



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

DO NOT
SCALE FROM
THIS PRINT

ACP-16-XX-X-XX.XX-X-XX-M-X

PLUG

SIZE

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)

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

PLATING

(SEE NOTE 9)

- G: 10u GOLD IN CONTACT AREA
- H: 30u GOLD IN CONTACT AREA

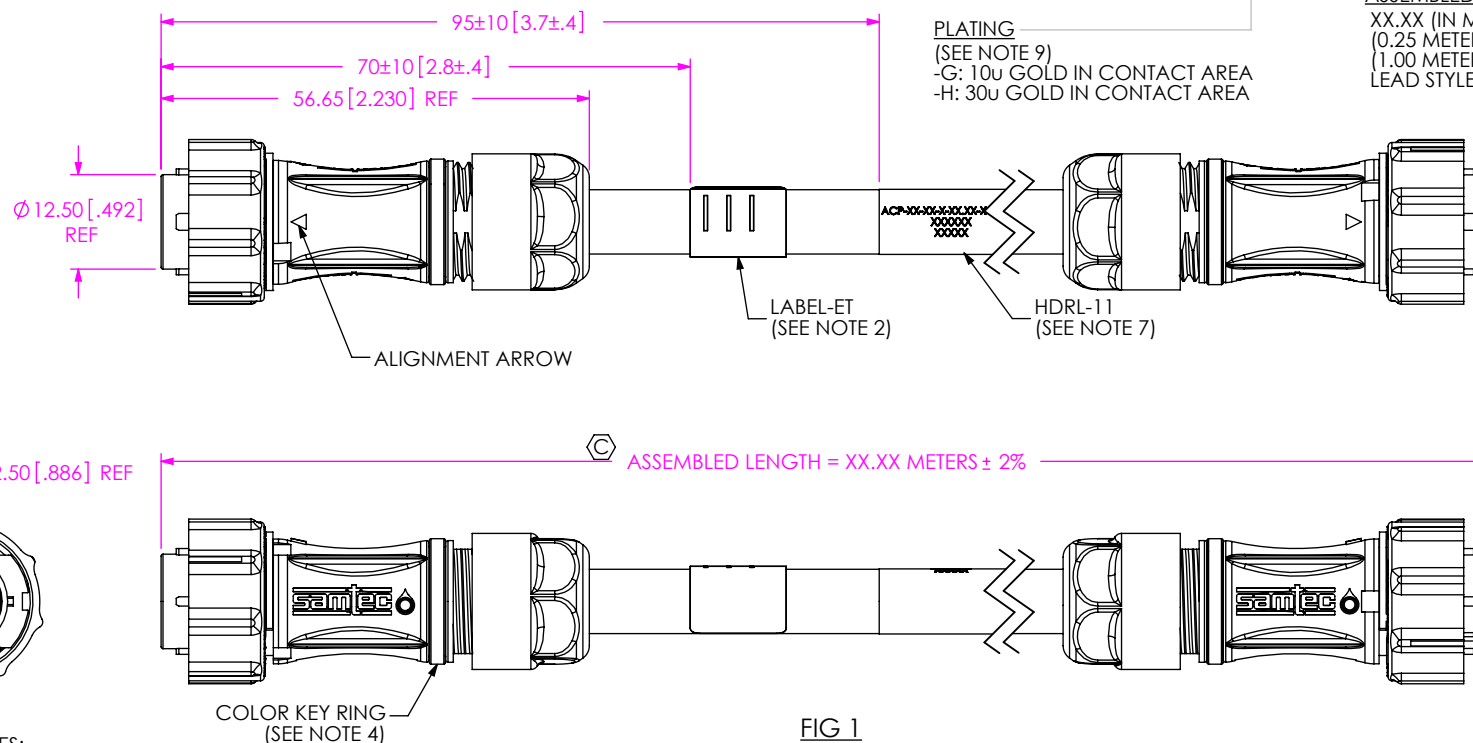


FIG 1
ACP-16-02-X-XX.XX-T-M-1 SHOWN

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].

