

DO NOT
SCALE FROM
THIS PRINT

PATENT NUMBER
7,544,093

CABLE CALLOUT
23S: MWC-2350-01 CABLE

OVERALL ASSEMBLY LENGTH (OAL)
XXXX (MILLIMETERS) (0100 MIN) (SEE NOTE 9)

END 1 CONNECTOR
(SEE TABLE 3, SHT 2)

END 2 CONNECTOR OR PREPARATION
(SEE TABLE 3, SHT 2)

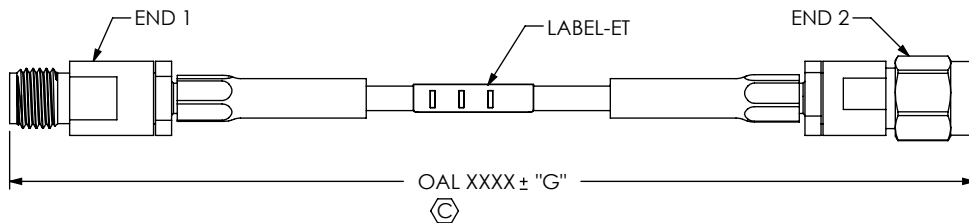


FIG 1
RF23S-92SJX-92SPX-XXXX SHOWN

TABLE 2	
OVERALL LENGTH	"G"
0100-0200 [3.94-7.87]	+3.0 [.12] / -0.0 [.00]
0201-0500 [7.91-19.69]	+5.0 [.20] / -0.0 [.00]
0501-1100 [19.72-43.30]	+10.0 [.39] / -0.0 [.00]
> 1100 [43.30]	± 1%

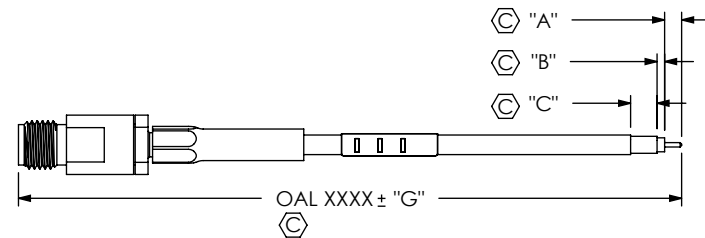


FIG 2
RF23S-92SJX-172849-XXXX SHOWN (SEE NOTE 3 & 5)

"C" (FORMAT: X.X)
"B" (FORMAT: X.X)
"A" (FORMAT: X.X)

DO NOT LEAVE ANY SPACE BLANK,
EACH MUST CONTAIN A
NUMERIC CHARACTER 0 THRU 9.

NOTES:

1. \odot REPRESENTS A CRITICAL DIMENSION
2. ASSEMBLY TO BE 100% TESTED FOR OPENS, SHORTS & HI-POT TESTED (PER TABLE 1, AC OR DC), THE HI-POT VOLTAGE FOR THE ASSEMBLY SHOULD BE SET TO THE END OPTION WITH THE LOWEST TEST VOLTAGE RATING.
3. DIM "A", "B", AND "C" HAVE A MINIMUM VALUE OF 0.0mm & A MAXIMUM VALUE OF 9.9mm.
4. FOR STRIPPED AND TINNED OPTION, ONLY THE CENTER CONDUCTOR IS TINNED.
5. CONNECTORS TO BE ORIENTED ACCORDING TO CO-RF-WI-3048-M.
6. FERRULE AND SPRING ARE FREE FLOATING AND ARE NOT STATIONARY.
7. AFTER FINAL ELECTRICAL TEST, LABEL EACH CABLE ASSEMBLY WITH 1 LABEL-ET.
8. CABLE ASSEMBLIES TO BE BULK PACKAGED PER PACKAGING STANDARD CO-RF-WI-3040-M.
9. CABLE LENGTHS LONGER THAN 1000 MILLIMETERS ARE NOT SUPPORTED BY S.I. TEST DATA.

