

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

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THIS PRINT

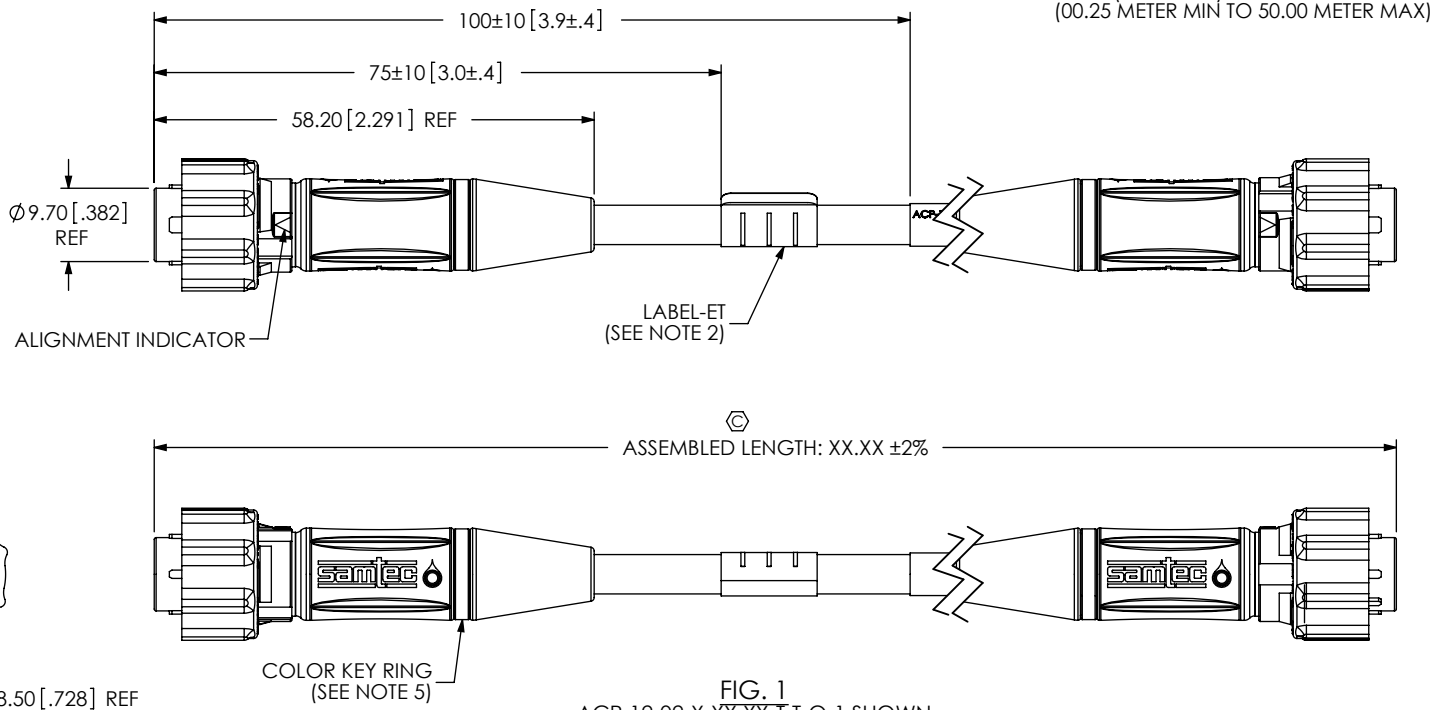


FIG. 1
ACP-12-02-X-XX.XX-T-O-1 SHOWN

NOTES:

