

Pb THIS PRODUCT MANUFACTURED
WITH LEAD-FREE PROCESSING

DO NOT
SCALE FROM
THIS PRINT

- PLUG SIZE**
- LEAD STYLE**
- 01: 14 POS (0.5 TERM/SKT), 28 AWG
 - 02: 10 POS (1.0 TERM/SKT), 24 AWG
 - 03: 4 POS PWR (1.5 TERM/SKT), 16 AWG
 - 04: 4 POS COMBO
(2 X COAX PLUG/JACK), COAX
(2 X 1.0 TERM/SKT), 24 AWG
 - 05: 4 POS COMBO
(3 X 1.5 TERM/SKT), 16 AWG
(1 X COAX PLUG/JACK), COAX
 - 06: 10 POS COMBO
(2 X 1.5 TERM/SKT), 16 AWG
(8 X 0.5 TERM/SKT), 28 AWG
 - 07: 7 POS COMBO
(1 X COAX PLUG/JACK), COAX
(6 X 1.0 TERM/SKT), 24 AWG
- KEYING FEATURE**
(SEE NOTE 4) (SEE SHEET 4)
- 1: ORANGE
 - 2: GREEN
 - 3: BLUE
 - 4: YELLOW
- METAL**
- END 2**
- T: TERMINAL
 - S: SOCKET
 - BC: BLUNT CUT
- END 1**
- T: TERMINAL
 - S: SOCKET (NOT AVAILABLE WITH END 2 -T)
- ASSEMBLED LENGTH**
XX.XX (IN METERS)
(0.25 METER MIN TO 50.00 METER MAX)
(1.00 METER MIN FOR -04, -05, & -07 LEAD STYLES CONTAINING COAX)
- PLATING**
(SEE NOTE 9)
- G: 10u GOLD IN CONTACT AREA
 - H: 30u GOLD IN CONTACT AREA

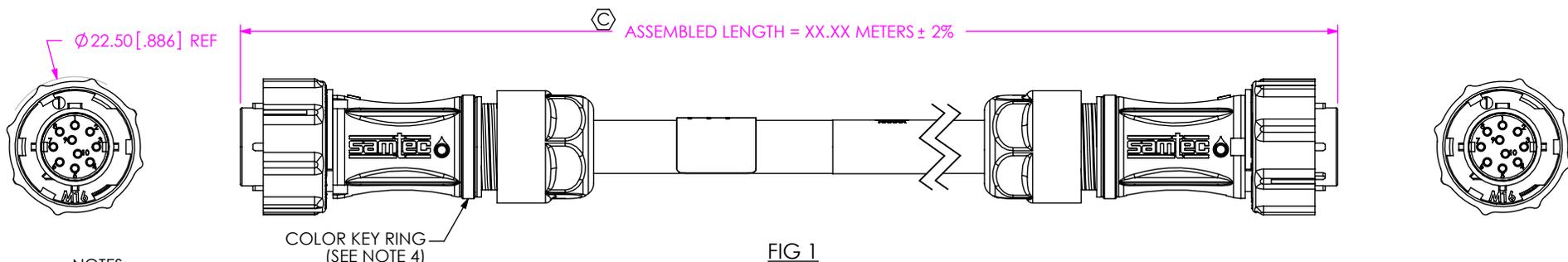
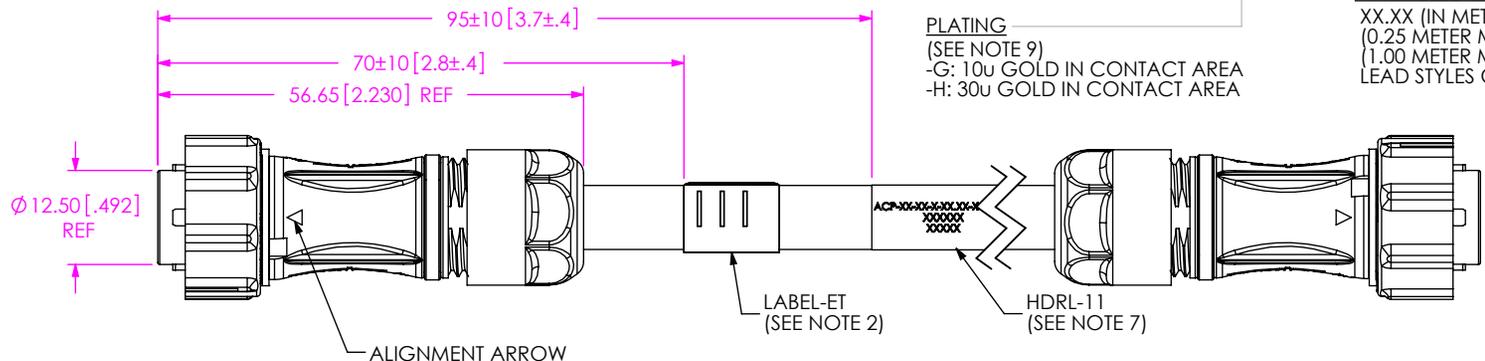
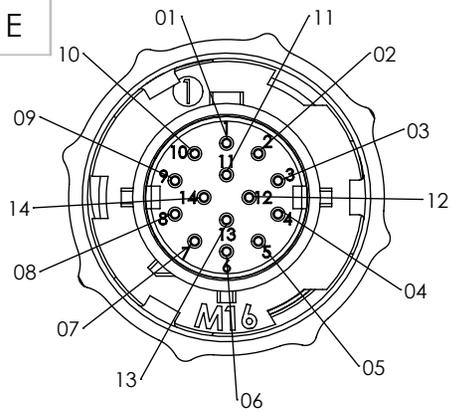


