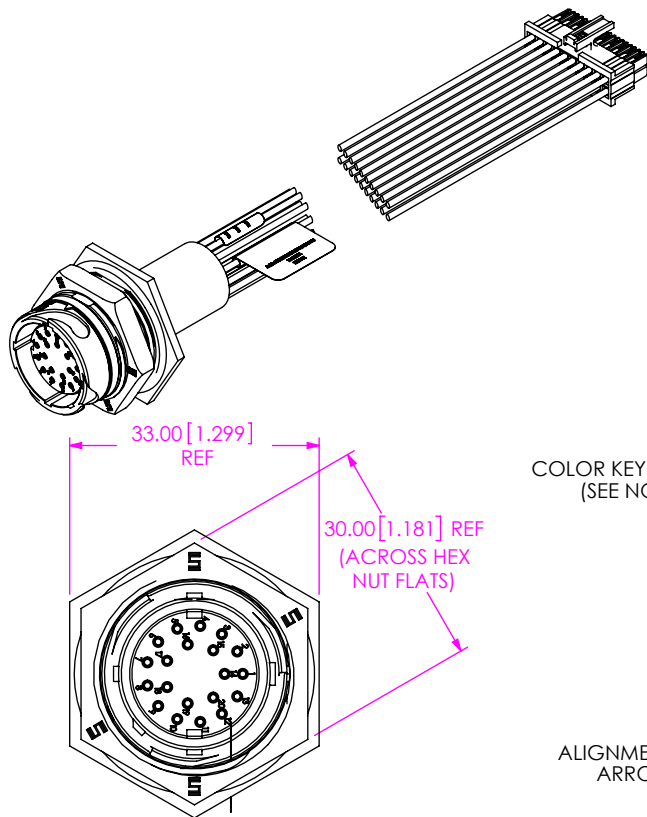


**DESIGNED & DIMENSIONED
IN MILLIMETERS[INCHES]**



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

DO NOT
SCALE FROM
THIS PRINT



NOTES:

1. $\odot$ REPRESENTS A CRITICAL DIMENSION.
2. ASSEMBLY TO BE 100% HI-POT TESTED AT 300V.
(1) LABEL-ET TO BE APPLIED AFTER FINAL ELECTRICAL TEST.
3. ASSEMBLIES TO BE BULK PACKAGED.
4. KEYING FEATURE 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-ACR-22-P-X PRINT FOR DUST CAP.
7. PLACE HDRL-11 (LABEL) IN FLAG STYLE, ON CABLE WHERE SHOWN. LABEL TO CONTAIN:
LINE 1 - PART NUMBER "ACR-22-XX-X-XX.XX-X-XX-P-X"
LINE 2 - SHOP ORDER NUMBER "XXXXXX"
LINE 3 - DATE CODE "XXXXX"
8. PANEL THICKNESS RANGE: 0.80[0.031] - 5.20[0.205]
9. FOR END 2 CABLE LENGTH, REFERENCE END 2 OPTIONS ON SHEET 4.
10. END 2 CONNECTOR PLATING:
MPSS & MMSD: 10 μ MIN GOLD.
RF316: 30 μ MIN GOLD ON INNER CONTACT
3 μ MIN GOLD ON OUTER CONTACT
3 μ MIN GOLD ON REMAINING METAL PARTS.
11. NOTE DELETED.
12. WHEN MOUNTING PRODUCT TO PANEL TORQUE ACPN-22-P TO 15 IN-LBS.
13. APPLY HEAT SHRINK TUBING TO -01, -02, -05, & -06 LEAD STYLES.
14. PLATING CALLOUTS APPLY TO END 1 TERMINALS & SOCKETS ONLY. COAX PLUGS/JACKS HAVE -H PLATING ON INNER TERMINALS/sockets & -F PLATING ON OUTER SHELLS.
15. MINIMUM BEND RADIUS FOR COAX CABLE IS 25.4[1.00].

ACR-22-XX-X-XX.XX-X-XX-P-X

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

SIZE

PLATING

- (SEE NOTE 10 & 14)
- G: LIGHT, 10 μ AU / 50 μ NI
MIN ON CONTACT
- H: HEAVY, 30 μ AU / 50 μ NI
MIN ON CONTACT

**KEYING FEATURE
(SEE NOTE 4)(SEE SHEET 6)**

- 1: ORANGE
- 2: GREEN
- 3: BLUE
- 4: YELLOW

STYLE

- P: PLASTIC

END 2

- BC: BLUNT CUT
- S1: CONNECTOR
(DETERMINED BY
LEAD STYLE)

END 1

- T: TERMINAL
- S: SOCKET

ASSEMBLED LENGTH

XX.XX (IN METERS)
(00.20 METER MIN TO 50.00 METER MAX)