F:\DWG\MISC\MKTG\RF23S-XXXXX-XXXXXX-XXXX-MKT.SLDDRW

UNLESS OTHERWISE SPECIFIED,
DIMENSIONS ARE IN
MILLIMETERS [INCHES].
TOLERANCES ARE:
DECIMALS ANGLES
.X: ± 0.3 [.01] 5°
.XX: ± 0.13 [.005]
.XXX: ± 0.051 [.0020]

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MATERIAL: DO NOT SCALE DRAWING

SHEET SCALE: 2:1

INNER PINS: BeCu
INSULATORS: PTFE (SCC31)
PCTFE (OTHERS)
GASKETS: SILICONE
CABLE BODY, RETAINER, FERRULE: BRASS
SPRING, SHELLS, BODY, C-RING, NUT: STAINLESS STEEL

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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:
RF23S CABLE ASSEMBLY

DWG. NO.
RF23S-XXXXX-XXXXXX-XXXX

BY: EMMA CHEN 12/14/2012 SHEET 1 OF 8

TABLE 3

END OPTION	SERIES	GENDER	CONFIGURATION	PLATING			FIGURE
				CENTER CONTACT	OUTER CONTACT	OTHER COMPONENTS	
-92SJP	2.92 MM	JACK	STRAIGHT	30μ" GOLD	STAINLESS STEEL	3μ" GOLD	SHT 3, FIG 3
-92SPP	2.92 MM	PLUG	STRAIGHT	30μ" GOLD	STAINLESS STEEL	3μ" GOLD	SHT 3, FIG 4
-SCC31	Bull's Eye ®	N/A	N/A	30μ" GOLD	3μ" GOLD	3μ" GOLD	SHT 4, FIG 5
-35SJP	3.50 MM	JACK	STRAIGHT	30μ" GOLD	STAINLESS STEEL	3μ" GOLD	SHT 4, FIG 6
-35SPP	3.50 MM	PLUG	STRAIGHT	30μ" GOLD	STAINLESS STEEL	3μ" GOLD	SHT 5, FIG 7
*-SING	SINGLE ENDED	-	-	-	-	-	-
*-XXXXXX	STRIPPED & TINNED	-	-	-	-	-	SHT 1, FIG 2

* = END 2 OPTION ONLY

TABLE 1

END OPTION	SUBTRACTOR	STRIP DIMENSIONS			HI POT	
		"Y"	"A"	"D"	"E"	"DC" "AC"
-92SJP	7.7 [0.30]	2.25 [0.089]	3.25 [0.128]	6.75 [0.266]	1000	1000
-92SPP	8.5 [0.33]	2.25 [0.089]	3.25 [0.128]	6.75 [0.266]	1000	1000
-SCC31	1.7 [0.07]	2.16 [0.085]	2.16 [0.085]	5.94 [0.234]	1000	750
-35SJP	8.3 [0.33]	1.65 [0.065]	2.45 [0.096]	5.95 [0.234]	1000	1000
-35SPP	9.2 [0.36]	1.65 [0.065]	2.45 [0.096]	5.95 [0.234]	1000	1000
*-SING	0.0 [0.00]	-	-	-	1000	1000
*-XXXXXX	0.0 [0.00]	"A"	"A"+"B"	"A"+"B"+"C"	1000	1000

* = END 2 OPTION ONLY

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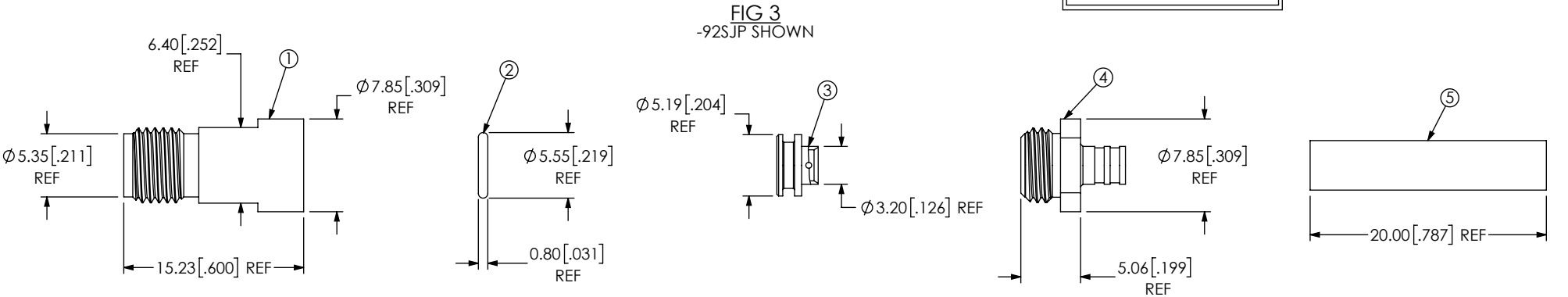