FIG 1
ACP-16-02-X-XX.XX-T-T-M-1 SHOWN

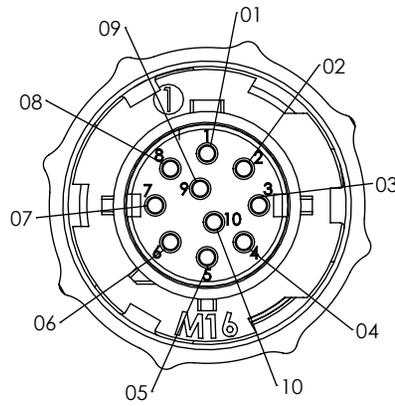
NOTES:

1. Ⓢ REPRESENTS A CRITICAL DIMENSION.
2. ASSEMBLY TO BE 100% TESTED FOR CONTINUITY, ISOLATION, & HI-POT AT 300V.
(1) LABEL-ET TO BE APPLIED AFTER FINAL ELECTRICAL TEST.
3. ASSEMBLIES TO BE BULK PACKAGED.
4. KEYING FEATURE (SEE SHEET 4) DETERMINES COLOR OF KEY RING AND DUSTCAP LANYARD IF APPLICABLE.
5. SIGNAL MAPPING IS 1 TO 1, 2 TO 2, 3 TO 3, etc..
6. REFER TO DCA-ACP-16-M-X PRINT FOR DUST CAP.
7. PLACE HDRL-11 (LABEL) ON CABLE WHERE SHOWN. LABEL TO CONTAIN
LINE 1 - PART NUMBER "ACP-16-XX-X-XX.XX-X-XX-M-X"
LINE 2 - SHOP ORDER NUMBER "XXXXXX"
LINE 3 - DATE CODE "XXXXX"
8. NOTE DELETED.
9. PLATING CALLOUTS APPLY TO TERMINALS & SOCKETS ONLY. COAX PLUGS/JACKS HAVE -H PLATING ON INNER TERMINALS/SOCKETS & -F PLATING ON OUTER SHELLS.
10. MINIMUM BEND RADIUS FOR INDIVIDUAL LINES OF COAX CABLE IS 25.4[1.00].

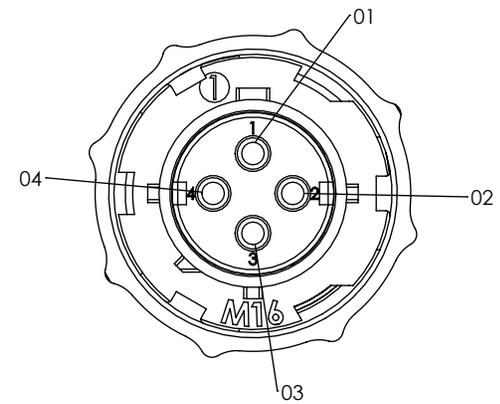
<p>UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN MILLIMETERS.</p> <p>TOLERANCES ARE:</p> <table border="0"> <tr> <td>DECIMALS</td> <td>ANGLES</td> </tr> <tr> <td>X.X: ±0.3 [01]</td> <td>2°</td> </tr> <tr> <td>X.XX: ±0.13 [005]</td> <td></td> </tr> <tr> <td>X.XXX: ±0.051 [0020]</td> <td></td> </tr> </table>	DECIMALS	ANGLES	X.X: ±0.3 [01]	2°	X.XX: ±0.13 [005]		X.XXX: ±0.051 [0020]		<p>PROPRIETARY NOTE</p> <p>THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION AND ALL DESIGN, MANUFACTURING, REPRODUCTION, USE, PATENT RIGHTS AND SALES RIGHTS ARE EXPRESSLY RESERVED BY SAMTEC, INC. THIS DOCUMENT SHALL NOT BE DISCLOSED, IN WHOLE OR PART, TO ANY UNAUTHORIZED PERSON OR ENTITY NOR REPRODUCED, TRANSFERRED OR INCORPORATED IN ANY OTHER PROJECT IN ANY MANNER WITHOUT THE EXPRESS WRITTEN CONSENT OF SAMTEC, INC.</p>	<p>samtec</p> <p>520 PARK EAST BLVD, NEW ALBANY, IN 47150 PHONE: 812-944-6733 FAX: 812-948-5047 e-Mail: info@SAMTEC.com code 53322</p>
	DECIMALS	ANGLES								
X.X: ±0.3 [01]	2°									
X.XX: ±0.13 [005]										
X.XXX: ±0.051 [0020]										
<p>MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 1:1</p> <p>SHELLS: ZINK ALLOY INSULATOR: PBT TERMINALS: BRASS CONTACTS: BRASS/BeCu</p>	<p>DESCRIPTION: ACCLIMATE CIRC. CABLE ASSEMBLY</p> <p>DWG. NO. ACP-16-XX-X-XX.XX-X-XX-M-X</p> <p>BY: D.SCHMELZ 04/30/2010 SHEET 1 OF 7</p>									



