

DESIGNED & DIMENSIONED
IN MILLIMETERS [INCHES]

ACP-22-XX-X-XX.XX-X-XX-M-X

DO NOT
SCALE FROM
THIS PRINT

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

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

LEAD STYLE
-01: 30 POS (1.0 TERM/SKT), 24 AWG
-02: 20 POS (1.0 TERM/SKT), 24 AWG
-03: 8 POS PWR (1.5 TERM/SKT), 16 AWG
-04: 6 POS (COAX PLUG/JACK), COAX
(ONLY AVAILABLE WITH -H PLATING)
-05: 20 POS COMBO
(4 X 1.5 TERM/SKT), 16 AWG
(16 X 1.0 TERM/SKT), 24 AWG
-06: 16 POS COMBO
(4 X COAX PLUG/JACK), COAX
(12 X 1.0 TERM/SKT), 24 AWG

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

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

PLATING
(SEE NOTE 9)
-G: LIGHT, 10µ" GOLD IN
CONTACT AREA
-H: HEAVY, 30µ" GOLD IN
CONTACT AREA

ASSEMBLED LENGTH
XX.XX (IN METERS)
(0.25 METER MIN TO 50.00 METER MAX)
(1.00 METER MIN FOR -04. & -06
LEAD STYLES CONTAINING COAX)

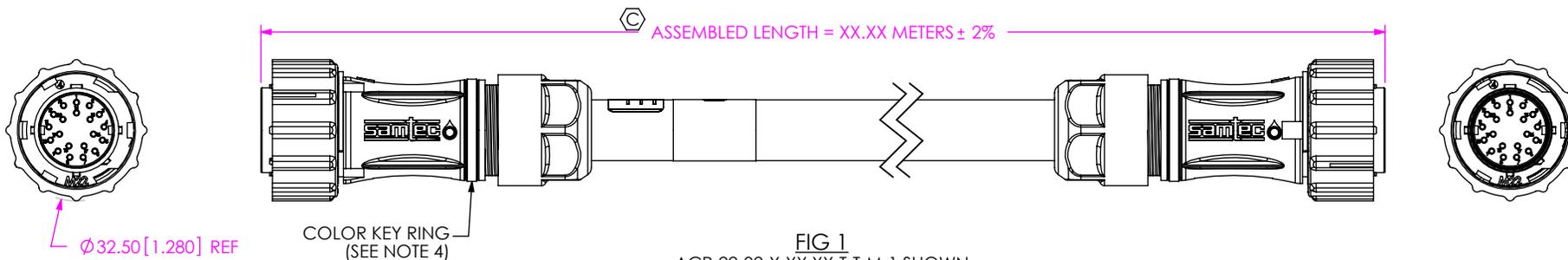
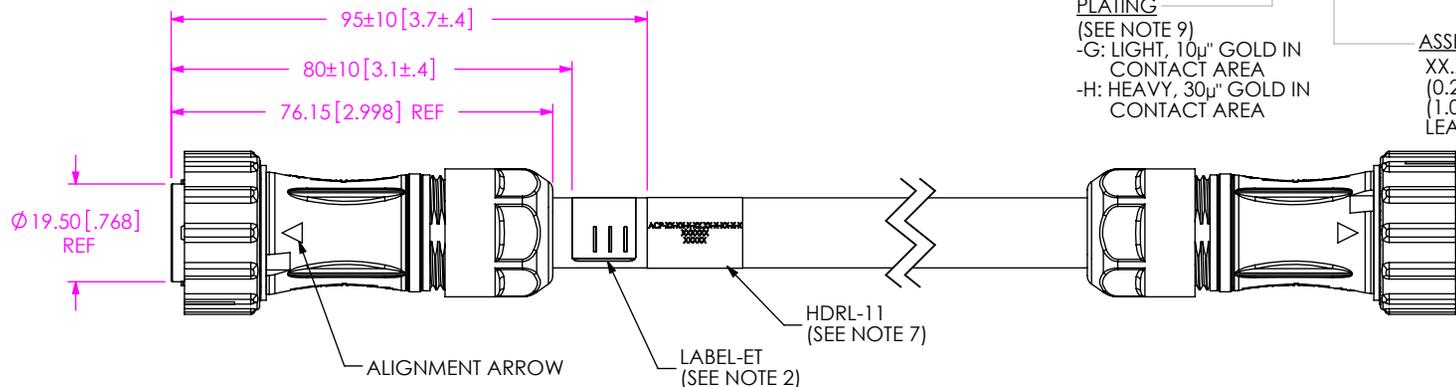


FIG 1
ACP-22-02-X-XX.XX-T-T-M-1 SHOWN

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-22-M-X PRINT FOR DUST CAP.
7. PLACE HDRL-11 (LABEL) ON CABLE WHERE SHOWN. LABEL TO CONTAIN
LINE 1 - PART NUMBER "ACP-22-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].