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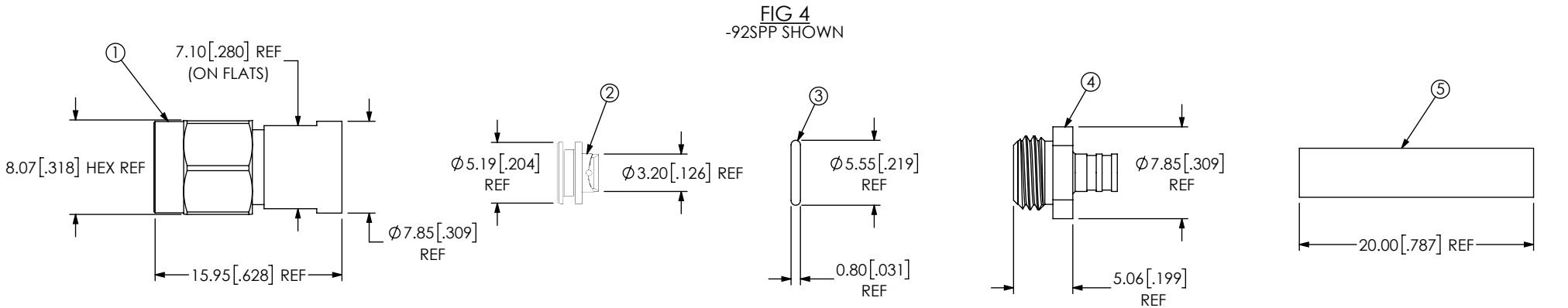
DESCRIPTION: RF23S CABLE ASSEMBLY

DWG. NO. RF23S-XXXXX-XXXXXX-XXXX

BY:EMMA CHEN 12/14/2012 SHEET 2 OF 8



BOM		
ITEM	COMPONENT	-HP
1	SUB ASSEMBLY	SUB-292PS-J-C-HP-ST-CS3
2	GASKET	292-C-ST-GKT
3	CABLE BODY	292-C-F-ST-CS3-CBDY
4	BODY	292PS-C-P-ST-CS3-BDY
5	HEAT SHRINK	HST-0.125-02-BLK-A



BOM		
ITEM	COMPONENT	-HP
1	SUB ASSEMBLY	SUB-292PS-J-C-HP-ST-CS3
2	CABLE BODY	292-C-F-ST-CS3-CBDY
3	GASKET	292-C-ST-GKT
4	BODY	292PS-C-P-ST-CS3-BDY
5	HEAT SHRINK	HST-0.125-02-BLK-A

