: MD-NYL-ZY-70G13-BK
 PREMOLD: MD-NYL-MA-OM646-BK
 TERMINALS: BRASS
 CONTACTS: BRASS/BeCu
 MAX FLASH ALLOWED: 0.05 [.002]
 MAX GATE VESTIGE: 0.05 [.002]

DESCRIPTION:
ACCLIMATE CIRC. CABLE ASSEMBLY
 DWG. NO.
ACP-12-XX-X-XX.XX-X-XX-O-X
 BY: D.SCHMELZ 09/17/2010 SHEET 1 OF 5

-T END OPTIONS

-S END OPTIONS



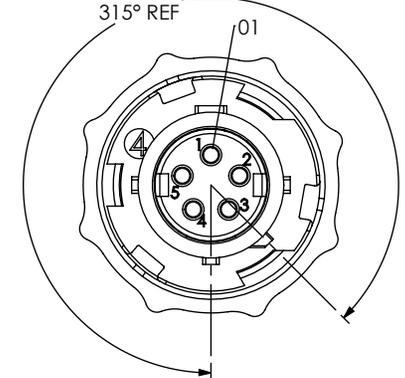
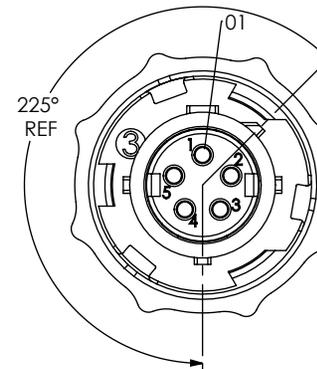
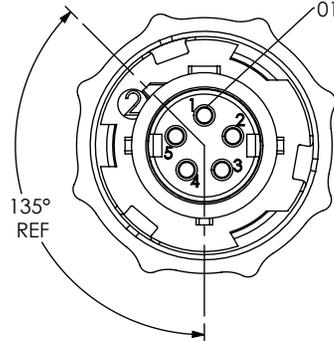
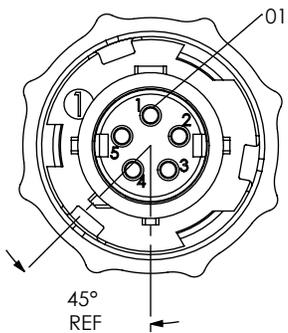
-1
ORANGE KEY RING

-2
GREEN KEY RING

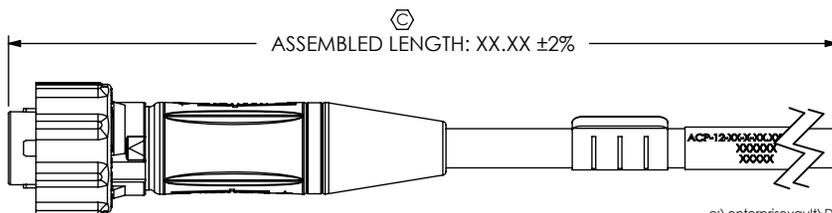
KEYING FEATURE
(SEE NOTE 5)

-3
BLUE KEY RING

-4
YELLOW KEY RING



-BC END OPTION
ACP-12-0T-X-XX.XX-T-BC-O-T SHOWN



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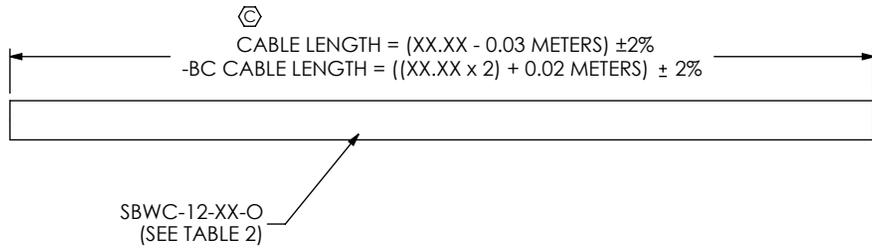
520 PARK EAST BLVD, NEW ALBANY, IN 47150
PHONE: 812-944-6733 FAX: 812-948-5047
e-Mail info@SAMTEC.com code 55322