1. C 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. SAMTEC LOGO SHALL APPEAR AT TWO EQUALLY SPACED LOCATIONS ON SURFACE SHOWN, APPROXIMATELY 16.33[.643] x 3.96[.156] x 0.20[.008] DEEP.
4. ASSEMBLIES TO BE BULK PACKAGED.
5. KEYING FEATURE DETERMINES COLOR OF KEY RING AND DUSTCAP LANYARD IF APPLICABLE.
6. SIGNAL MAPPING IS 1 TO 1, 2 TO 2, 3 TO 3, etc..
7. REFER TO DCA-ACP-12-P-X PRINT FOR DUST CAP.
8. PLACE HDRL-11 (LABEL) ON CABLE WHERE SHOWN. LABEL TO CONTAIN:
LINE 1 - PART NUMBER "ACP-12-XX-X-XX.XX-X-XX-O-X"
LINE 2 - SHOP ORDER NUMBER "XXXXXX"
LINE 3 - DATE CODE "XXXXXX"
9. ASSEMBLY TO BE 100% TESTED FOR CONTINUITY, ISOLATION, & HI-POT AT 300V BEFORE OVERMOLDING.
10. ORIENTATION OF END 1 AND END 2 MAY VARY.
11. PARTS TO BE BUILT & INSPECTED TO IPC-A-620 CLASS 2.

c:\enterprise\va\DWG\MISC\MKTG\ACP-12-XX-X-XX.XX-X-XX-O-X-MKT.SLDDRW

ACP-12-XX-X-XX.XX-X-XX-O-X

SIZE

LEAD STYLE

- 01: 4 POS (1.0 TERM/SKT), 24 AWG
- 02: 5 POS (1.0 TERM/SKT), 24 AWG
- 03: 6 POS (0.5 TERM/SKT), 28 AWG
- 04: 8 POS (0.5 TERM/SKT), 28 AWG
- 05: 6 POS COMBO (2x1.0 TERM/SKT), 24 AWG (4x0.5 TERM/SKT), 28 AWG

PLATING

- G: 10µ" GOLD IN CONTACT AREA
- H: 30µ" GOLD IN CONTACT AREA

ASSEMBLED LENGTH
XX.XX (IN METERS)

(00.25 METER MIN TO 50.00 METER MAX)

KEYING FEATURE
(SEE NOTE 5)(SEE SHEET 2)

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

STYLE

-O: OVERMOLDED PLASTIC

END 2

- T: TERMINAL
- S: SOCKET
- BC: BLUNT CUT

END 1

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

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
SHELL/LOCKING SLEEVE: NYLON, COLOR: BLACK
INSULATOR: PBT, COLOR: BLACK
OVERMOLD: MD-NYL-ZY-70G13-BK
PREMOLD: MD-NYL-MA-OM646-BK
TERMINALS: BRASS
CONTACTS: BRASS/BeCu
MAX FLASH ALLOWED: 0.05 [.002]
MAX GATE VESTIGE: 0.05 [.002]

SHEET SCALE: 1:1

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DESCRIPTION:

ACCLIMATE CIRC. CABLE ASSEMBLY

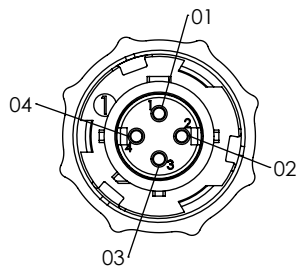
DWG. NO.