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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MATERIAL: DO NOT SCALE DRAWING
SHELLS: ZINC ALLOY
INSULATOR: PBT, COLOR: BLACK
TERMINALS: BRASS
CONTACTS: BRASS/BeCu
BAYONET COLLAR: ZINC ALLOY
CABLE NUT: ZINC ALLOY
GROMMET: NBR
GROMMET CAGE: NYLON, COLOR: BLACK
COLOR RINGS: SILICONE

SHEET SCALE: 2:3

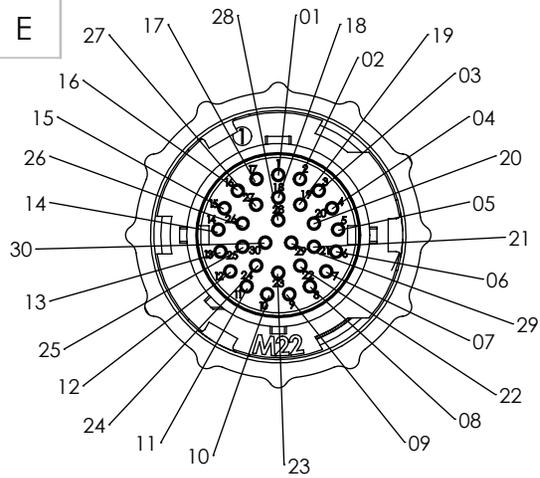


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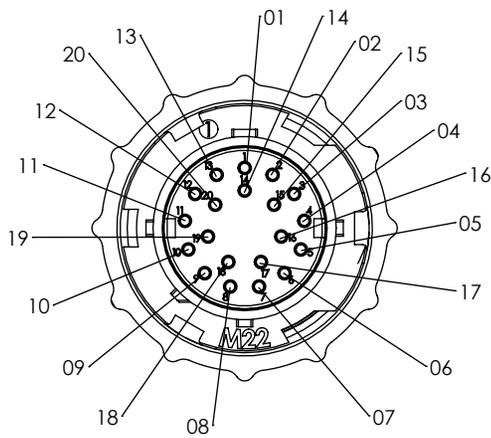
DESCRIPTION:
ACCLIMATE CIRC. CABLE ASSEMBLY

DWG. NO.
ACP-22-XX-X-XX.XX-X-XX-M-X

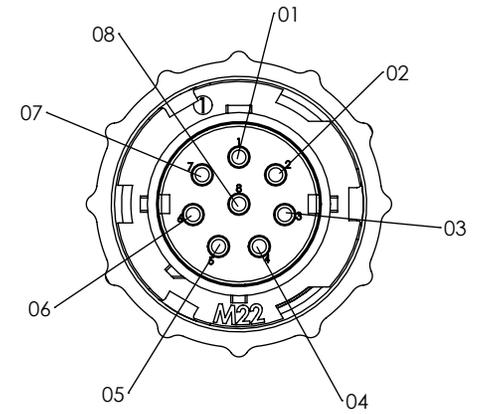
BY: CLAY W 9/5/2010 SHEET 1 OF 7



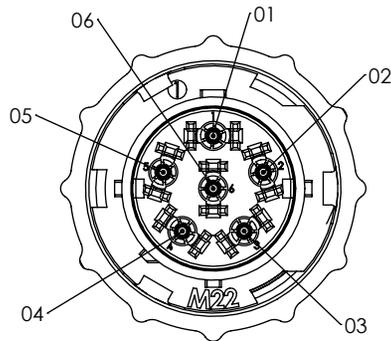
-01: 30 POS
(1.0 TERMINALS)



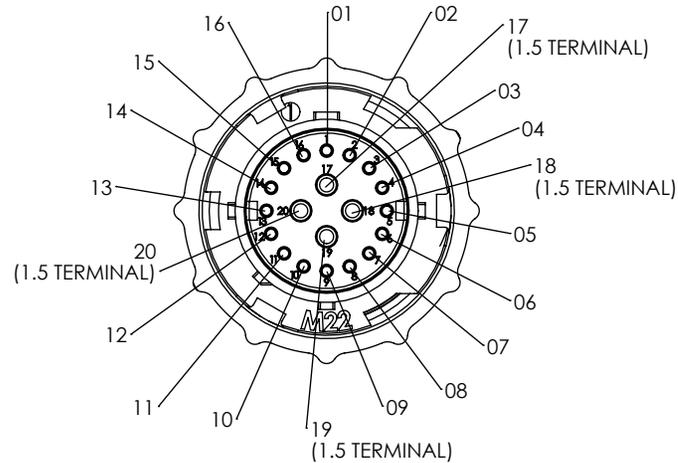
-02: 20 POS
(1.0 TERMINALS)



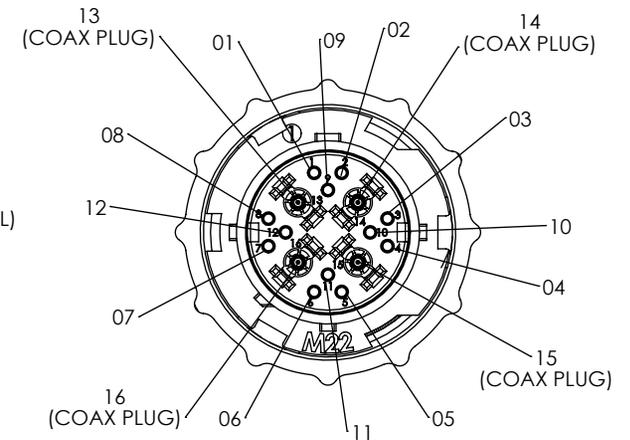
-03: 8 POS
(1.5 TERMINALS)