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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]

MATERIAL:

SHELLS: ZINK ALLOY
INSULATOR: PBT
TERMINALS: BRASS
CONTACTS: BRASS/BeCu

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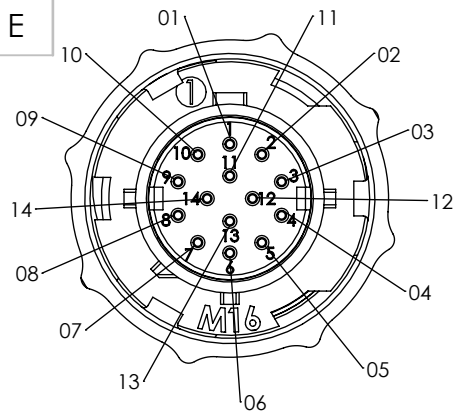
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ACCLIMATE CIRC. CABLE ASSEMBLY

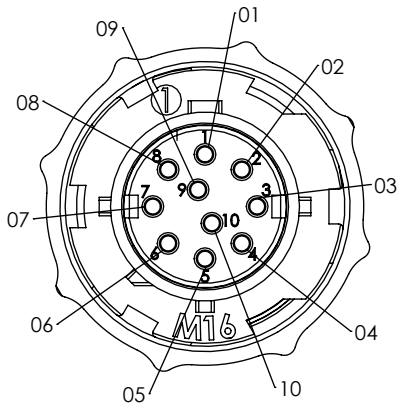
DWG. NO.

ACP-16-XX-X-XX.XX-X-XX-M-X

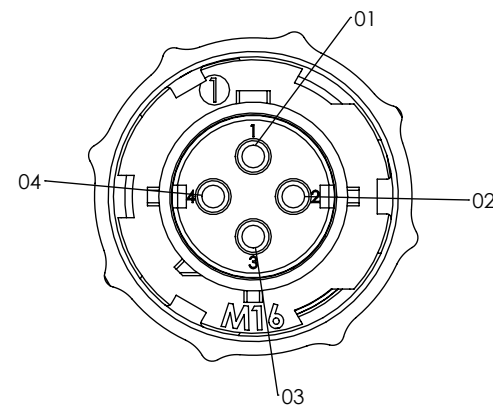
BY: D.SCHMELZ 04/30/2010 SHEET 1 OF 7



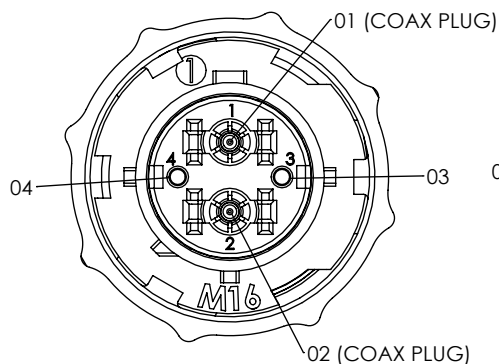
-01: 14 POS
(Ø0.5 TERMINALS)



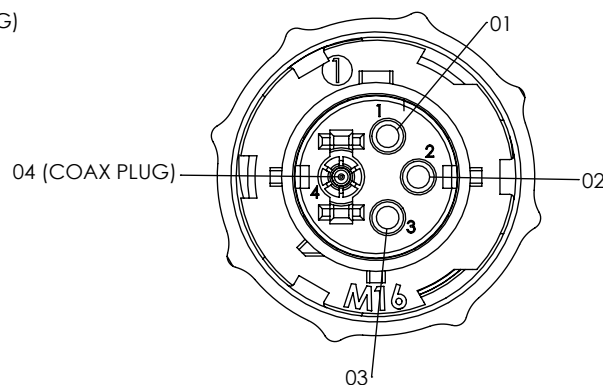
-02: 10 POS
(Ø1.0 TERMINALS)