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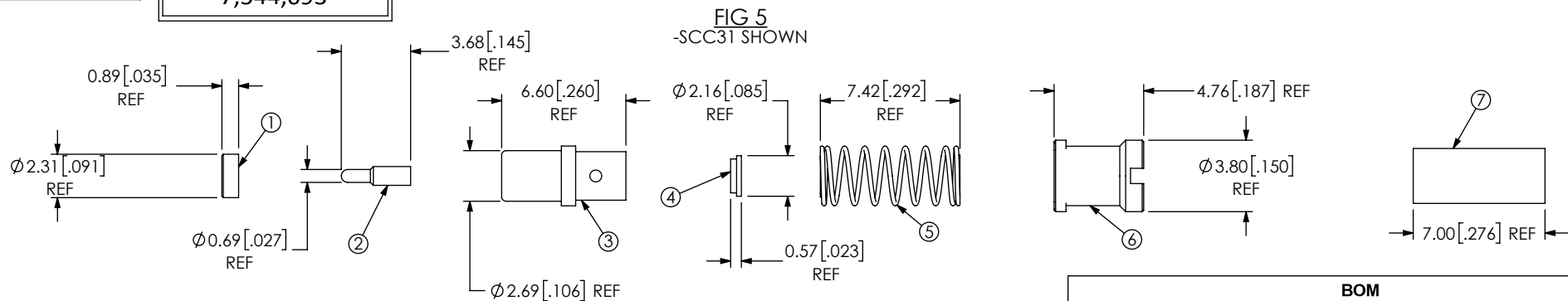
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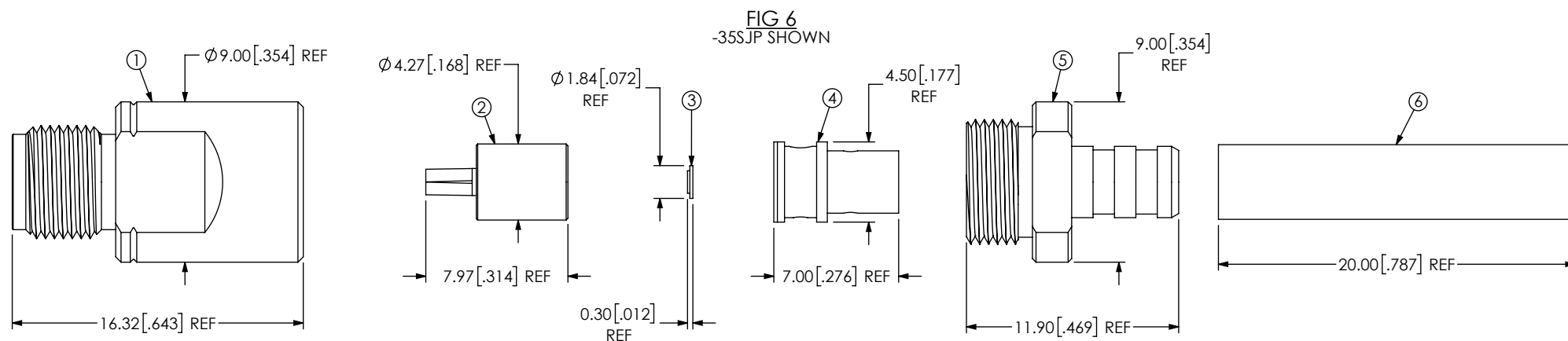
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DWG. NO. RF23S-XXXXXX-XXXXXX-XXXX

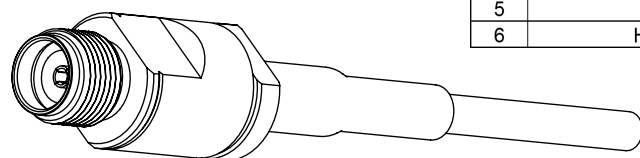
BY:EMMA CHEN 12/14/2012 SHEET 3 OF 8



BOM		
ITEM	COMPONENT	-HF
1	INSULATOR 1	PRB3-INS-003
2	PIN	PRB3-PIN-002-H
3	FERRULE	PRB3-FER-002-F
4	RETAINER	PRB3-RET-002-F
5	SPRING	PRB3-SPR-002
6	INSULATOR 2	PRB3-INS-004
7	HEAT SHRINK	HST-0.125-02-BLK



BOM		
ITEM	COMPONENT	-HP
1	SHELL	350-J-C-P-ST-CS3-SHL
2	SUB SOCKET ASSEMBLY	SUB-350-J-C-HP-ST-CS3-SKT
3	INSULATOR	350-ST-CS3-INS
4	CABLE BODY	350-C-F-ST-CS3-CBDY
5	BODY	350-C-P-ST-CS3-BDY
6	HEAT SHRINK	HST-0.125-02-BLK-A