-04: 6 POS
(COAX PLUGS)



-05: 20 POS COMBO
(4 X 1.5 TERMINALS)
(16 X 1.0 TERMINALS)



-06: 16 POS COMBO
(4 X COAX PLUGS)
(12 X 1.0 TERMINALS)

-T END OPTIONS

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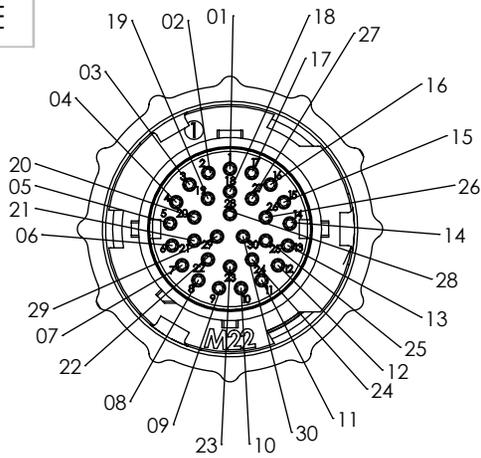


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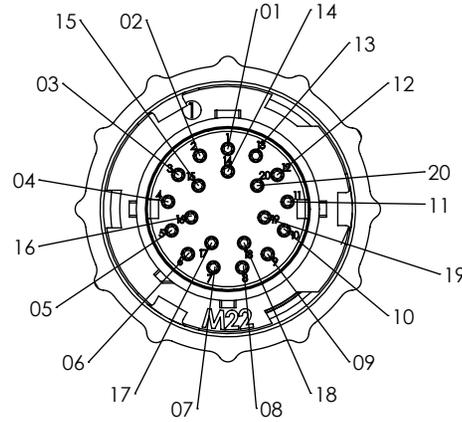
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DWG. NO. ACP-22-XX-X-XX.XX-X-XX-M-X

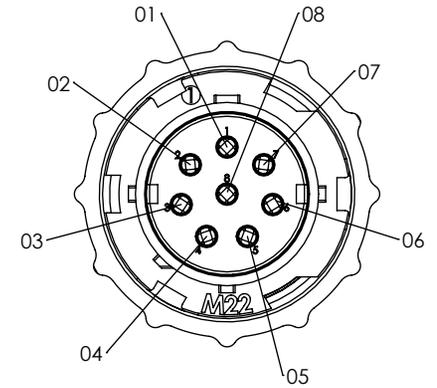
BY: CLAY W 9/5/2010 SHEET 2 OF 7



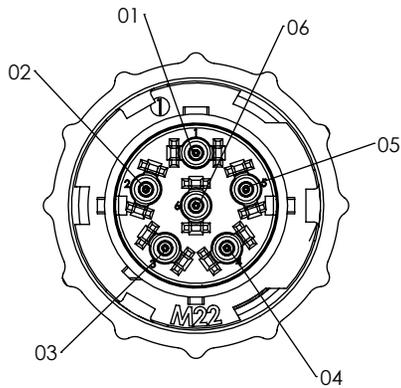
-01: 30 POS
(1.0 SOCKETS)



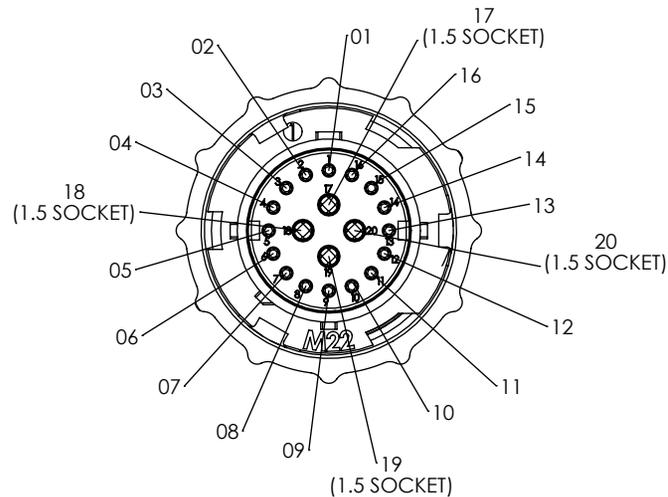
-02: 20 POS
(1.0 SOCKETS)