ACP-12-XX-X-XX.XX-X-XX-O-X

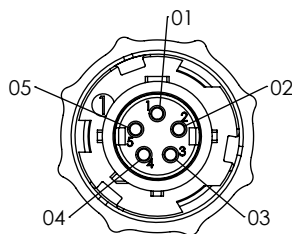
BY: D.SCHMELZ 09/17/2010 SHEET 1 OF 5

-T END OPTIONS

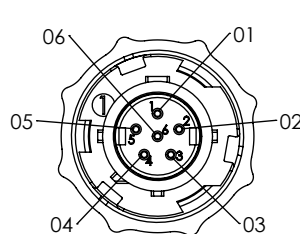
-01: 4 POS
Ø1.0 TERMINALS



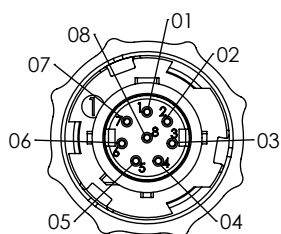
-02: 5 POS
Ø1.0 TERMINALS



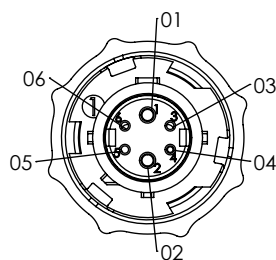
-03: 6 POS
Ø0.5 TERMINALS



-04: 8 POS
Ø0.5 TERMINALS

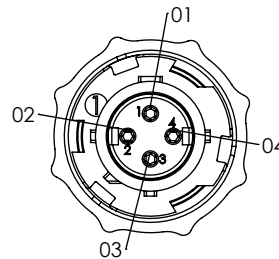


-05: 6 POS COMBO
2xØ1.0 TERMINALS
4xØ0.5 TERMINALS

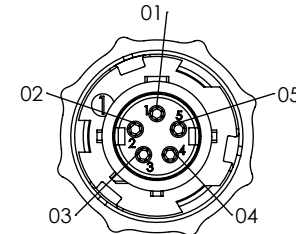


-S END OPTIONS

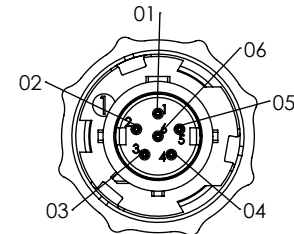
-01: 4 POS
Ø1.0 SOCKET



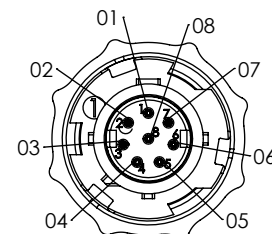
-02: 5 POS
Ø1.0 SOCKET



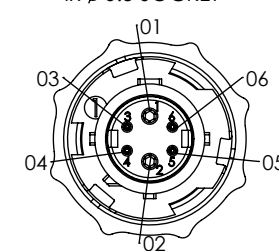
-03: 6 POS
Ø0.5 SOCKET



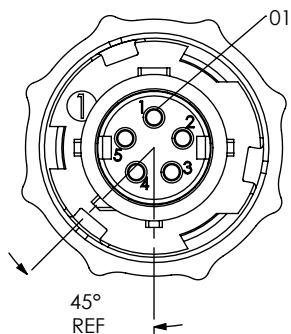
-04: 8 POS
Ø0.5 SOCKET



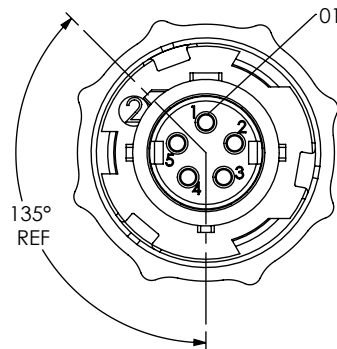
-05: 6 POS COMBO
2xØ1.0 SOCKET
4xØ0.5 SOCKET



-1
ORANGE KEY RING

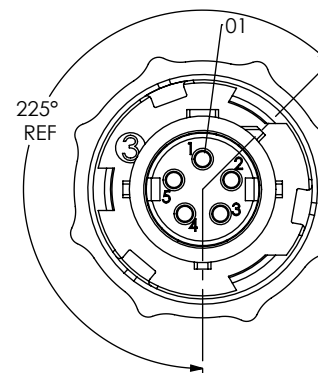


-2
GREEN KEY RING

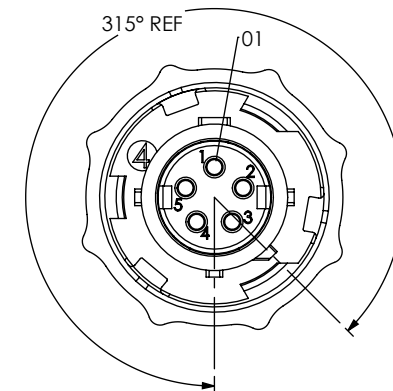


KEYING FEATURE
(SEE NOTE 5)