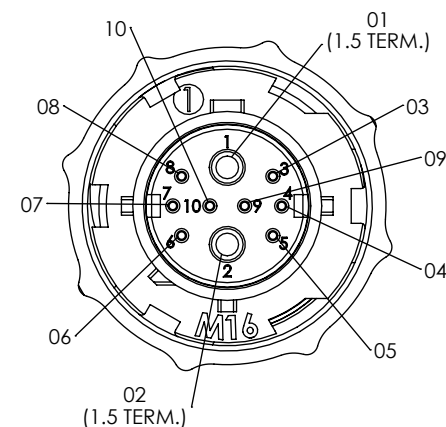
-03: 4 POS
(Ø1.5 TERMINALS)



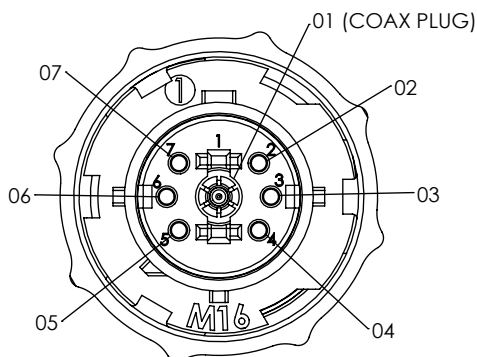
-04: 4 POS COMBO
(2 X COAX PLUGS)
(2 X Ø1.0 TERMINALS)



-05: 4 POS COMBO
(3 X Ø1.5 TERMINALS)
(1 X COAX PLUG)



-06: 10 POS COMBO
(2 X Ø1.5 TERMINALS)
(8 X Ø0.5 TERMINALS)



-07: 7 POS COMBO
(1 X COAX PLUG)
(6 X Ø1.0 TERMINALS)

-T END OPTIONS

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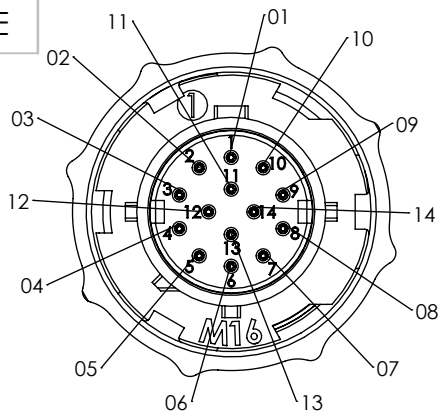
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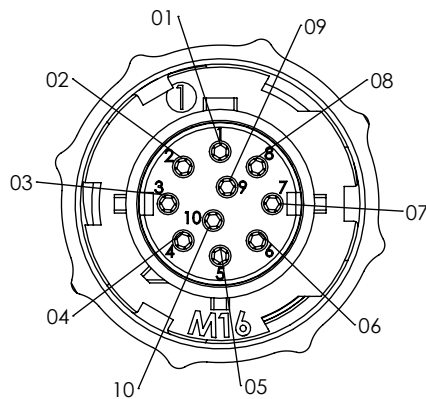
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DWG. NO. ACP-16-XX-X-XX.XX-X-XX-M-X

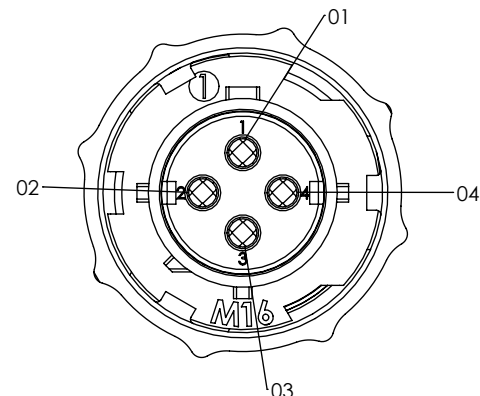
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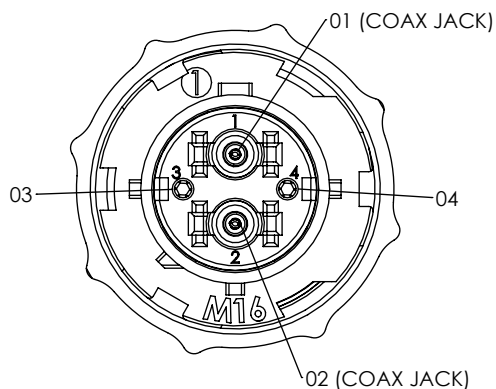
-01: 14 POS
(Ø0.5 SOCKETS)