DESCRIPTION: ACCLIMATE CIRC. CABLE ASSEMBLY

DWG. NO. ACP-12-XX-X-XX.XX-X-XX-O-X

BY: D.SHMELZ 09/17/2010 SHEET 2 OF 5

IN-PROCESS 1
CUT SBWC-12-XX-O TO LENGTH



IN-PROCESS 2
FEED SBWC-12-XX-O BUNDLED CABLE THROUGH
ACCR-12-X, ACCLS-12-P, & ACCOS-12-P-X

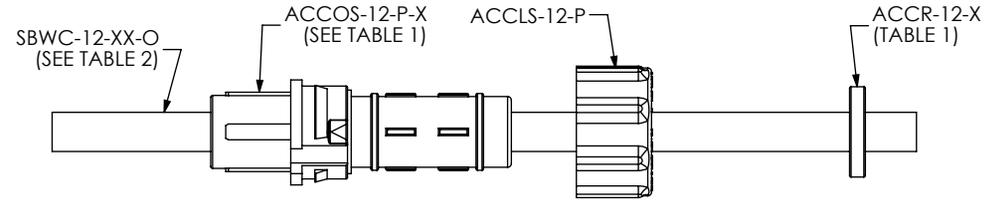


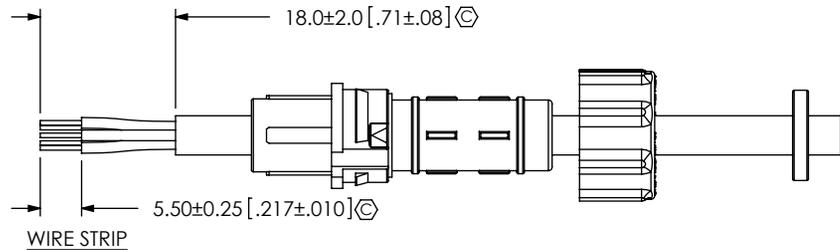
TABLE 1

KEYING FEATURE	SHELL PART #	ACCR-12-X
-1	ACCOS-12-P-1	ACCR-12-1
-2	ACCOS-12-P-2	ACCR-12-2
-3	ACCOS-12-P-3	ACCR-12-3
-4	ACCOS-12-P-4	ACCR-12-4

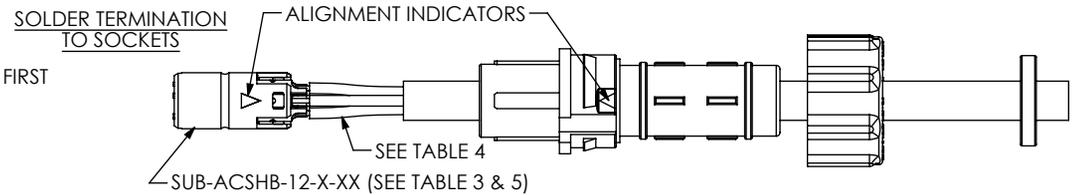
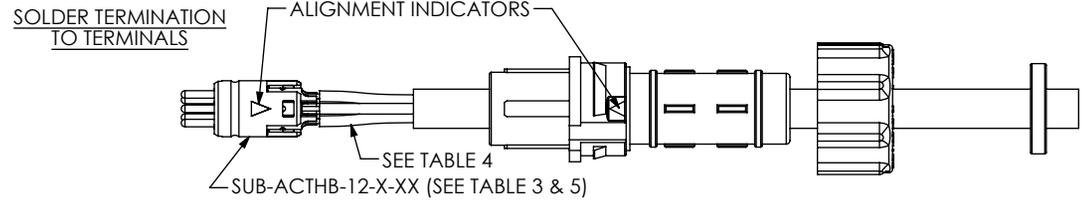
TABLE 2

LEAD STYLES	SBWC PART #
-01	SBWC-12-01-O
-02	SBWC-12-02-O
-03	SBWC-12-03-O
-04	SBWC-12-04-O
-05	SBWC-12-05-O

IN-PROCESS 3
STRIP OUTER JACKET & INNER WIRES
TO DIMENSIONS SHOWN



IN-PROCESS 4
TERMINATE WIRES TO TERMINALS/SOCKETS
(SEE NOTE 6)