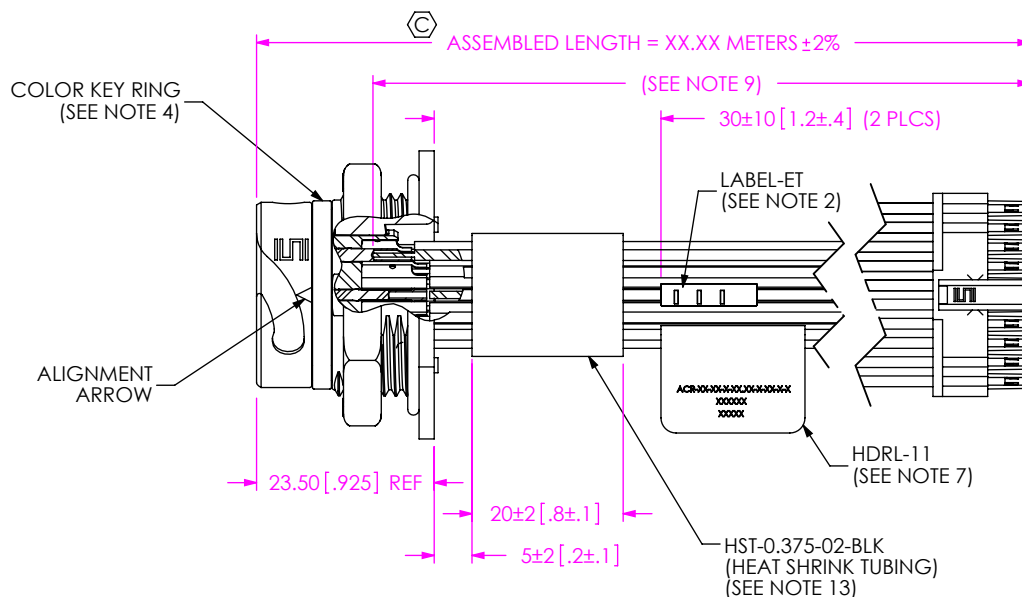


FIG 1

ACR-22-02-X-XX.XX-S-S1-P-1 SHOWN

UNLESS OTHERWISE SPECIFIED,
DIMENSIONS ARE IN MILLIMETERS.

TOLERANCES ARE:

DECIMALS	ANGLES
X.X: $\pm$ 0.3 [.01]	2°
X.XX: $\pm$ 0.13 [.005]	
X.XXX: $\pm$ 0.051 [.0020]	

MATERIAL: DO NOT SCALE DRAWING
SHELL: NYLON, COLOR: BLACK
HOLDER BODY: PBT, COLOR: BLACK
TERMINALS: BRASS
CONTACTS: BRASS/BeCu
BAYONET COLLAR: NYLON, COLOR: BLACK
CABLE NUT: NYLON, COLOR: BLACK
GROMMET: NBR
GROMMET CAGE: NYLON, COLOR: BLACK
COLOR RINGS: SILICONE

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SHEET SCALE: 2:1

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PHONE: 812-944-6733 FAX: 812-948-5047
e-Mail: info@SAMTEC.com code 55322

DESCRIPTION:

M22 CABLE ASSEMBLY

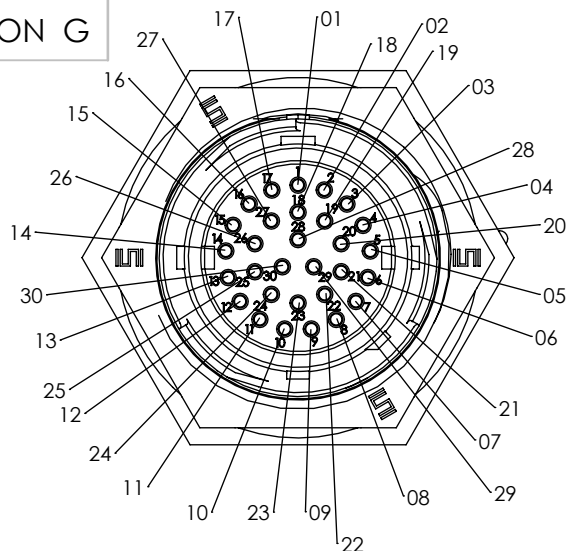
DWG. NO.

ACR-22-XX-X-XX.XX-X-XX-P-X

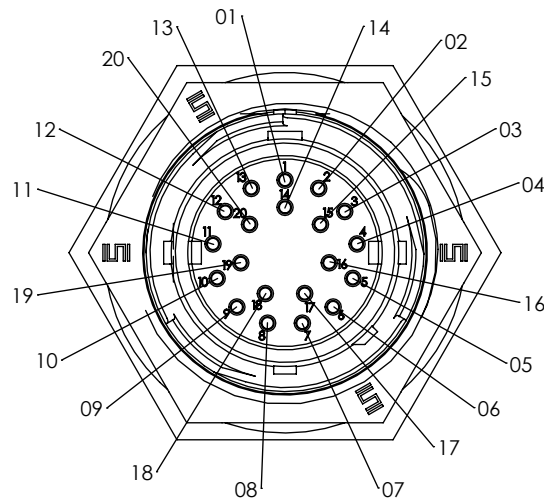
BY: CLAY W

9/8/2010

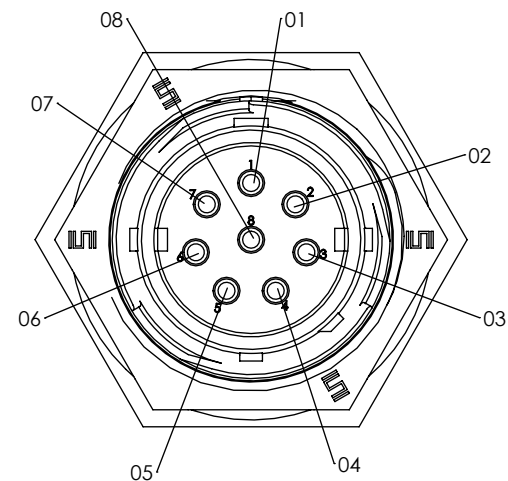
SHEET 1 OF 8



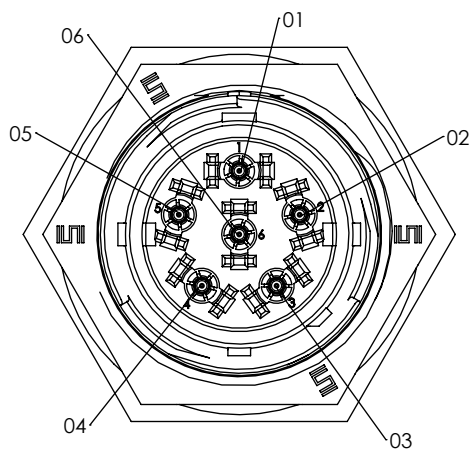
-01: 30 POS
(Ø 1.0 TERMINALS)