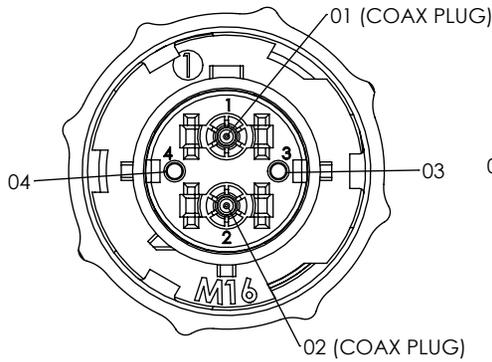
-01: 14 POS
($\varnothing 0.5$ TERMINALS)



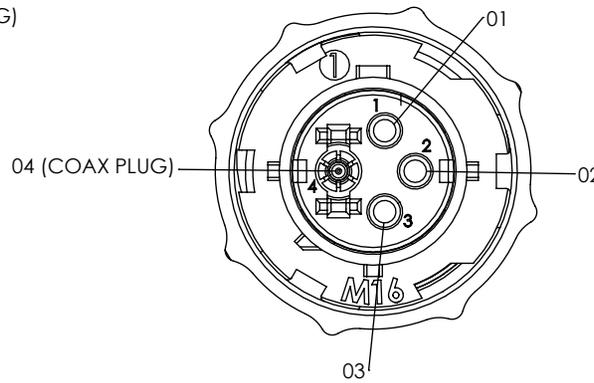
-02: 10 POS
($\varnothing 1.0$ TERMINALS)



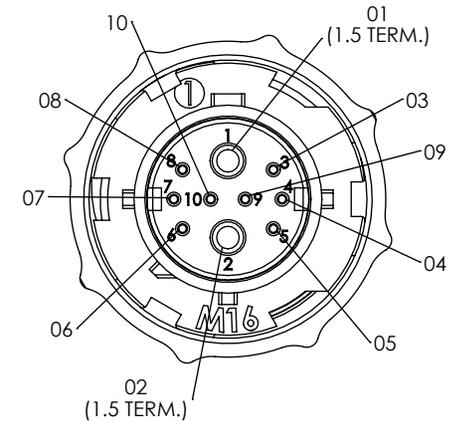
-03: 4 POS
($\varnothing 1.5$ TERMINALS)



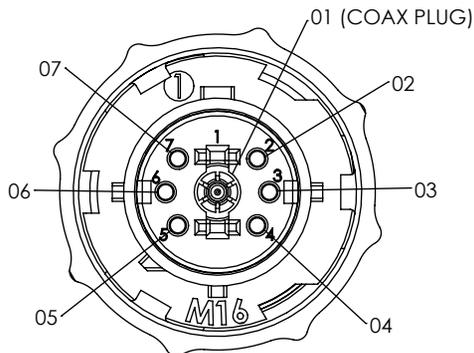
-04: 4 POS COMBO
(2 X COAX PLUGS)
(2 X $\varnothing 1.0$ TERMINALS)



-05: 4 POS COMBO
(3 X $\varnothing 1.5$ TERMINALS)
(1 X COAX PLUG)



-06: 10 POS COMBO
(2 X $\varnothing 1.5$ TERMINALS)
(8 X $\varnothing 0.5$ TERMINALS)



-07: 7 POS COMBO
(1 X COAX PLUG)
(6 X $\varnothing 1.0$ TERMINALS)

-T END OPTIONS

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SHEET SCALE: 1.5:1

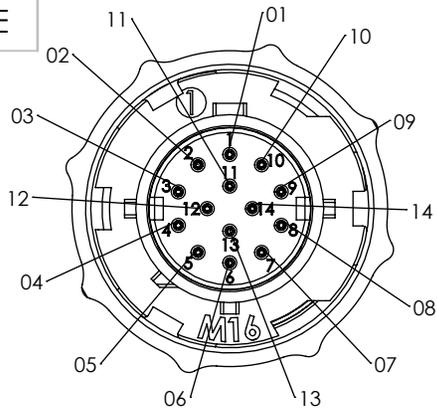


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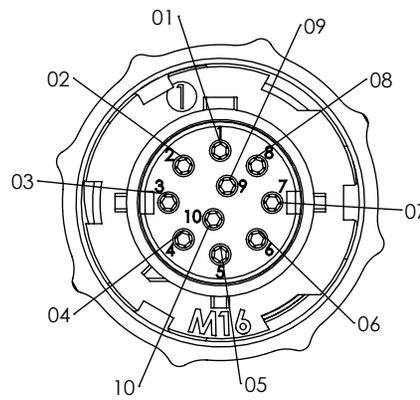
DESCRIPTION: **ACCLIMATE CIRC. CABLE ASSEMBLY**