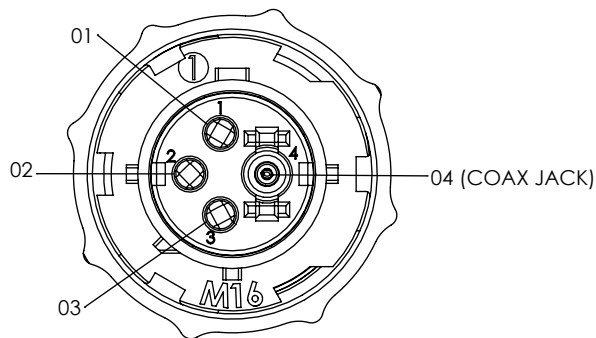
-02: 10 POS
(Ø1.0 SOCKETS)



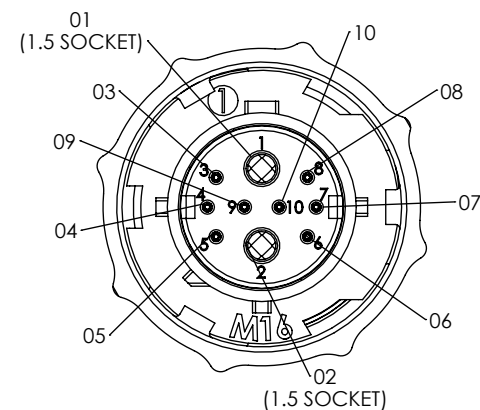
-03: 4 POS
(Ø1.5 SOCKETS)



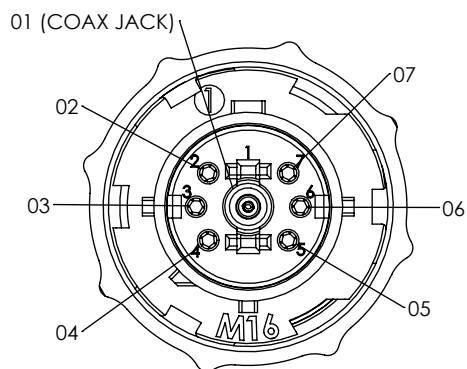
-04: 4 POS COMBO
(2 COAX JACKS)
(2 X Ø1.0 SOCKETS)



-05: 4 POS COMBO
(3 X Ø1.5 SOCKETS)
(1 X COAX JACK)



-06: 10 POS COMBO
(2 X Ø1.5 SOCKETS)
(8 X Ø0.5 SOCKETS)



-07: 7 POS COMBO
(1 X COAX JACK)
(6 X Ø1.0 SOCKETS)