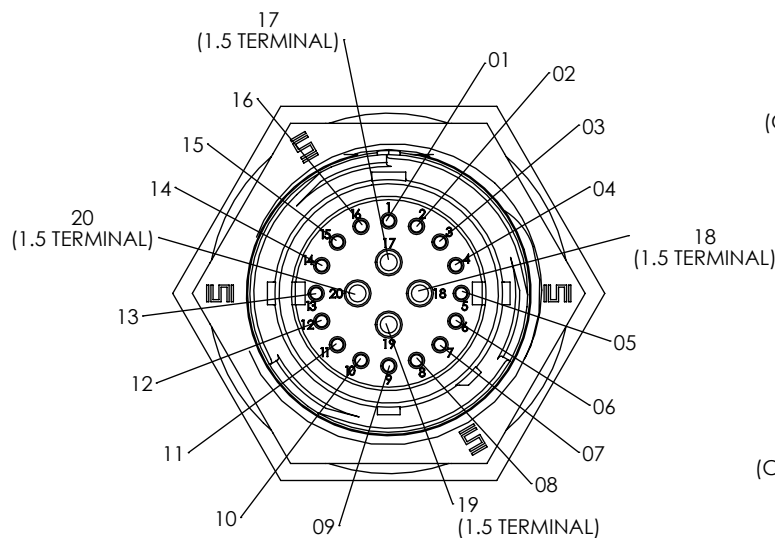
-02: 20 POS
(Ø 1.0 TERMINALS)



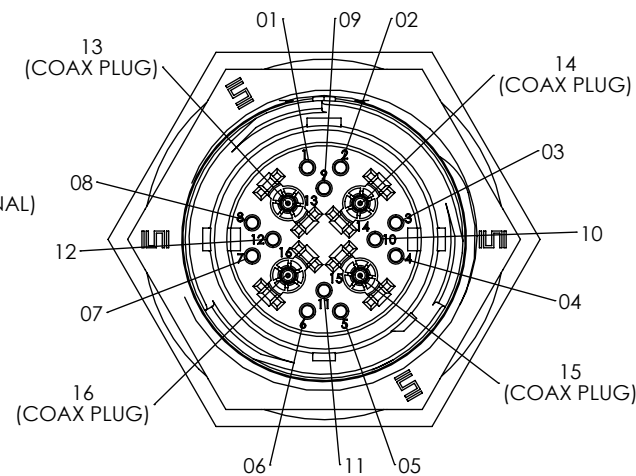
-03: 8 POS
(Ø 1.5 TERMINALS)



-04: 6 POS
(COAX PLUGS)



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



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

-T END OPTIONS

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SHEET SCALE: 1.5:1

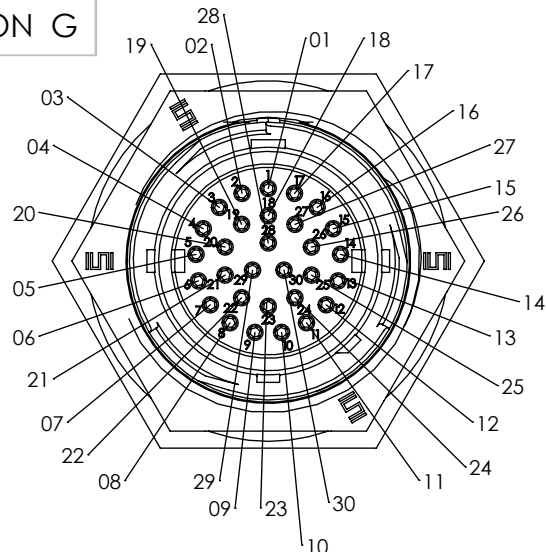
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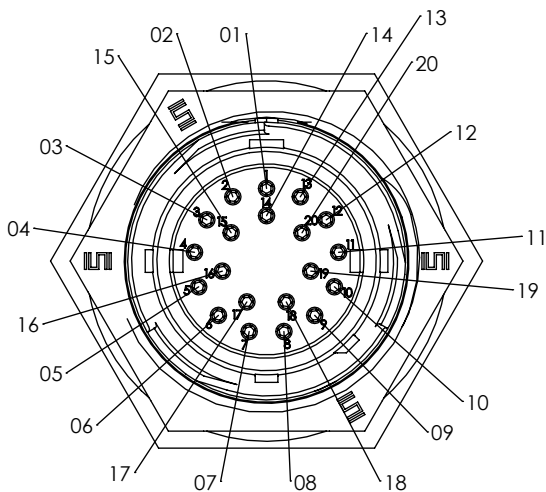
DESCRIPTION:
M22 CABLE ASSEMBLY