DWG. NO. **ACP-16-XX-X-XX.XX-X-XX-M-X**

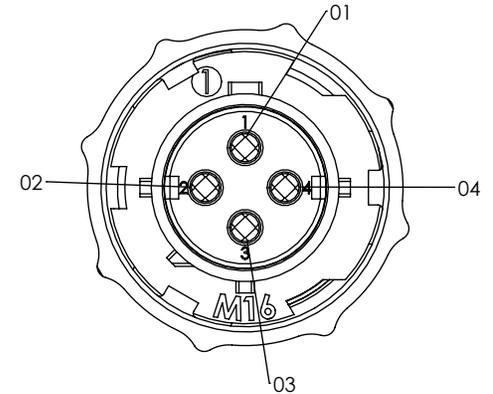
BY: D.SCHMELZ 04/30/2010 SHEET 2 OF 7



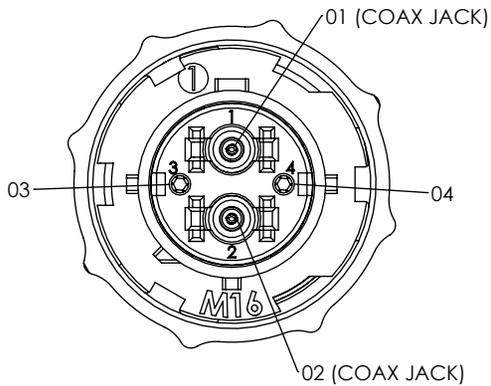
-01: 14 POS
($\varnothing 0.5$ SOCKETS)



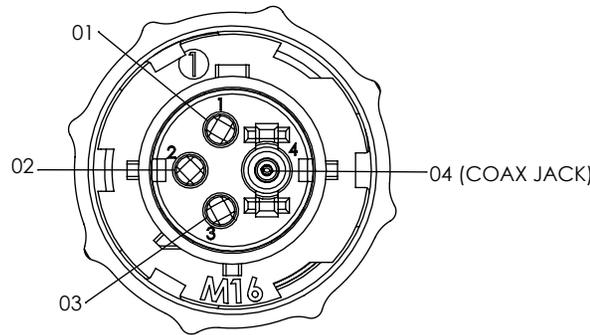
-02: 10 POS
($\varnothing 1.0$ SOCKETS)



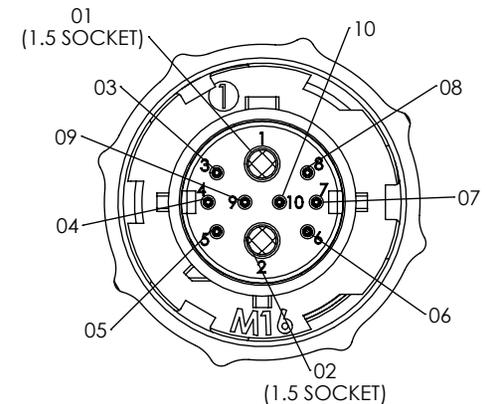
-03: 4 POS
($\varnothing 1.5$ SOCKETS)



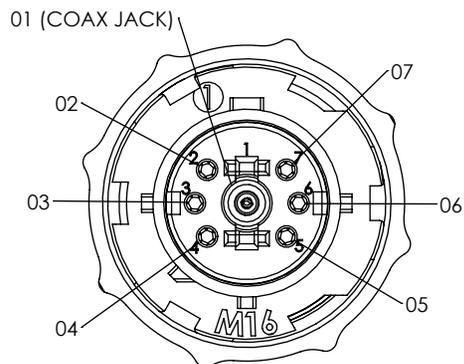
-04: 4 POS COMBO
(2 COAX JACKS)
(2 X $\varnothing 1.0$ SOCKETS)



-05: 4 POS COMBO
(3 X $\varnothing 1.5$ SOCKETS)
(1 X COAX JACK)



-06: 10 POS COMBO
(2 X $\varnothing 1.5$ SOCKETS)
(8 X $\varnothing 0.5$ SOCKETS)



-07: 7 POS COMBO
(1 X COAX JACK)
(6 X $\varnothing 1.0$ SOCKETS)