ON LEADSTYLES -03 & -04
SOLDER INNER PIN/SOCKET FIRST
AND THEN OUTER RING

TABLE 5

PLATING	SUB-ACXHB-12-X-XX
-G	SUB-ACXHB-12-G-XX
-H	SUB-ACXHB-12-H-XX

TABLE 3

LEAD STYLE	END1/END 2	SUB-ACXHB-12-X-XX
-01	-T	SUB-ACTHB-12-X-01
-02	-T	SUB-ACTHB-12-X-02
-03	-T	SUB-ACTHB-12-X-03
-04	-T	SUB-ACTHB-12-X-04
-05	-T	SUB-ACTHB-12-X-05
-01	-S	SUB-ACSHB-12-X-01
-02	-S	SUB-ACSHB-12-X-02
-03	-S	SUB-ACSHB-12-X-03
-04	-S	SUB-ACSHB-12-X-04
-05	-S	SUB-ACSHB-12-X-05

TABLE 4

WIRE COLOR					
POSITION	LEAD STYLE				
	-01	-02	-03	-04	-05
01	BROWN	BROWN	BROWN	BROWN	BROWN
02	RED	RED	RED	RED	RED
03	ORANGE	ORANGE	ORANGE	ORANGE	ORANGE
04	YELLOW	YELLOW	YELLOW	YELLOW	YELLOW
05		GREEN	GREEN	GREEN	GREEN
06			BLUE	BLUE	BLUE
07				VIOLET	
08				GRAY	

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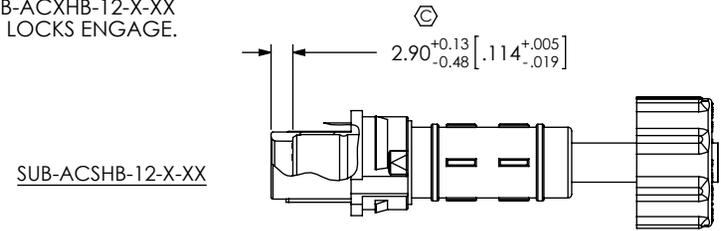
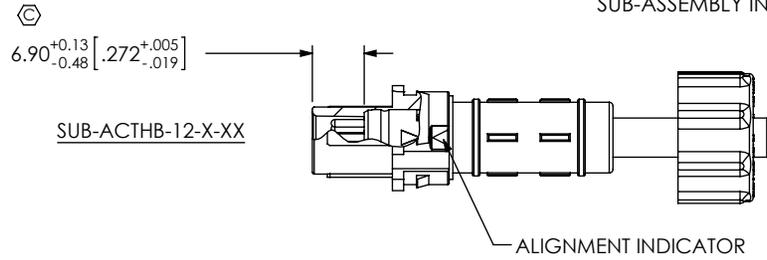
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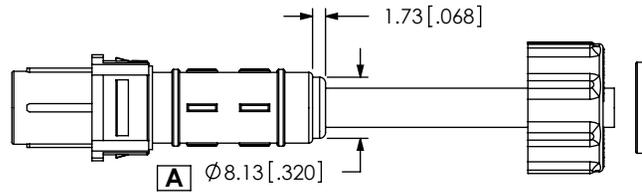
DWG. NO.
ACP-12-XX-X-XX.XX-X-XX-O-X