DWG. NO.
ACR-22-XX-X-XX.XX-X-XX-P-X

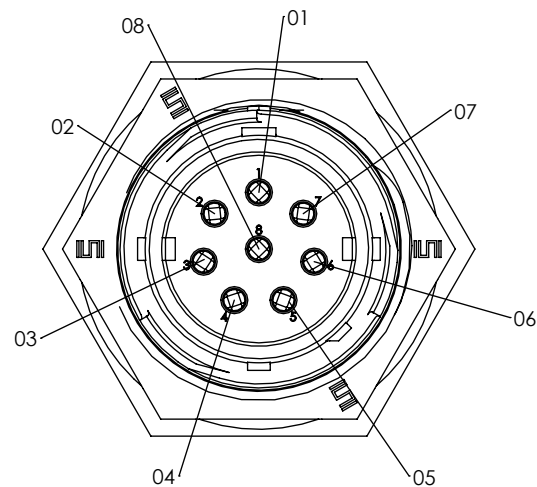
BY: CLAY W 9/8/2010 SHEET 2 OF 8



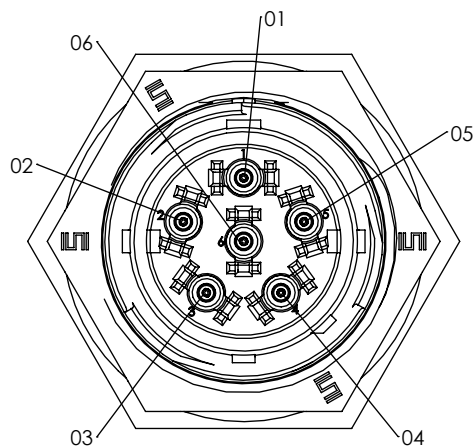
-01: 30 POS
($\varnothing$ 1.0 SOCKETS)



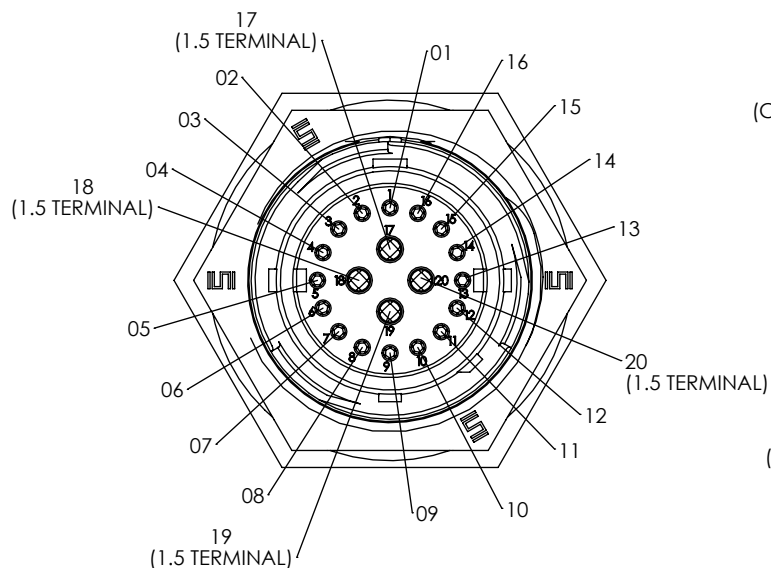
-02: 20 POS
($\varnothing$ 1.0 SOCKETS)



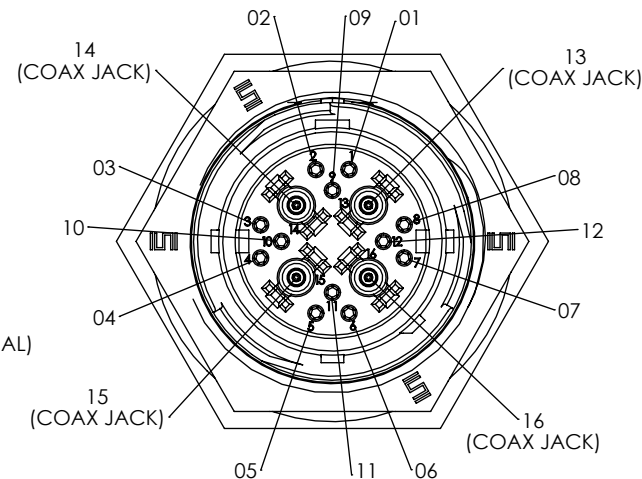
-03: 8 POS
($\varnothing$ 1.5 SOCKETS)



-04: 6 POS
(COAX JACK)



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



-06: 16 POS COMBO
4 X COAX JACK
12 X 1.0 SOCKETS

-S END OPTIONS

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SHEET SCALE: 1.5:1

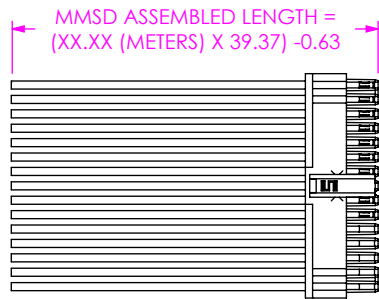
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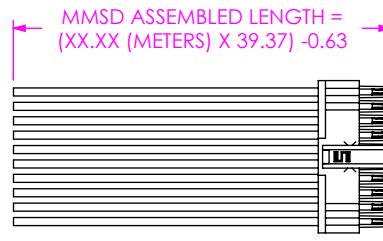
DESCRIPTION:
M22 CABLE ASSEMBLY