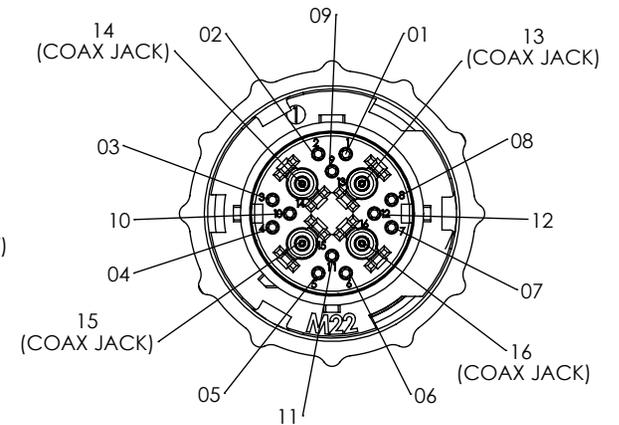
-03: 8 POS
(1.5 SOCKETS)



-04: 6 POS
(COAX JACKS)



-05: 20 POS COMBO
(4 X 1.5 SOCKETS)
(16 X 1.0 SOCKETS)



-06: 16 POS COMBO
(4 X COAX JACKS)
(12 X 1.0 SOCKETS)

-S END OPTIONS

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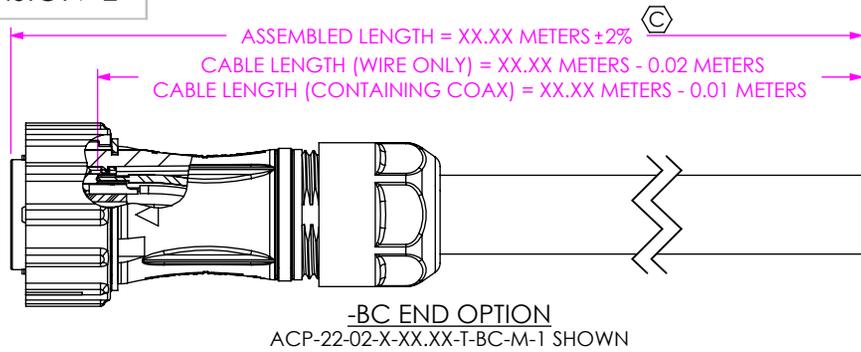
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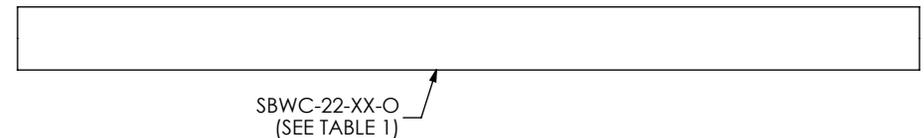
DWG. NO. **ACP-22-XX-X-XX.XX-X-XX-M-X**

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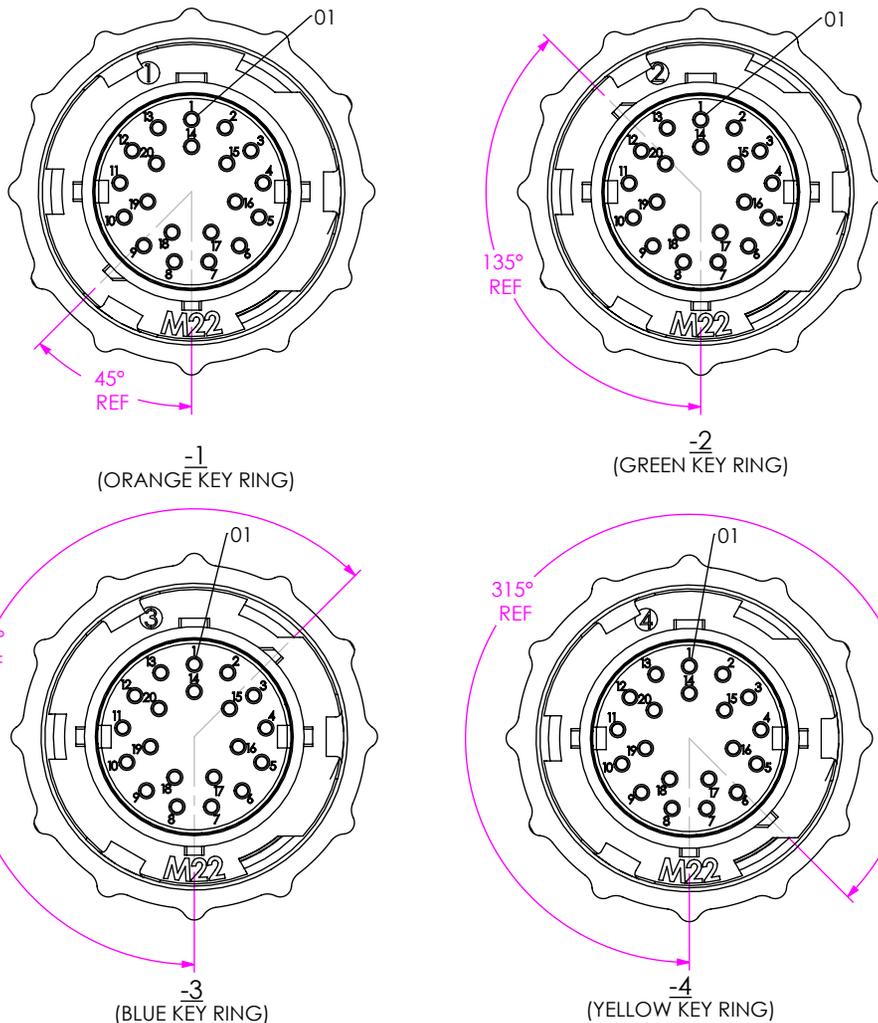
REVISION E