-S END OPTIONS

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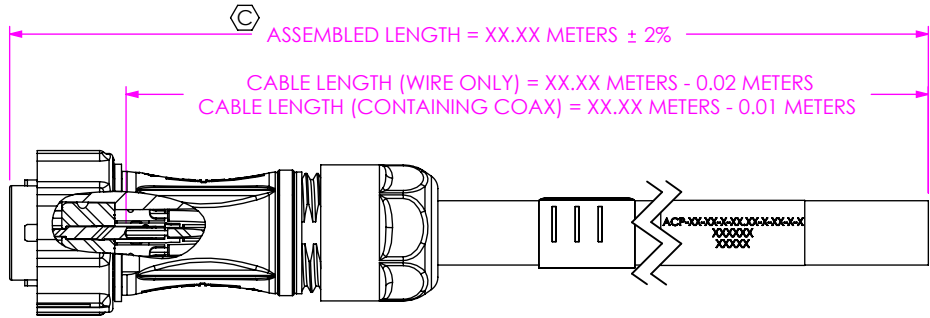
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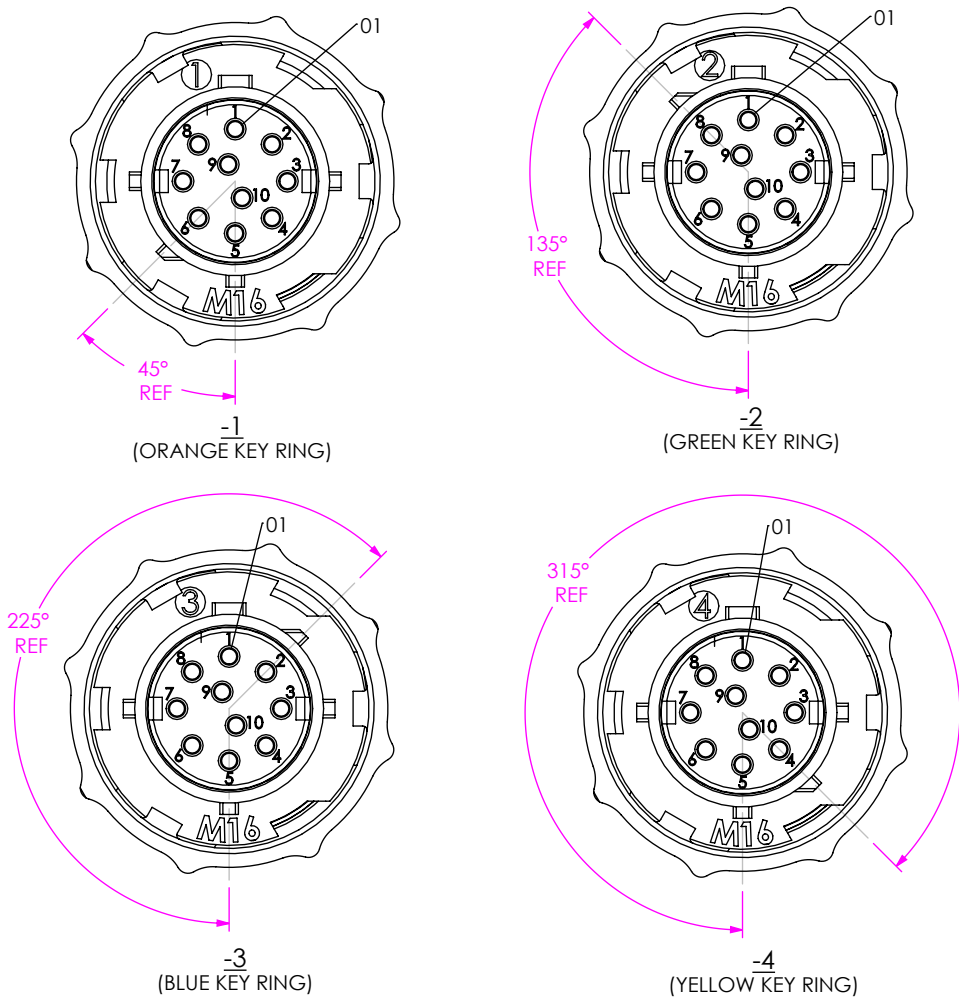
DESCRIPTION: ACCLIMATE CIRC. CABLE ASSEMBLY

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

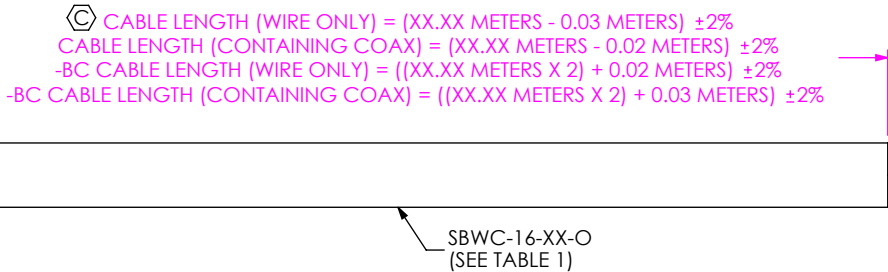
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-BC END OPTION
ACP-16-02-X-XX.XX-T-BC-M-1 SHOWN