DWG. NO.
ACR-22-XX-X-XX.XX-X-XX-P-X

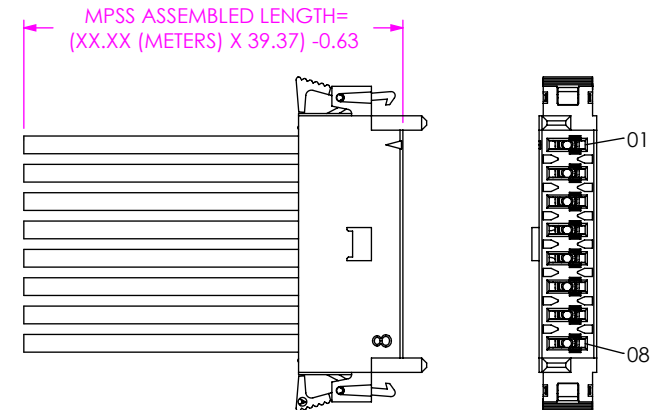
BY: CLAY W 9/8/2010 SHEET 3 OF 8



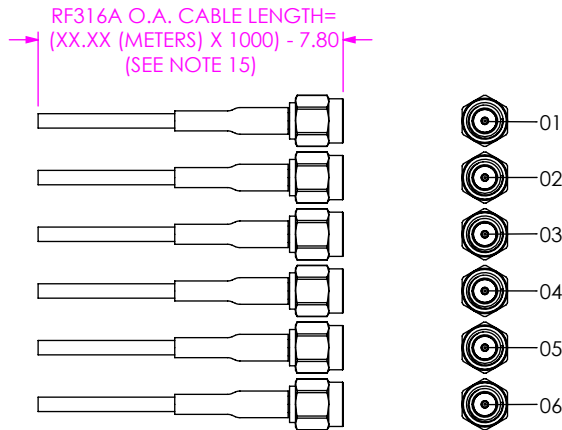
-01: 30 POS
(MMSD-15-24-L-XX.XX-S-K)



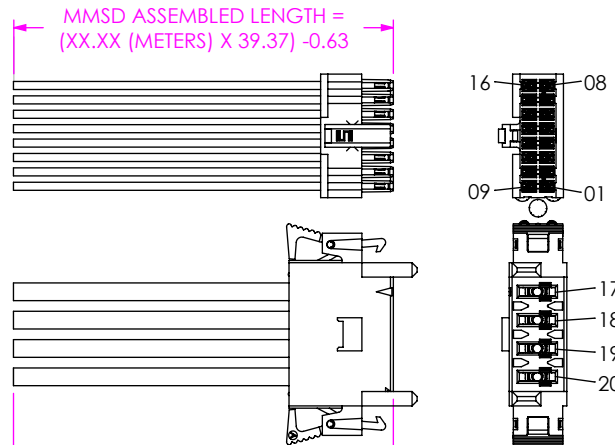
-02: 20 POS
(MMSD-10-24-L-XX.XX-S-K)



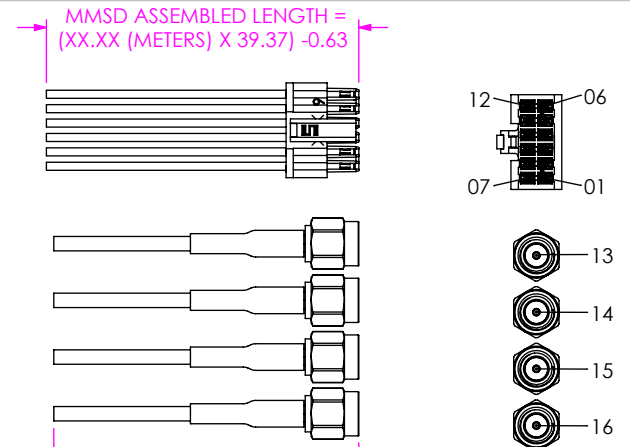
-03: 8 POS
(MPSS-08-16-L-XX.XX-SR)



-04: 6 POS
(6 X RF316A-01SP1-SING-XXXX)



-05: 20 POS COMBO
(1 X MMSD-08-24-L-XX.XX-S-K)
(1 X MPSS-04-16-L-XX.XX-SR)



-06: 16 POS COMBO
(1 X MMSD-06-24-L-XX.XX-S-K)
(4 X RF316A-01SP1-SING-XXXX)

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DESCRIPTION:
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DWG. NO.
ACR-22-XX-X-XX.XX-X-XX-P-X

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-BC END 2 OPTION
BUILD DOUBLE-ENDED INITIALLY FOR E-TEST
(SEE IN-PROCESS 7)