\odot CABLE LENGTH (WIRE ONLY) = (XX.XX METERS - 0.03 METERS) ± 2%
 CABLE LENGTH (CONTAINING COAX) = (XX.XX 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) + 0.05 METERS) ± 2%



IN-PROCESS 1
 CUT SBWC CABLE TO LENGTH SHOWN



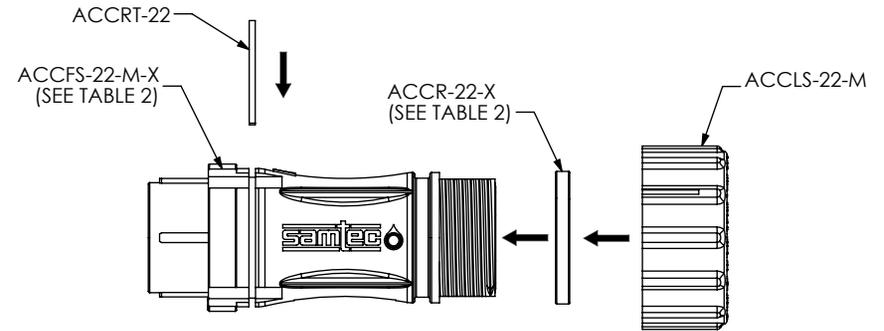
KEYING FEATURE
 (SEE NOTE 4)

TABLE 1

LEAD STYLES	SBWC PART #
-01	SBWC-22-01-O
-02	SBWC-22-02-O
-03	SBWC-22-03-O
-04	SBWC-22-04-O
-05	SBWC-22-05-O
-06	SBWC-22-06-O

TABLE 2

KEYING FEATURE	ACCFS-22-M-X	ACCR-22-X
-1	ACCFS-22-M-1	ACCR-22-1
-2	ACCFS-22-M-2	ACCR-22-2
-3	ACCFS-22-M-3	ACCR-22-3
-4	ACCFS-22-M-4	ACCR-22-4



IN-PROCESS 2
 STRETCH ACCR-22-X OVER ACCFS-22-M-X UNTIL IT SEATS IN GROOVE
 PUSH ACCLS-22-M ONTO ACCFS-22-M-X UNTIL IT BOTTOMS OUT AGAINST
 FLANGE. SNAP ACCRT-22 (RETAINING RING) INTO GROOVE IN
 ACCFS-22-M-X TO HOLD ACCLS-22-M IN PLACE

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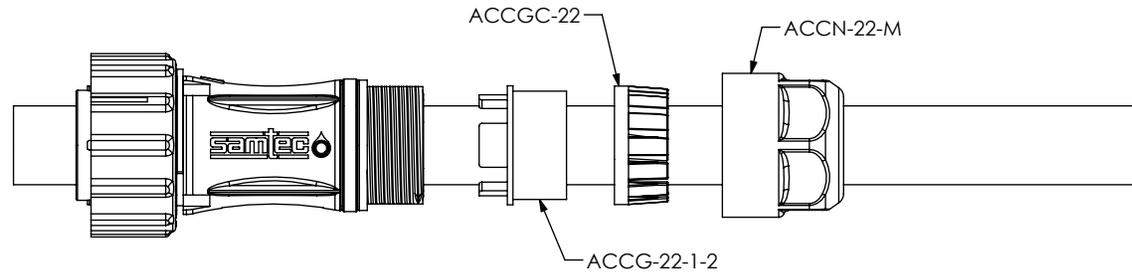