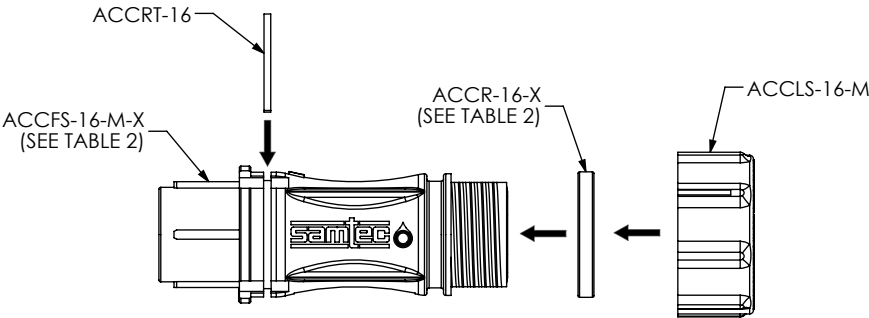
KEYING FEATURE
(SEE NOTE 4)



IN-PROCESS 1
CUT SBWC CABLE TO LENGTH SHOWN

TABLE 1	
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

TABLE 2		
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



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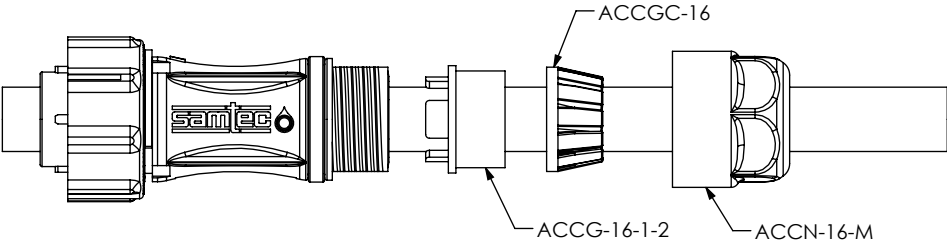
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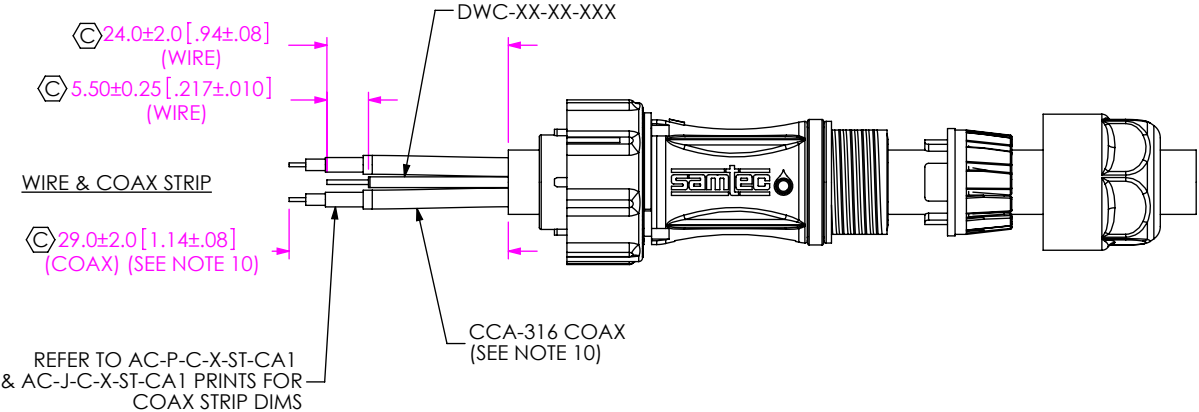
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DWG. NO.
ACP-16-XX-X-XX.XX-X-XX-M-X