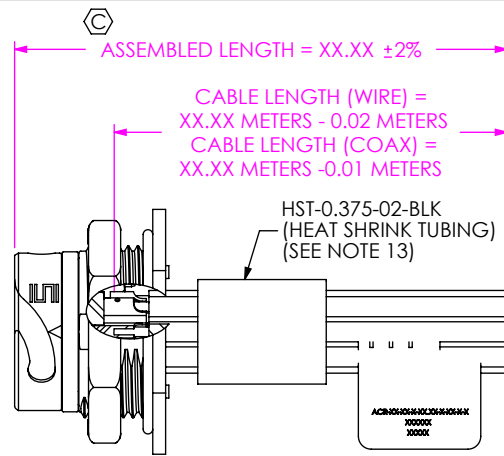


TABLE 2												
LEAD STYLE												
POSITION	-01		-02		-03		-04		-05		-06	
	COLOR	DWC-XX-XX-XXX	COLOR	DWC-XX-XX-XXX	COLOR	DWC-XX-XX-XXX	COLOR	DWC-XX-XX-XXX	COLOR	DWC-XX-XX-XXX	COLOR	DWC-XX-XX-XXX
01	BROWN	DWC-24-01-300	BROWN	DWC-24-01-300	BROWN	DWC-16-01-300	COAX	CCS-174525-01-CC	BROWN	DWC-24-01-300	BROWN	DWC-24-01-300
02	RED	DWC-24-02-300	RED	DWC-24-02-300	RED	DWC-16-02-300	COAX		RED	DWC-24-02-300	RED	DWC-24-02-300
03	ORANGE	DWC-24-03-300	ORANGE	DWC-24-03-300	ORANGE	DWC-16-03-300	COAX		ORANGE	DWC-24-03-300	ORANGE	DWC-24-03-300
04	YELLOW	DWC-24-04-300	YELLOW	DWC-24-04-300	YELLOW	DWC-16-04-300	COAX		YELLOW	DWC-24-04-300	YELLOW	DWC-24-04-300
05	GREEN	DWC-24-05-300	GREEN	DWC-24-05-300	GREEN	DWC-16-05-300	COAX		GREEN	DWC-24-05-300	GREEN	DWC-24-05-300
06	DARK BLUE	DWC-24-06-300	DARK BLUE	DWC-24-06-300	DARK BLUE	DWC-16-06-300	COAX		DARK BLUE	DWC-24-06-300	DARK BLUE	DWC-24-06-300
07	VIOLET	DWC-24-07-300	VIOLET	DWC-24-07-300	VIOLET	DWC-16-07-300			VIOLET	DWC-24-07-300	VIOLET	DWC-24-07-300
08	GRAY	DWC-24-08-300	GRAY	DWC-24-08-300	GRAY	DWC-16-08-300			GRAY	DWC-24-08-300	GRAY	DWC-24-08-300
09	WHITE	DWC-24-09-300	WHITE	DWC-24-09-300					WHITE	DWC-24-09-300	WHITE	DWC-24-09-300
10	BLACK	DWC-24-10-300	BLACK	DWC-24-10-300					BLACK	DWC-24-10-300	BLACK	DWC-24-10-300
11	GREEN / BLACK	DWC-24-11-300	GREEN / BLACK	DWC-24-11-300				NA	GREEN / BLACK	DWC-24-11-300	GREEN / BLACK	DWC-24-11-300
12	TAN	DWC-24-12-300	TAN	DWC-24-12-300					TAN	DWC-24-12-300	TAN	DWC-24-12-300
13	DARK BLUE / YELLOW	DWC-24-31-300	DARK BLUE / YELLOW	DWC-24-31-300					DARK BLUE / YELLOW	DWC-24-31-300	COAX	CCS-174525-01-CC
14	PINK	DWC-24-14-300	PINK	DWC-24-14-300					PINK	DWC-24-14-300	COAX	
15	BROWN / WHITE	DWC-24-15-300	BROWN / WHITE	DWC-24-15-300					BROWN / WHITE	DWC-24-15-300	COAX	
16	RED / WHITE	DWC-24-16-300	RED / WHITE	DWC-24-16-300					RED / WHITE	DWC-24-16-300	COAX	
17	ORANGE / WHITE	DWC-24-17-300	ORANGE / WHITE	DWC-24-17-300					ORANGE / WHITE	DWC-16-17-300		NA
18	YELLOW / WHITE	DWC-24-18-300	YELLOW / WHITE	DWC-24-18-300					YELLOW / WHITE	DWC-16-18-300		
19	GREEN / WHITE	DWC-24-19-300	GREEN / WHITE	DWC-24-19-300					GREEN / WHITE	DWC-16-19-300		
20	DARK BLUE / WHITE	DWC-24-20-300	DARK BLUE / WHITE	DWC-24-20-300					DARK BLUE / WHITE	DWC-16-20-300		
21	VIOLET / WHITE	DWC-24-21-300										NA
22	GRAY / WHITE	DWC-24-22-300										
23	WHITE / BLACK	DWC-24-23-300										
24	BLACK / WHITE	DWC-24-24-300										
25	GREEN / YELLOW	DWC-24-25-300										
26	TAN / WHITE	DWC-24-26-300										
27	DARK BLUE / PINK	DWC-24-27-300										
28	PINK / WHITE	DWC-24-28-300										
29	BROWN / BLACK	DWC-24-29-300										
30	RED / BLACK	DWC-24-30-300										

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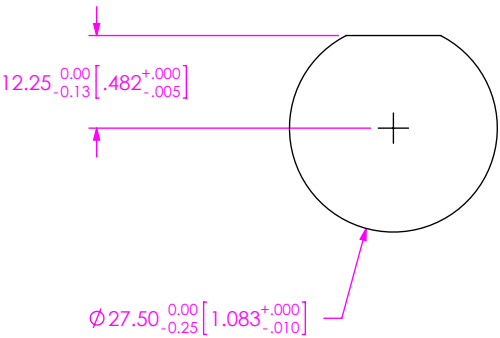
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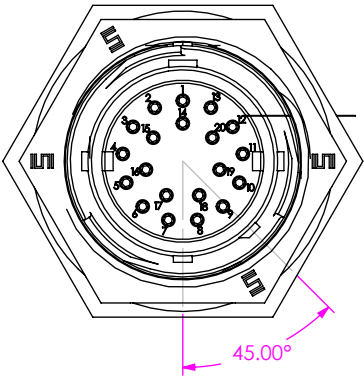
DESCRIPTION:
M22 CABLE ASSEMBLY

DWG. NO.
ACR-22-XX-X-XX.XX-X-XX-P-X

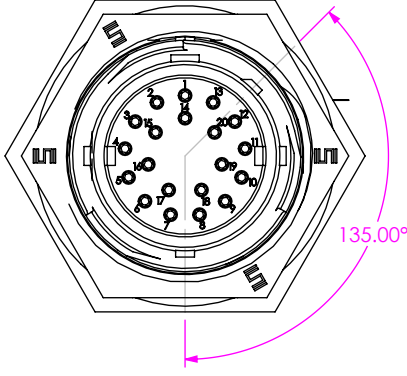
BY: CLAY W 9/8/2010 SHEET 5 OF 8



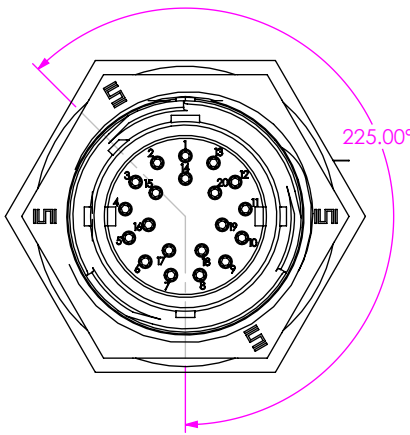
RECOMMENDED PANEL OPENING
(SEE NOTE 8)