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SHEET SCALE: 3:1

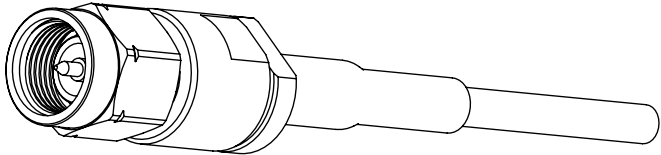
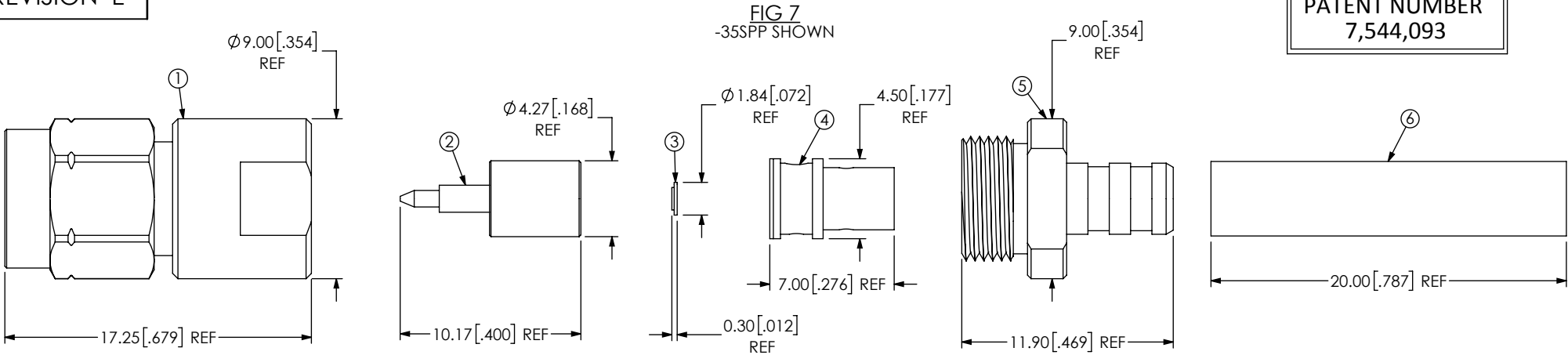
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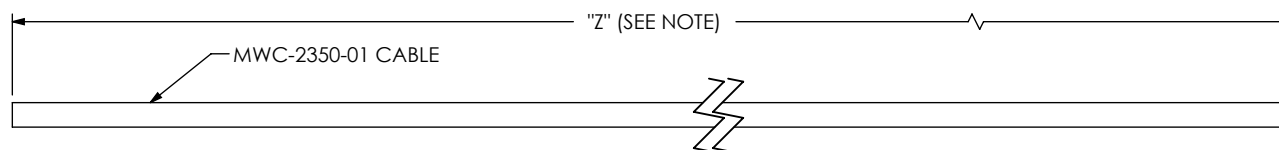
DWG. NO. RF23S-XXXXX-XXXXXX-XXXX

BY:EMMA CHEN 12/14/2012 SHEET 4 OF 8



BOM		
ITEM	COMPONENT	-HP
1	SUB SHELL ASSEMBLY	SUB-350-P-C-P-ST-CS3-SHL
2	SUB PIN ASSEMBLY	SUB-350-P-C-HP-ST-CS3-PIN
3	INSULATOR	350-ST-CS3-INS
4	CABLE BODY	350-C-F-ST-CS3-CBDY
5	BODY	350-C-P-ST-CS3-BDY
6	HEAT SHRINK	HST-0.125-02-BLK-A

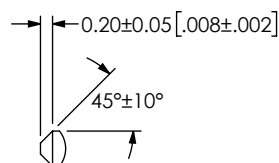
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	SHEET SCALE: 3:1	DWG. NO. RF23S-XXXXX-XXXXXX-XXXX	
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IN PROCESS 1
CUT CABLE TO LENGTH

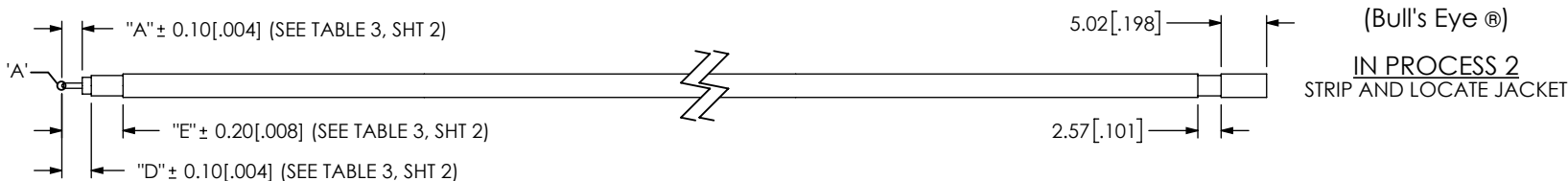
NOTE: "Z" = 2 * OAL - 2*"Y"(END 1)] (FOR -SING OR -XXXXXX OPTIONS)
"Z" = OAL - "Y"(END 1) - "Y"(END 2) (FOR DOUBLE ENDED OPTIONS)