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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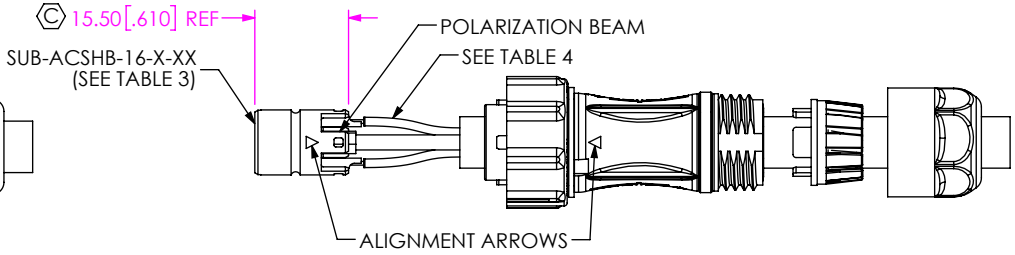
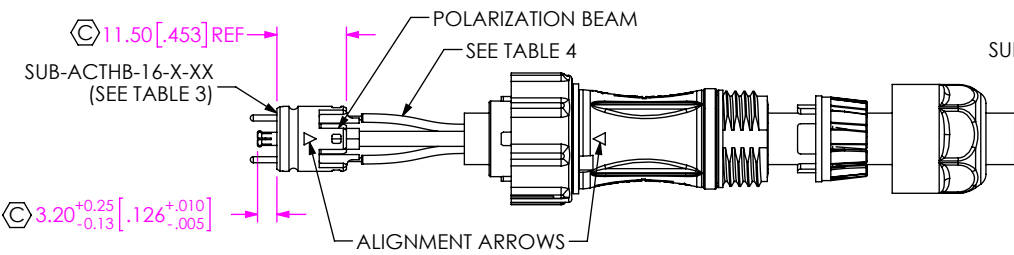
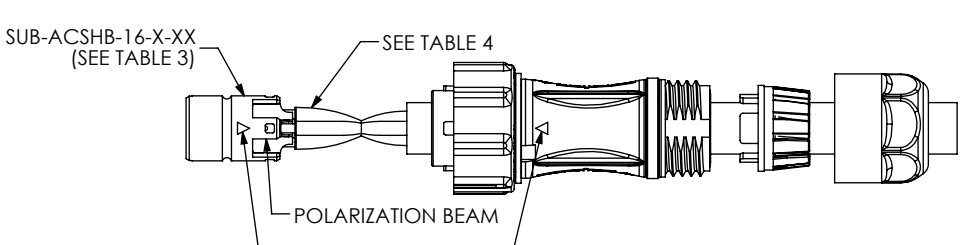
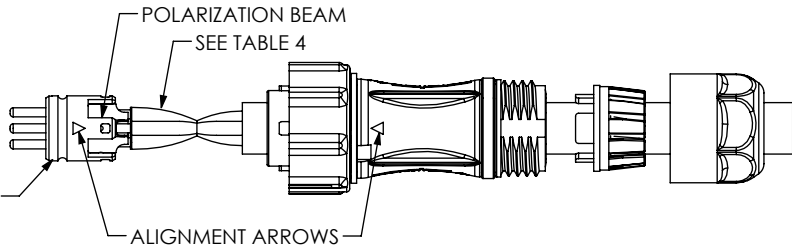


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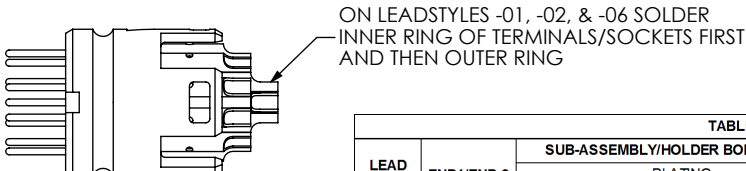
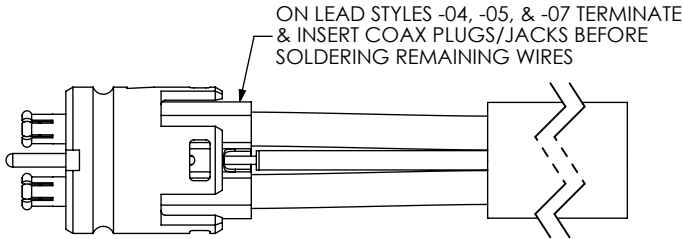
DWG. NO.
ACP-16-XX-X-XX.XX-X-XX-M-X