-S END OPTIONS

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SHEET SCALE: 1.5:1

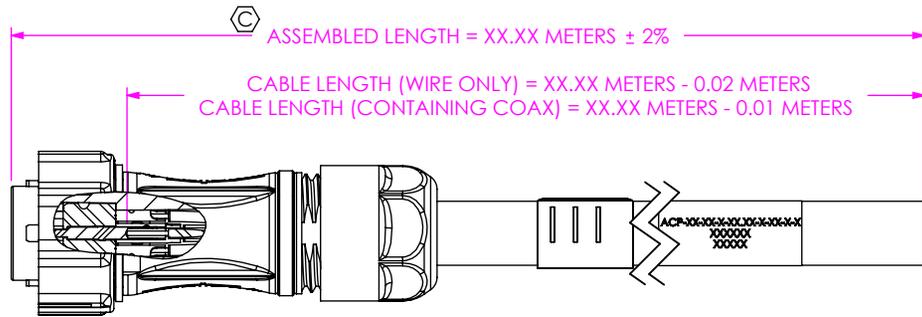


520 PARK EAST BLVD, NEW ALBANY, IN 47150
PHONE: 812-944-6733 FAX: 812-948-5047
e-Mail info@SAMTEC.com code 55322

DESCRIPTION: ACCLIMATE CIRC. CABLE ASSEMBLY

DWG. NO. ACP-16-XX-X-XX.XX-X-XX-M-X

BY: D.SCHMELZ 04/30/2010 SHEET 3 OF 7



-BC END OPTION
ACP-16-02-X-XX.XX-T-BC-M-1 SHOWN

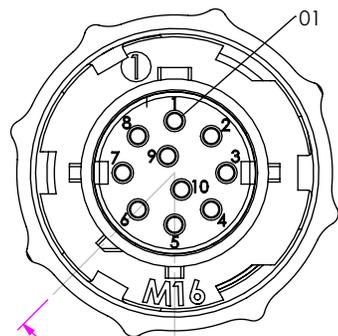
⊕ CABLE LENGTH (WIRE ONLY) = (XX.XX METERS - 0.03 METERS) ± 2%
 CABLE LENGTH (CONTAINING COAX) = (XX.XX METERS - 0.02 METERS) ± 2%
 -BC CABLE LENGTH (WIRE ONLY) = ((XX.XX METERS X 2) + 0.02 METERS) ± 2%
 -BC CABLE LENGTH (CONTAINING COAX) = ((XX.XX METERS X 2) + 0.03 METERS) ± 2%



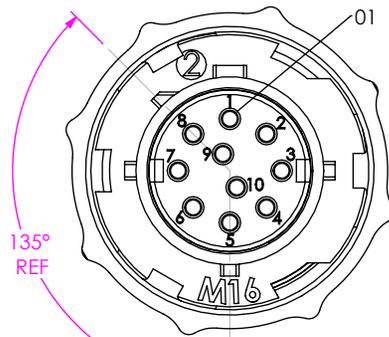
IN-PROCESS 1
CUT SBWC CABLE TO LENGTH SHOWN

LEAD STYLES	SBWC PART #
-01	SBWC-16-01-O
-02	SBWC-16-02-O
-03	SBWC-16-03-O
-04	SBWC-16-04-O
-05	SBWC-16-05-O
-06	SBWC-16-06-O
-07	SBWC-16-07-O

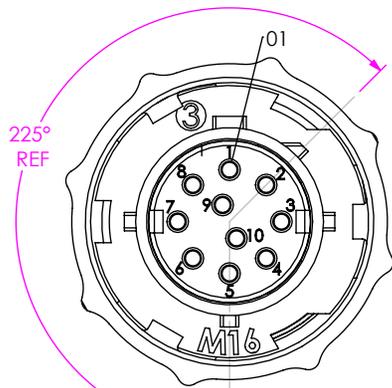
KEYING FEATURE	ACCFs-16-M-X	ACCR-16-X
-1	ACCFs-16-M-1	ACCR-16-1
-2	ACCFs-16-M-2	ACCR-16-2
-3	ACCFs-16-M-3	ACCR-16-3
-4	ACCFs-16-M-4	ACCR-16-4



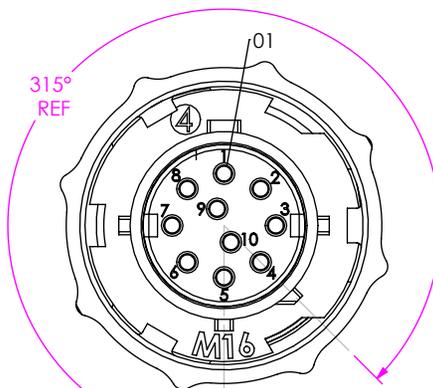
-1 (ORANGE KEY RING)



-2 (GREEN KEY RING)

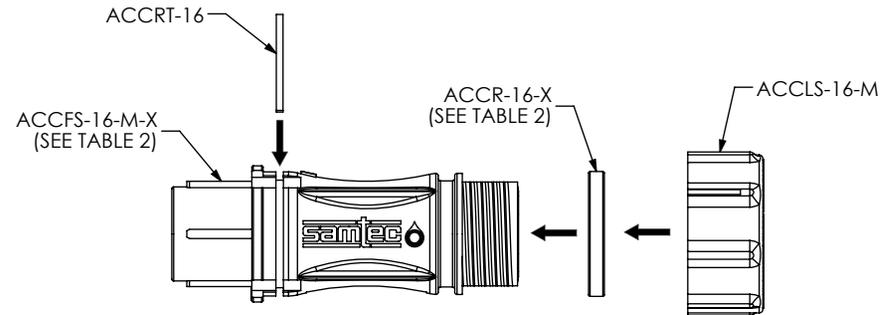


-3 (BLUE KEY RING)



-4 (YELLOW KEY RING)

KEYING FEATURE
(SEE NOTE 4)



IN-PROCESS 2
STRETCH ACCR-16-X OVER ACCFS-16-M-X UNTIL IT SEATS IN GROOVE
 PUSH ACCLS-16-M ONTO ACCFS-16-M-X UNTIL IT BOTTOMS OUT AGAINST
 FLANGE. SNAP ACCRT-16 (RETAINING RING) INTO GROOVE IN
 ACCFS-16-M-X TO HOLD ACCLS-16-M IN PLACE