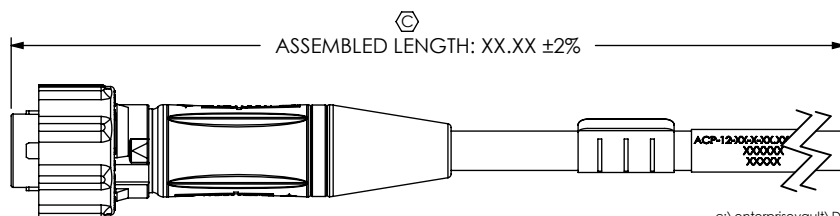
-3
BLUE KEY RING



-4
YELLOW KEY RING



-BC END OPTION
ACP-12-0T-X-XX.XX-T-BC-O-T SHOWN



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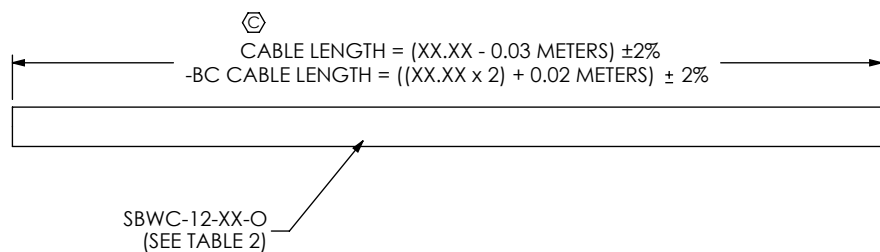
DESCRIPTION: ACCLIMATE CIRC. CABLE ASSEMBLY

DWG. NO. ACP-12-XX-X-XX.XX-X-XX-O-X

BY: D.SCHMELZ 09/17/2010 SHEET 2 OF 5

REVISION A

IN-PROCESS 1 CUT SBWC-12-XX-O TO LENGTH



IN-PROCESS 2 FEED SBWC-12-XX-O BUNDLED CABLE THROUGH ACCR-12-X, ACCLS-12-P, & ACCOS-12-P-X

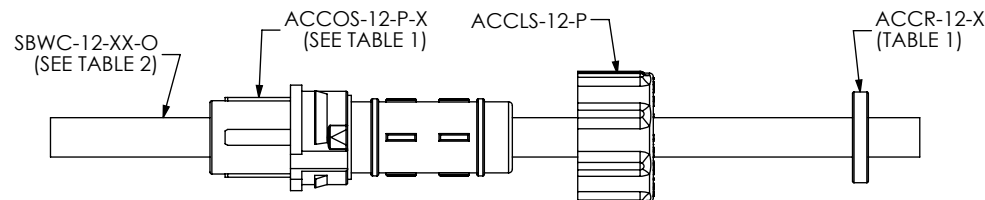


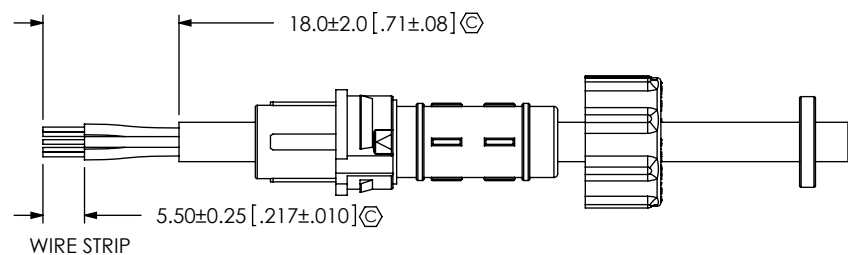
TABLE 1

KEYING FEATURE	SHELL PART #	ACCR-12-X
-1	ACCOS-12-P-1	ACCR-12-1
-2	ACCOS-12-P-2	ACCR-12-2
-3	ACCOS-12-P-3	ACCR-12-3
-4	ACCOS-12-P-4	ACCR-12-4