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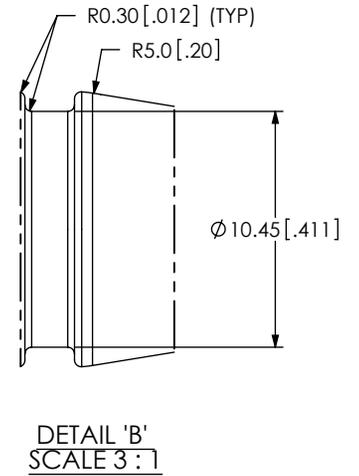
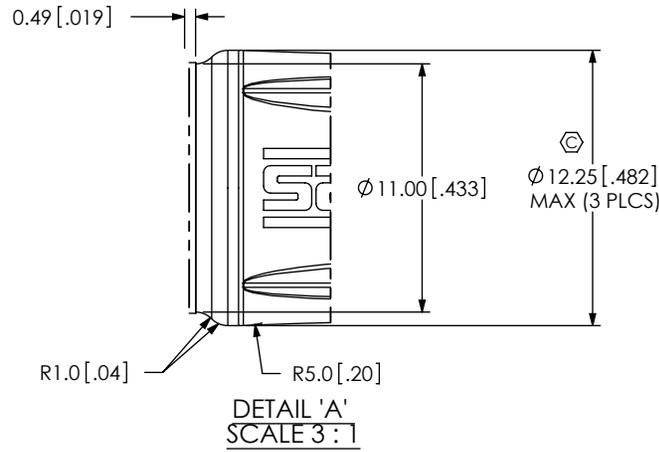
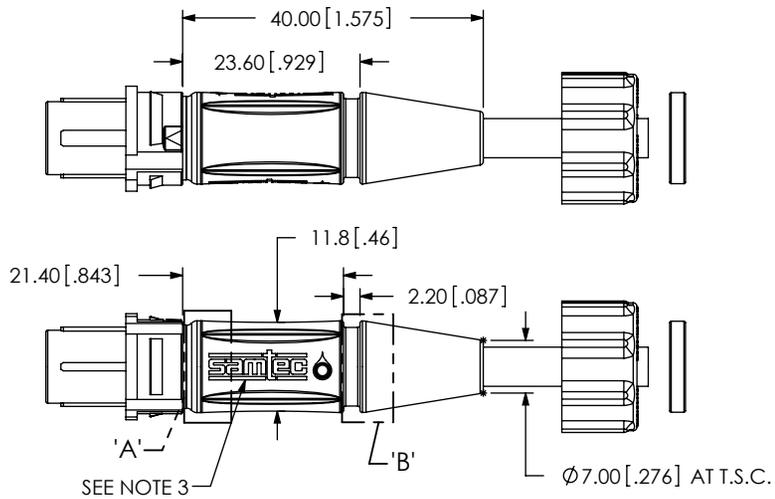
IN-PROCESS 5
 WHILE MAKING SURE ALIGNMENT ARROWS LINE UP TO AID POLARIZATION BEAM ENGAGEMENT, INSERT SUB-ACXHB-12-X-XX SUB-ASSEMBLY INTO ACCOS-12-P-X UNTIL SNAP LOCKS ENGAGE. (SEE NOTE 9)



IN-PROCESS 6
 PREMOLD



IN-PROCESS 7
 APPLY OVERMOLD GRIP



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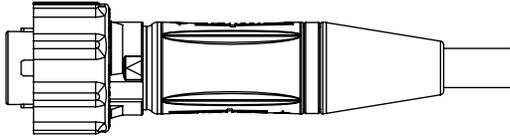
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 ACP-12-XX-X-XX.XX-X-XX-O-X

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REVISION A

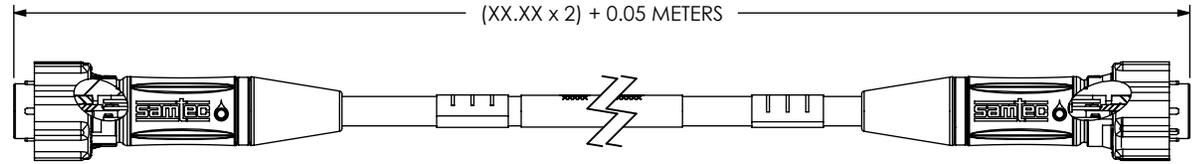
IN-PROCESS 8

PUSH ACCLS-12-L OVER OVERMOLD
AND ACCOS-12-P-X UNTIL IT SNAPS.
STRETCH ACCR-12-X OVER OVERMOLD
UNTIL IT SEATS IN GROOVE.



IN-PROCESS 9

(-BC END OPTION ONLY)
BUILD DOUBLE-ENDED INITIALLY FOR E-TEST,
APPLY LABEL-ET & HDRL-11 TO BOTH ENDS,
AND CUT CABLE IN HALF



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