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



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)

TABLE 4										
WIRE COLOR										
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	NA	NA	NA	GREEN	GREEN			
06	DARK BLUE	DARK BLUE				DARK BLUE	DARK BLUE			
07	VIOLET	VIOLET				VIOLET	VIOLET			
08	GRAY	GRAY				GRAY	NA			
09	WHITE	WHITE				WHITE				
10	BLACK	BLACK				BLACK				
11	GREEN / BLACK	NA								
12	TAN									
13	DARK BLUE / YELLOW									
14	PINK									

TABLE 3					
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-ACSHB-16-G-01	SUB-ACSHB-16-H-01	NA	
-02	-T	SUB-ACSHB-16-G-02	SUB-ACSHB-16-H-02	NA	
-03	-T	SUB-ACSHB-16-G-03	SUB-ACSHB-16-H-03	NA	
-04	-T	SUB-ACSHB-16-G-04	SUB-ACSHB-16-H-04	AC-P-C-H-ST-CA1	2
-05	-T	SUB-ACSHB-16-G-05	SUB-ACSHB-16-H-05	AC-P-C-H-ST-CA1	1
-06	-T	SUB-ACSHB-16-G-06	SUB-ACSHB-16-H-06	NA	
-07	-T	SUB-ACSHB-16-G-07	SUB-ACSHB-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

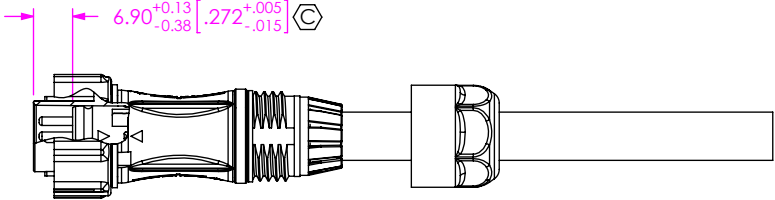
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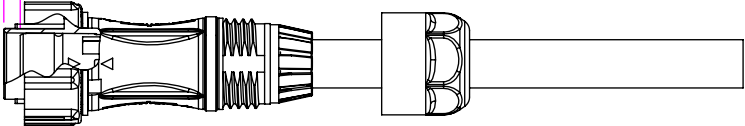
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SHEET SCALE: 1:1

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)

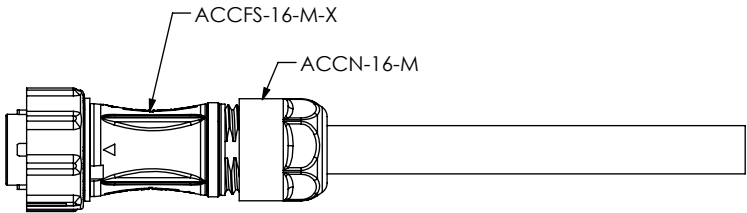
2.90 +0.13/-0.38 [.114 +.005/-0.015]



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

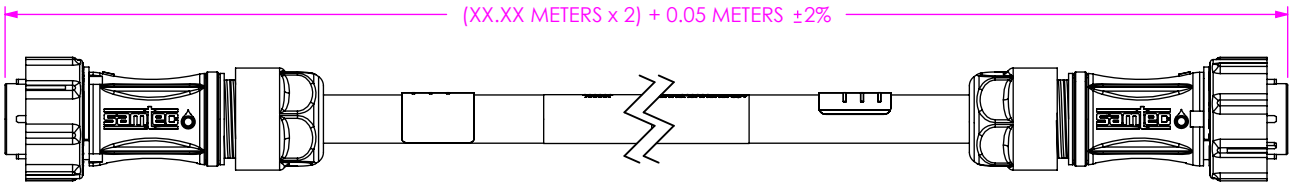
IN-PROCESS 6

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

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SHEET SCALE: 1:1



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