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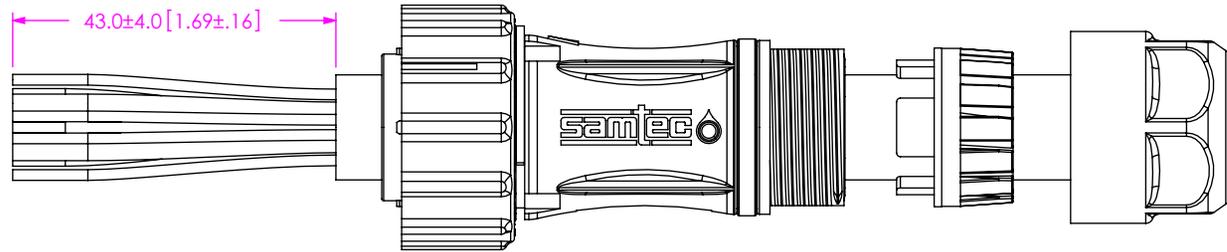
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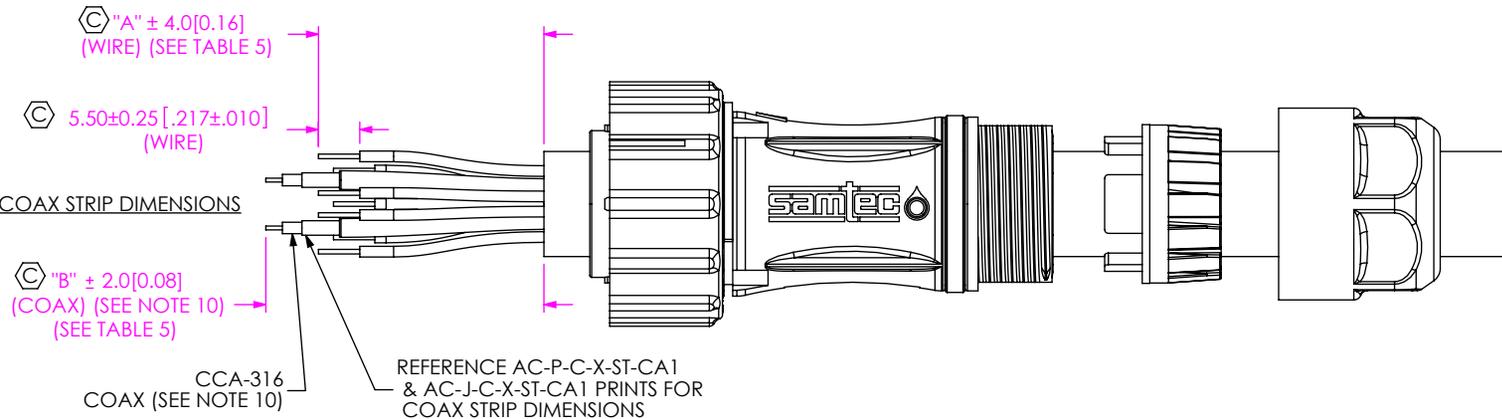
IN-PROCESS 3

FEED SBWC-22-XX-O BUNDLED CABLE THROUGH ACCN-22-M, ACCGC-22, ACCG-22-1-2, & ACCFS-22-M-X)

INITIAL WIRE & COAX STRIP DIMENSIONS
(ONLY APPLIES TO -04 & -06 LEAD STYLES)



FINAL WIRE & COAX STRIP DIMENSIONS



IN-PROCESS 4

STRIP OUTER JACKET & INNER WIRES/COAX TO DIMENSIONS SHOWN & TIN INNER CONDUCTORS. PUSH ACCGC-22 ON TO ACCG-22-1-2 UNTIL IT BOTTOMS OUT AGAINST FLANGE OF ACCG-22-1-2.

LEAD STYLES	"A"	"B"
-01	30.00 [1.181]	NA
-02	30.00 [1.181]	NA
-03	30.00 [1.181]	NA
-04	NA	43.00 [1.693]
-05	30.00 [1.181]	NA
-06	34.00 [1.339]	37.00 [1.457]

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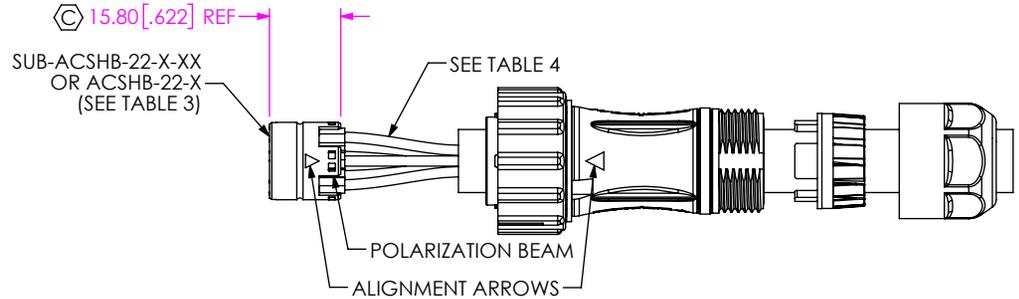
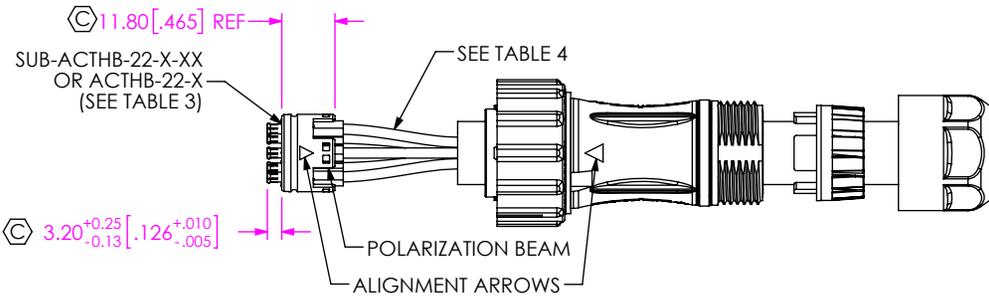
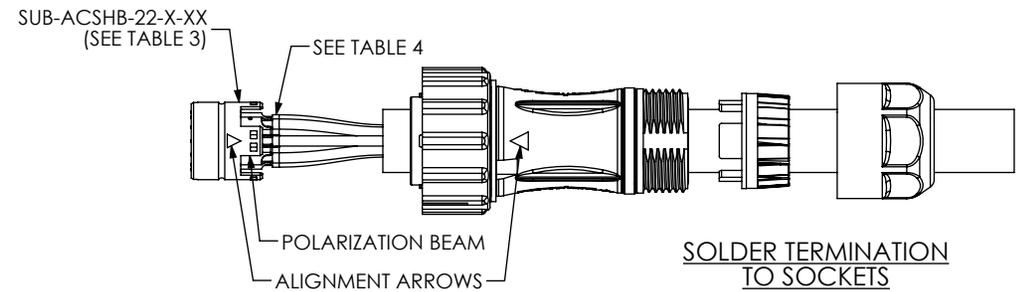
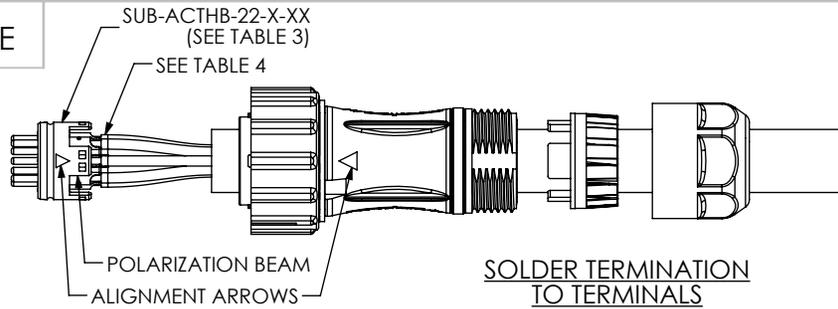
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REVISION E