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SHEET SCALE: 1:1

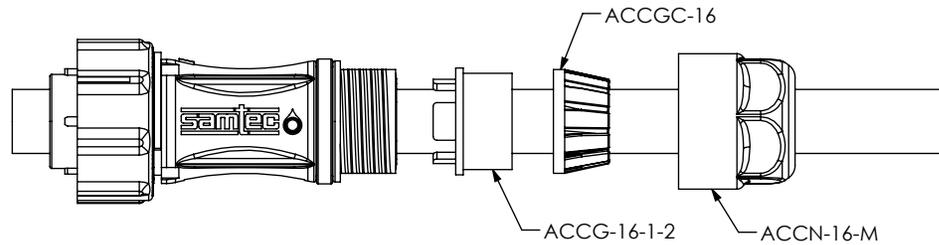


520 PARK EAST BLVD, NEW ALBANY, IN 47150
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 e-Mail info@SAMTEC.com code 55322

DESCRIPTION:
ACCLIMATE CIRC. CABLE ASSEMBLY

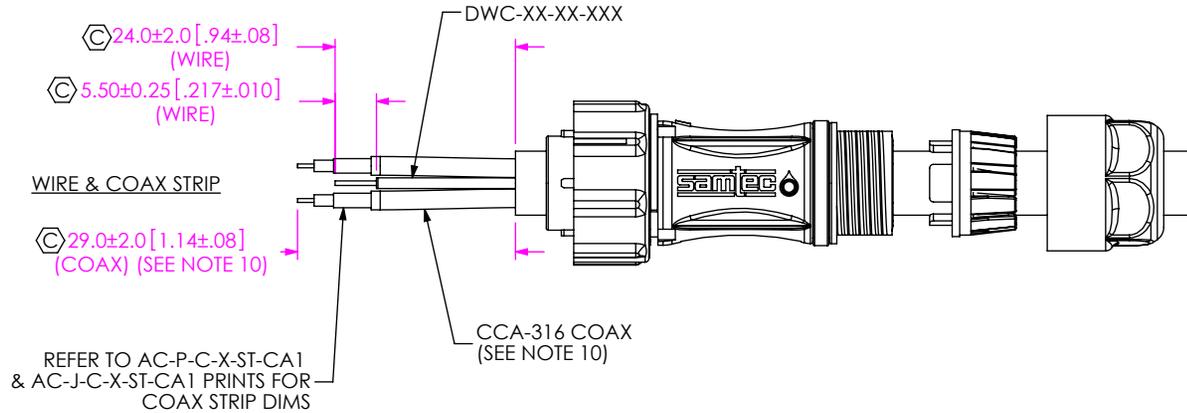
DWG. NO.
ACP-16-XX-X-XX.XX-X-XX-M-X

BY: D.SCHMELZ 04/30/2010 SHEET 4 OF 7



IN-PROCESS 3

FEED SBWC-16-XX-O BUNDLED CABLE THROUGH ACCN-16-M, ACCGC-16, ACCG-16-1-2, & ACCFS-16-M-X)



IN-PROCESS 4

STRIP OUTER JACKET & INNER WIRES/COAX TO DIMENSIONS SHOWN & TIN INNER CONDUCTORS. PUSH ACCGC-16 ONTO ACCG-16-1-2 UNTIL IT BOTTOMS OUT AGAINST FLANGE ON ACCG-16-1-2.

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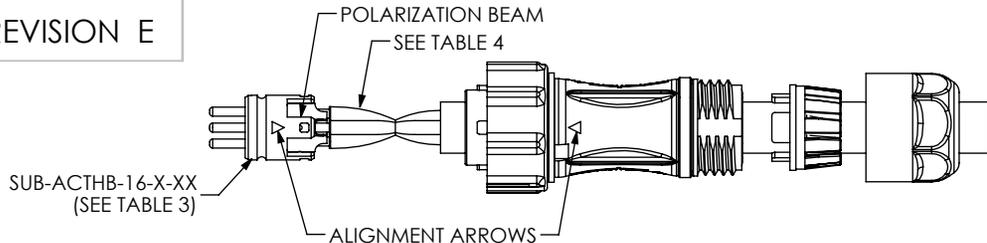


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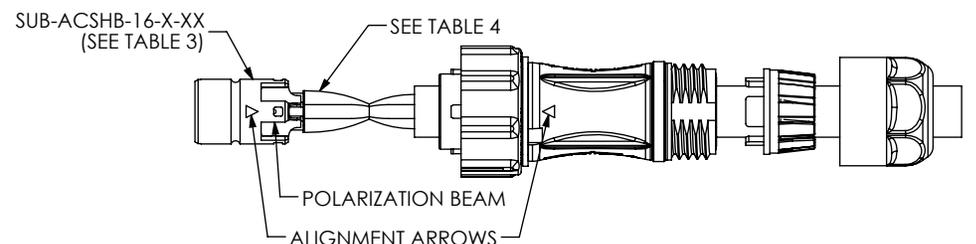
DESCRIPTION:
ACCLIMATE CIRC. CABLE ASSEMBLY