IN PROCESS 2
STRIP CABLE &
CHAMFER CENTER CONDUCTOR

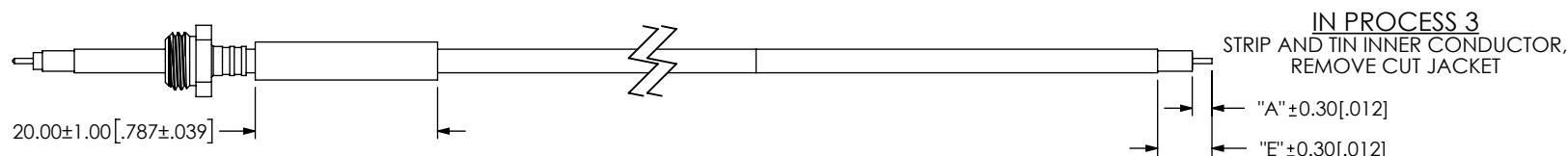


DETAIL 'A'
SCALE 8 : 1

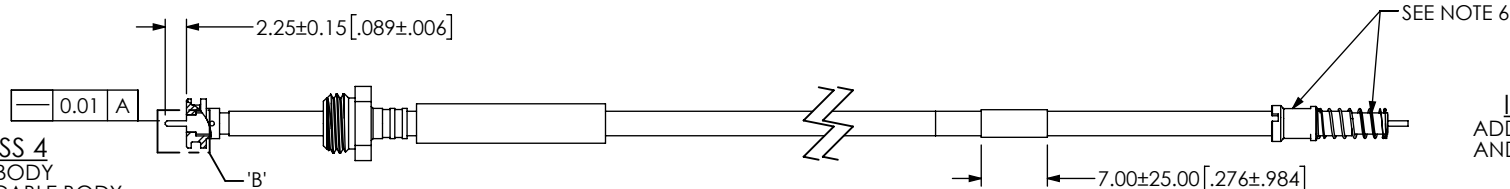
IN PROCESS 3
ADD BODY & HEAT SHRINK



(Bull's Eye ®)
IN PROCESS 2
STRIP AND LOCATE JACKET

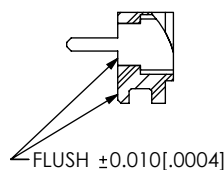


IN PROCESS 3
STRIP AND TIN INNER CONDUCTOR,
REMOVE CUT JACKET



IN PROCESS 4
ADD CABLE BODY
SOLDER CABLE TO CABLE BODY
TRIM DIELECTRIC TO BE FLUSH WITH BODY

IN PROCESS 4
ADD RETAINER, SPRING
AND HEAT SHRINK TUBE



DETAIL 'B'
SCALE 3 : 1

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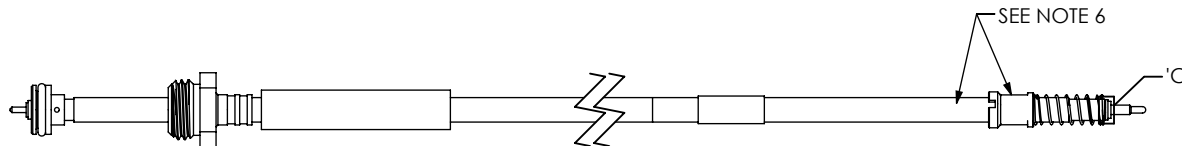
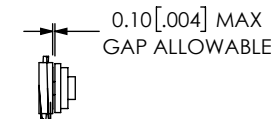
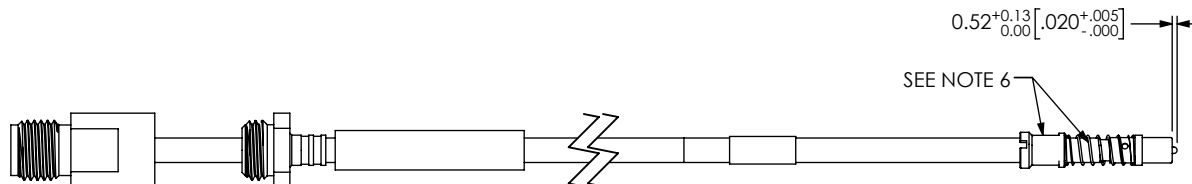
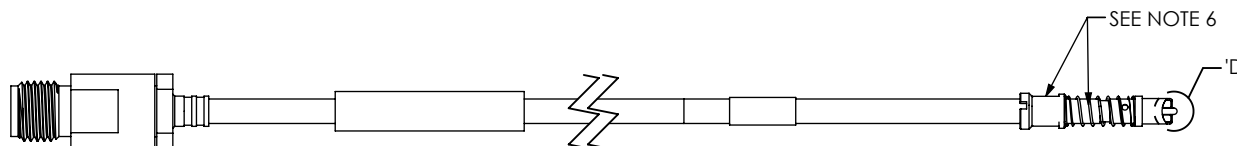
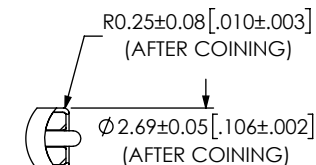
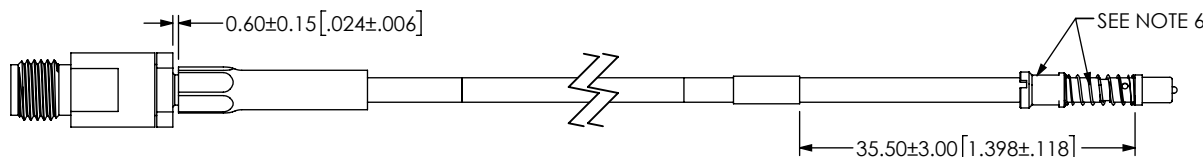
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DESCRIPTION: RF23S CABLE ASSEMBLY