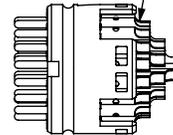
COAX PLUG INSERTION
AFTER TERMINATION, PUSH COAX PLUG INTO CORE UNTIL RETENTION BEAMS ENGAGE AND LOCK IT INTO PLACE

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

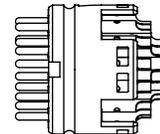
IN-PROCESS 5
TERMINATE WIRES/COAX TO TERMINAL/SOCKETS
(SEE AC-P-C-X-ST-CA1 & AC-J-C-X-ST-CA1 PRINTS FOR COAX TERMINATION)
(SEE NOTE 5)

POSITION	LEAD STYLE					
	-01	-02	-03	-04	-05	-06
01	BROWN	BROWN	BROWN	COAX	BROWN	BROWN
02	RED	RED	RED	COAX	RED	RED
03	ORANGE	ORANGE	ORANGE	COAX	ORANGE	ORANGE
04	YELLOW	YELLOW	YELLOW	COAX	YELLOW	YELLOW
05	GREEN	GREEN	GREEN	COAX	GREEN	GREEN
06	DARK BLUE	DARK BLUE	DARK BLUE	COAX	DARK BLUE	DARK BLUE
07	VIOLET	VIOLET	VIOLET		VIOLET	VIOLET
08	GRAY	GRAY	GRAY		GRAY	GRAY
09	WHITE	WHITE			WHITE	WHITE
10	BLACK	BLACK			BLACK	BLACK
11	GREEN / BLACK	GREEN / BLACK			GREEN / BLACK	GREEN / BLACK
12	TAN	TAN			TAN	TAN
13	DARK BLUE / YELLOW	DARK BLUE / YELLOW			DARK BLUE / YELLOW	COAX
14	PINK	PINK			PINK	COAX
15	BROWN / WHITE	BROWN / WHITE			BROWN / WHITE	COAX
16	RED / WHITE	RED / WHITE			RED / WHITE	COAX
17	ORANGE / WHITE	ORANGE / WHITE			ORANGE / WHITE	
18	YELLOW / WHITE	YELLOW / WHITE			YELLOW / WHITE	
19	GREEN / WHITE	GREEN / WHITE			GREEN / WHITE	
20	DARK BLUE / WHITE	DARK BLUE / WHITE	NA	NA	DARK BLUE / WHITE	
21	VIOLET / WHITE					
22	GRAY / WHITE					
23	WHITE / BLACK					
24	BLACK / WHITE					
25	GREEN / YELLOW					
26	TAN / WHITE	NA			NA	
27	DARK BLUE / PINK					
28	PINK / WHITE					
29	BROWN / BLACK					
30	RED / BLACK					