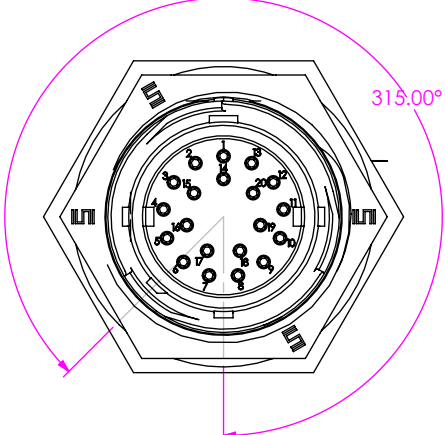
-1
(ORANGE KEY RING)



-2
(GREEN KEY RING)



-3
(BLUE KEY RING)



-4
(YELLOW KEY RING)

KEYING FEATURE
(SEE NOTE 4)

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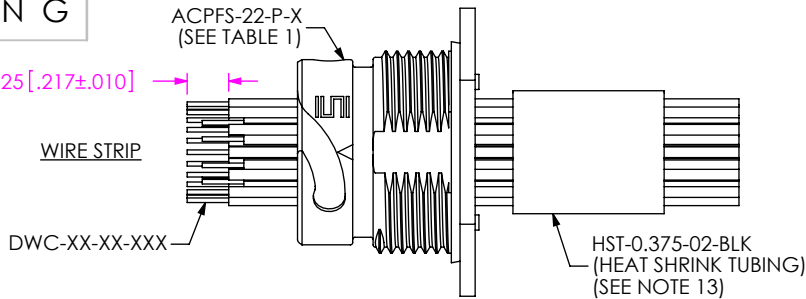
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e-Mail info@SAMTEC.com code 55322

DESCRIPTION: M22 CABLE ASSEMBLY

DWG. NO. ACR-22-XX-X-XX.XX-X-XX-P-X

BY: CLAY W 9/8/2010 SHEET 6 OF 8

5.50±0.25 [.217±.010]



CCA-316 COAX (SEE NOTE 15)

COAX STRIP

REFERENCE AC-P-C-X-ST-CA1 & AC-J-C-X-ST-CA1 PRINTS FOR COAX STRIP DIMENSIONS

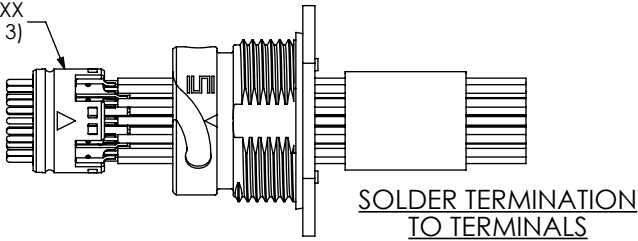
ACPFS-22-P-X (SEE TABLE 1)

IN-PROCESS 1

FEED CABLES FROM END 2 DISCRETE CABLE ASSEMBLY THROUGH HST-0.375-02-BLK & ACPFS-22-P-X, STRIP CABLES TO DIMENSIONS SHOWN AND TIN INNER CONDUCTORS. FOR -BC OPTION, FEED DWC/COAX & STRIP TO DIMENSIONS SHOWN

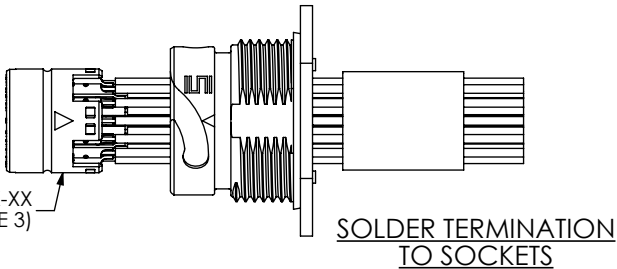
TABLE 1	
KEYING FEATURE	SHELL PART #
-1	ACPFS-22-P-1
-2	ACPFS-22-P-2
-3	ACPFS-22-P-3
-4	ACPFS-22-P-4

SUB-ACTHB-22-X-XX (SEE TABLE 3)



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

SUB-ACSHB-22-X-XX (SEE TABLE 3)



11.80 [.465] REF

SUB-ACTHB-22-X-XX OR ACTHB-22-X (SEE TABLE 3)

3.20^{+0.25}_{-0.13} [.126^{+0.010}_{-.005}]

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

ON LEADSTYLES -01, -02, -03, -05, & -06 SOLDER INNER RING OF TERMINALS/ SOCKETS FIRST AND THEN OUTER RING

15.80 [.622] REF

SUB-ACSHB-22-X-XX OR ACSHB-22-X (SEE TABLE 3)

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

TABLE 3					
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

IN-PROCESS 2

TERMINATE WIRES/COAX TO TERMINALS/SOCKETS (SEE AC-P-C-X-ST-CA1 & AC-J-C-X-ST-CA1 PRINTS FOR COAX TERMINATION)

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DESCRIPTION:

M22 CABLE ASSEMBLY

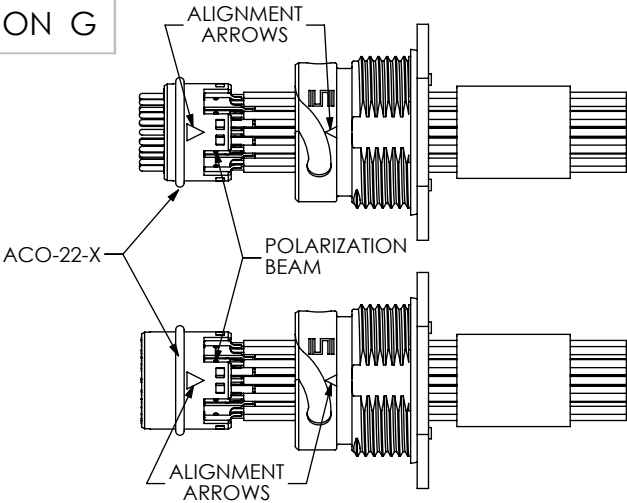
DWG. NO.

ACR-22-XX-X-XX.XX-X-XX-P-X

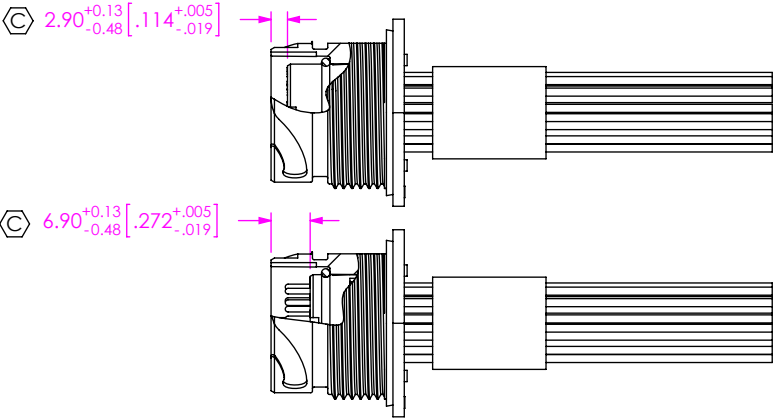
BY: CLAY W

9/8/2010

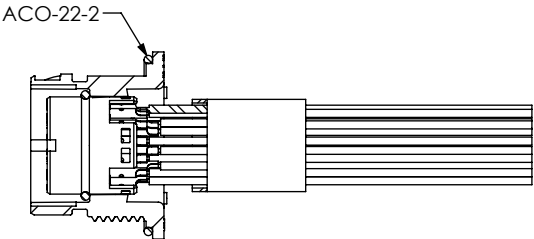
SHEET 7 OF 8



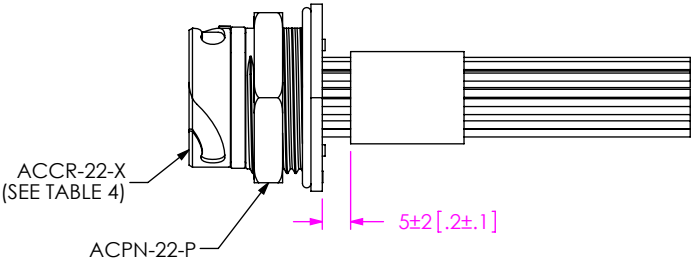
IN-PROCESS 3
PUSH ACO-22-1 ORING ONTO SUB-ACTHB-22-X-X OR SUB-ACSHB-22-X-X SUB-ASSEMBLIES



IN-PROCESS 4
WHILE MAKING SURE ALIGNMENT ARROWS LINE UP TO AID POLARIZATION BEAM ENGAGEMENT, INSERT SUB-ACXHB-22-X SUB-ASSEMBLY INTO ACPFS-22-P-X PANEL SHELL UNTIL SNAP LOCKS ENGAGE

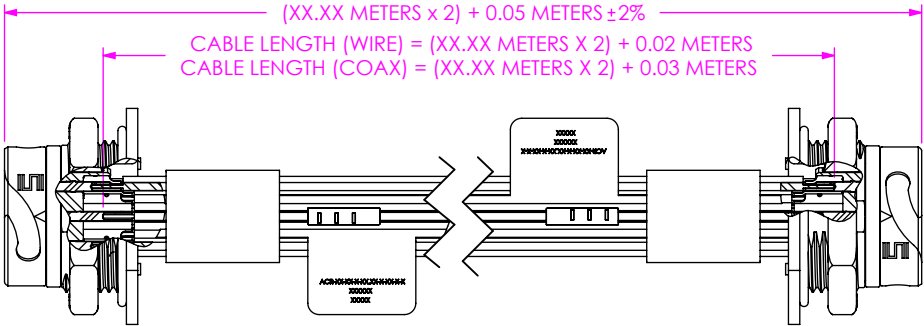


IN-PROCESS 5
INSERT ACO-22-2 WHERE SHOWN



IN-PROCESS 6
THREAD ACPN-22-P ONTO ACPFS-22-P-X
STRETCH ACCR-22-X OVER ACPFS-22-P-X
UNTIL IT SEATS IN GROOVE. ACTIVATE HEAT SHRINK TUBING.

TABLE 4	
KEYING FEATURE	ACCR-22-X
-1 (ORANGE)	ACCR-22-1
-2 (GREEN)	ACCR-22-2
-3 (BLUE)	ACCR-22-3
-4 (YELLOW)	ACCR-22-4



IN-PROCESS 7
(-BC 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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DESCRIPTION:
M22 CABLE ASSEMBLY

DWG. NO.
ACR-22-XX-X-XX.XX-X-XX-P-X

BY: CLAY W 9/8/2010 SHEET 8 OF 8