DWG. NO.
ACP-16-XX-X-XX.XX-X-XX-M-X

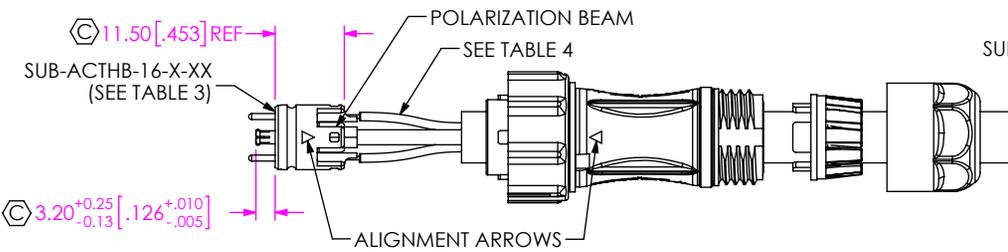
BY: D.SCHMELZ 04/30/2010 SHEET 5 OF 7



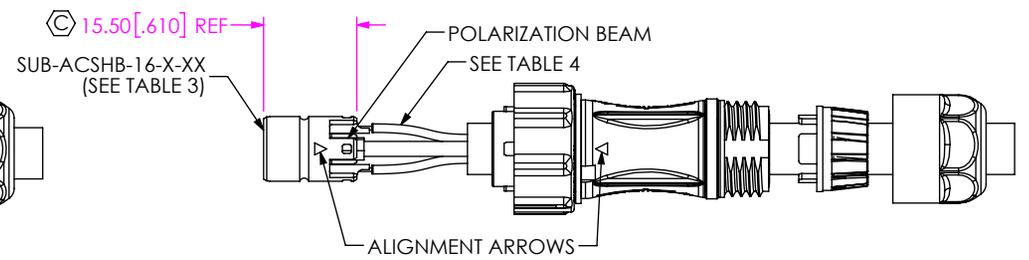
SOLDER TERMINATION TO TERMINALS



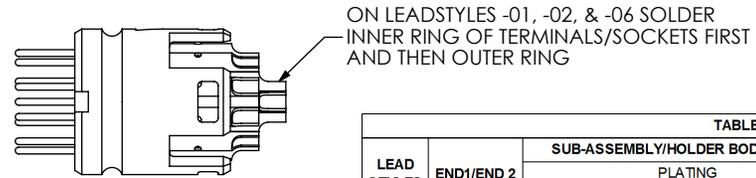
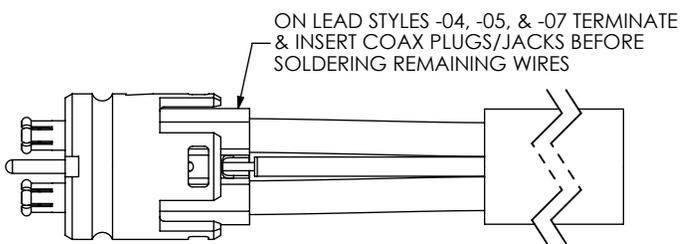
SOLDER TERMINATION TO SOCKETS



COAX PLUG INSERTION
AFTER TERMINATION PUSH COAX PLUG INTO CORE UNTIL RETENTION BEAMS ENGAGE AND LOCK IT IN PLACE



COAX JACK INSERTION
AFTER TERMINATION PUSH COAX JACK INTO CORE UNTIL RETENTION BEAMS ENGAGE AND LOCK IT IN PLACE



IN-PROCESS 5
TERMINATE WIRES/COAX TO TERMINAL/SOCKETS (SEE AC-P-C-X-ST-CA & AC-J-C-X-ST-CA1 PRINTS FOR COAX TERMINATION) (SEE NOTE 5)

POSITION	LEAD STYLE						
	-01	-02	-03	-04	-05	-06	-07
01	BROWN	BROWN	BROWN	COAX	BROWN	BROWN	COAX
02	RED	RED	RED	COAX	RED	RED	RED
03	ORANGE	ORANGE	ORANGE	ORANGE	ORANGE	ORANGE	ORANGE
04	YELLOW	YELLOW	YELLOW	YELLOW	COAX	YELLOW	YELLOW
05	GREEN	GREEN				GREEN	GREEN
06	DARK BLUE	DARK BLUE				DARK BLUE	DARK BLUE
07	VIOLET	VIOLET				VIOLET	VIOLET
08	GRAY	GRAY				GRAY	
09	WHITE	WHITE				WHITE	
10	BLACK	BLACK				BLACK	
11	GREEN / BLACK		NA	NA	NA		NA
12	TAN						
13	DARK BLUE / YELLOW						
14	PINK						