ON LEADSTYLE -06,
TERMINATE & INSERT
COAX PLUGS/JACKS
BEFORE SOLDERING
REMAINING WIRES



ON LEADSTYLES -01, -02, -03 & -05
SOLDER INNER RING OF
TERMINALS/SOCKETS FIRST AND
THEN OUTER RING



LEAD STYLES	END1/END 2	PLATING		COAX PLUG/JACK PART #	
		-G	-H	AC-X-C-H-ST-CA1	QTY
-01	-T	SUB-ACTHB-22-G-01	SUB-ACTHB-22-H-01	NA	
-02	-T	SUB-ACTHB-22-G-02	SUB-ACTHB-22-H-02	NA	
-03	-T	SUB-ACTHB-22-G-03	SUB-ACTHB-22-H-03	NA	
-04	-T	ACTHB-22-6	ACTHB-22-6	AC-P-C-H-ST-CA1	6
-05	-T	SUB-ACTHB-22-G-05	SUB-ACTHB-22-H-05	NA	
-06	-T	SUB-ACTHB-22-G-06	SUB-ACTHB-22-H-06	AC-P-C-H-ST-CA1	4
-01	-S	SUB-ACSHB-22-G-01	SUB-ACSHB-22-H-01	NA	
-02	-S	SUB-ACSHB-22-G-02	SUB-ACSHB-22-H-02	NA	
-03	-S	SUB-ACSHB-22-G-03	SUB-ACSHB-22-H-03	NA	
-04	-S	ACSHB-22-6	ACSHB-22-6	AC-J-C-H-ST-CA1	6
-05	-S	SUB-ACSHB-22-G-05	SUB-ACSHB-22-H-05	NA	
-06	-S	SUB-ACSHB-22-G-06	SUB-ACSHB-22-H-06	AC-J-C-H-ST-CA1	4

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SHEET SCALE: 1:1



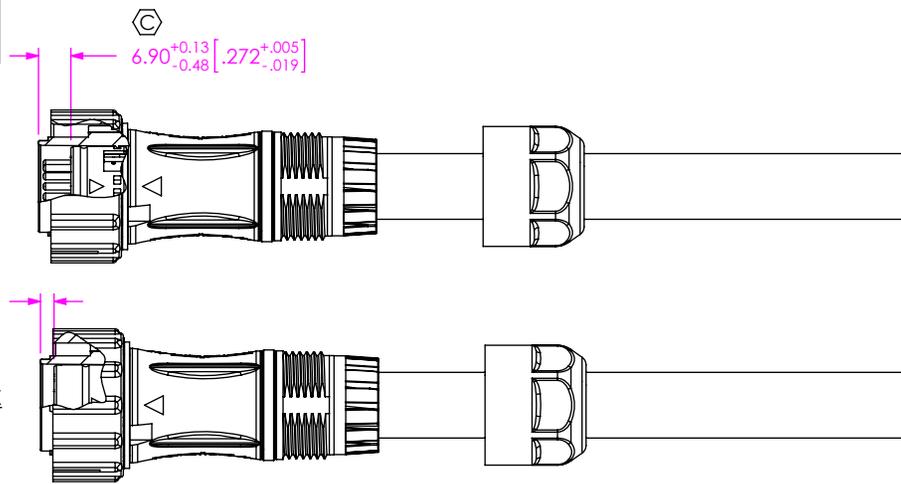
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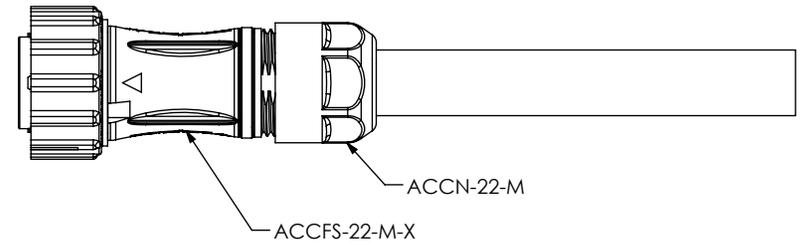
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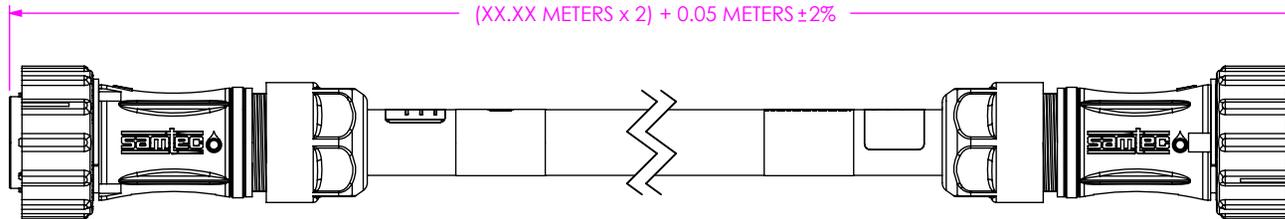
REVISION E



IN-PROCESS 6
 WHILE MAKING SURE ALIGNMENT ARROWS LINE UP TO AID POLARIZATION BEAM ENGAGEMENT, INSERT SUB-ACXHB-22-X-XX SUB-ASSEMBLY INTO ACCFS-22-M-X UNTIL SNAP LOCKS ENGAGE. PUSH ACCGC-22 & ACCG-22-1-2 UP AGAINST BACK OF ACCFS-22-M-X



IN-PROCESS 7
 THREAD ACCN-22-M ONTO ACCFS-22-M-X TO 15.00 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

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SHEET SCALE: 1:1



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