DWG. NO. RF23S-XXXXX-XXXXXX-XXXX

BY:EMMA CHEN 12/14/2012 SHEET 6 OF 8

IN PROCESS 5
ADD GASKETIN PROCESS 5
ADD INSULATOR 2 AND
INDUCTIVE SOLDER PINDETAIL 'C'
SCALE 3 : 1IN PROCESS 6
ADD SUB ASSEMBLYIN PROCESS 6
ADD AND SOLDER FERRULEIN PROCESS 7
TORQUE SUB ASSEMBLY TO CABLE BODY,
20~30 IN-LBSIN PROCESS 7
ADD INSULATOR 1 AND COIN END0.41 [0.016] MAX
(LENGTH OF COINED SECTION)DETAIL 'D'
SCALE 3 : 1IN PROCESS 8
ACTIVATE HEAT SHRINKIN PROCESS 8
ACTIVATE HEAT SHRINK

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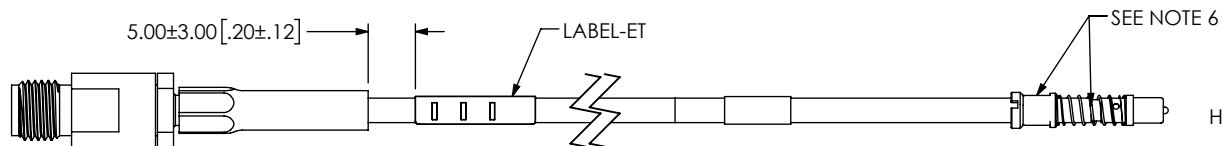
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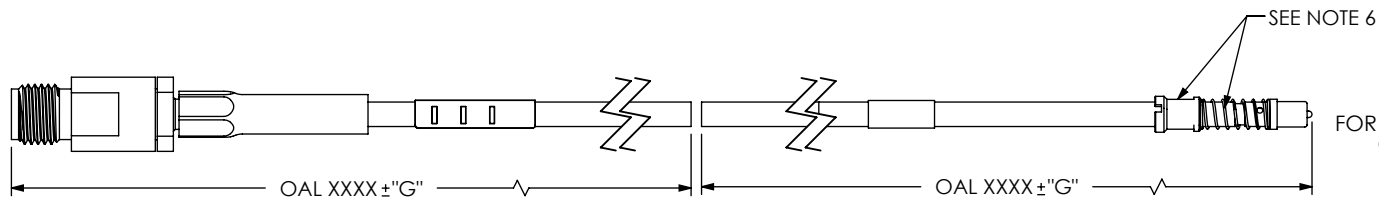
BY: EMMA CHEN 12/14/2012 SHEET 7 OF 8

IN PROCESS 9
PERFORM ELECTRICAL
HIPOT & ADD LABEL NEAR END 1
OR ON BOTH ENDS IF -SING



IN PROCESS 9
PERFORM ELECTRICAL
HI-POT & ADD LABEL NEAR END 1
OR ON BOTH ENDS IF -SING

IN PROCESS 10
FOR -SING OR -XXXXXX END 2
OPTION, CUT IN HALF



IN PROCESS 10
FOR -SING OR -XXXXXX END 2
OPTION, CUT IN HALF

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