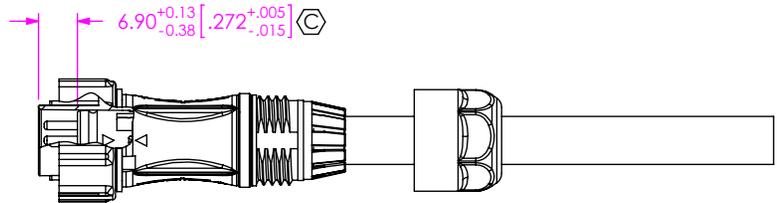
LEAD STYLES	END1/END 2	SUB-ASSEMBLY/HOLDER BODY PART #		COAX PLUG/JACK PART #	
		PLATING			
		-G	-H	AC-X-C-H-ST-CA1	QTY
-01	-T	SUB-ACTHB-16-G-01	SUB-ACTHB-16-H-01	NA	
-02	-T	SUB-ACTHB-16-G-02	SUB-ACTHB-16-H-02	NA	
-03	-T	SUB-ACTHB-16-G-03	SUB-ACTHB-16-H-03	NA	
-04	-T	SUB-ACTHB-16-G-04	SUB-ACTHB-16-H-04	AC-P-C-H-ST-CA1	2
-05	-T	SUB-ACTHB-16-G-05	SUB-ACTHB-16-H-05	AC-P-C-H-ST-CA1	1
-06	-T	SUB-ACTHB-16-G-06	SUB-ACTHB-16-H-06	NA	
-07	-T	SUB-ACTHB-16-G-07	SUB-ACTHB-16-H-07	AC-P-C-H-ST-CA1	1
-01	-S	SUB-ACSHB-16-G-01	SUB-ACSHB-16-H-01	NA	
-02	-S	SUB-ACSHB-16-G-02	SUB-ACSHB-16-H-02	NA	
-03	-S	SUB-ACSHB-16-G-03	SUB-ACSHB-16-H-03	NA	
-04	-S	SUB-ACSHB-16-G-04	SUB-ACSHB-16-H-04	AC-J-C-H-ST-CA1	2
-05	-S	SUB-ACSHB-16-G-05	SUB-ACSHB-16-H-05	AC-J-C-H-ST-CA1	1
-06	-S	SUB-ACSHB-16-G-06	SUB-ACSHB-16-H-06	NA	
-07	-S	SUB-ACSHB-16-G-07	SUB-ACSHB-16-H-07	AC-J-C-H-ST-CA1	1

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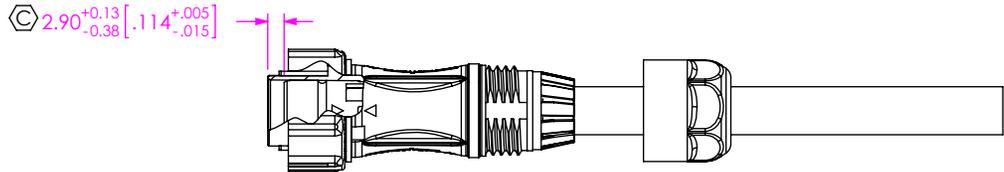


DO NOT SCALE DRAWING
SHEET SCALE: 1:1

DESCRIPTION:
ACCLIMATE CIRC. CABLE ASSEMBLY
DWG. NO.
ACP-16-XX-X-XX.XX-X-XX-M-X
BY: D.SCHMELZ 04/30/2010 SHEET 6 OF 7



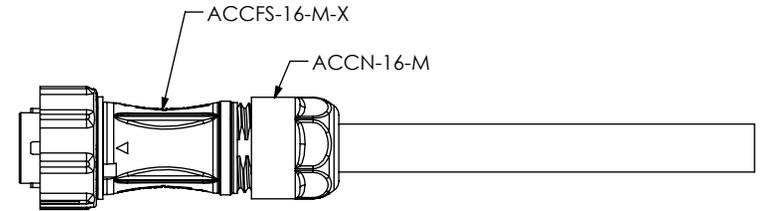
SUB-ACTHB-16-X-XX
(TERMINAL)



SUB-ACSHB-16-X-XX
(SOCKET)

IN-PROCESS 6

WHILE MAKING SURE ALIGNMENT ARROWS LINE UP TO AID POLARIZATION BEAM ENGAGEMENT, INSERT SUB-ACXHB-16-X-XX SUB-ASSEMBLY INTO ACCFS-16-M-X UNTIL SNAP LOCKS ENGAGE. PUSH ACCGC-16 & ACCG-16-1-2 UP AGAINST BACK OF ACCFS-16-M-X BEING SURE TO ALIGN (4) LEGS OF ACCG-16-1-2 WITH (4) CLEARANCE GROOVES IN THE ACCFS-16-M-X.



IN-PROCESS 7
THREAD ACCN-16-M ONTO ACCFS-16-M-X & TORQUE TO 10.00 IN-LBS.



IN-PROCESS 8

(-BC END OPTION ONLY)

BUILD DOUBLE-ENDED INITIALLY FOR E-TEST, APPLY LABEL-ET & HDRL-11 TO BOTH ENDS, AND CUT CABLE IN HALF

PROPRIETARY NOTE
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DO NOT SCALE DRAWING

SHEET SCALE: 1:1



520 PARK EAST BLVD, NEW ALBANY, IN 47150
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DESCRIPTION:
ACCLIMATE CIRC. CABLE ASSEMBLY

DWG. NO.
ACP-16-XX-X-XX.XX-X-XX-M-X

BY: D.SCHMELZ 04/30/2010 SHEET 7 OF 7