TABLE 2

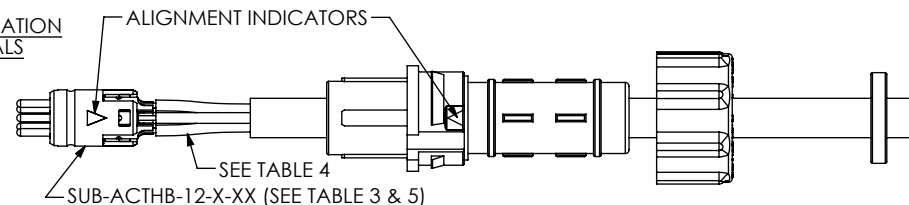
LEAD STYLES	SBWC PART #
-01	SBWC-12-01-O
-02	SBWC-12-02-O
-03	SBWC-12-03-O
-04	SBWC-12-04-O
-05	SBWC-12-05-O

IN-PROCESS 3 STRIP OUTER JACKET & INNER WIRES TO DIMENSIONS SHOWN



IN-PROCESS 4 TERMINATE WIRES TO TERMINALS/SOCKETS (SEE NOTE 6)

SOLDER TERMINATION
TO TERMINALS



SOLDER TERMINATION
TO SOCKETS

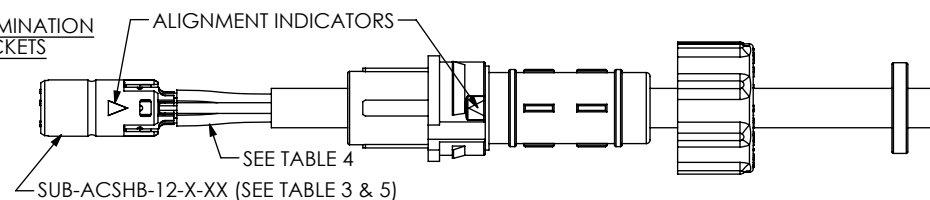


TABLE 5

PLATING	SUB-ACXHB-12-X-XX
-G	SUB-ACXHB-12-G-XX
-H	SUB-ACXHB-12-H-XX

ON LEADSTYLES -03 & -04
SOLDER INNER PIN/SOCKET FIRST
AND THEN OUTER RING

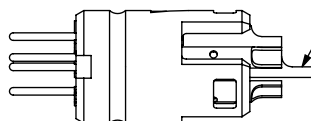


TABLE 3

LEAD STYLE	END1/END 2	SUB-ACXHB-12-X-XX
-01	-T	SUB-ACTHB-12-X-01
-02	-T	SUB-ACTHB-12-X-02
-03	-T	SUB-ACTHB-12-X-03
-04	-T	SUB-ACTHB-12-X-04
-05	-T	SUB-ACTHB-12-X-05
-01	-S	SUB-ACSHB-12-X-01
-02	-S	SUB-ACSHB-12-X-02
-03	-S	SUB-ACSHB-12-X-03
-04	-S	SUB-ACSHB-12-X-04
-05	-S	SUB-ACSHB-12-X-05

TABLE 4

WIRE COLOR					
POSITION	LEAD STYLE				
	-01	-02	-03	-04	-05
01	BROWN	BROWN	BROWN	BROWN	BROWN
02	RED	RED	RED	RED	RED
03	ORANGE	ORANGE	ORANGE	ORANGE	ORANGE
04	YELLOW	YELLOW	YELLOW	YELLOW	YELLOW
05	NA	GREEN	GREEN	GREEN	GREEN
06		NA	BLUE	BLUE	BLUE
07			VIOLET	NA	NA
08					

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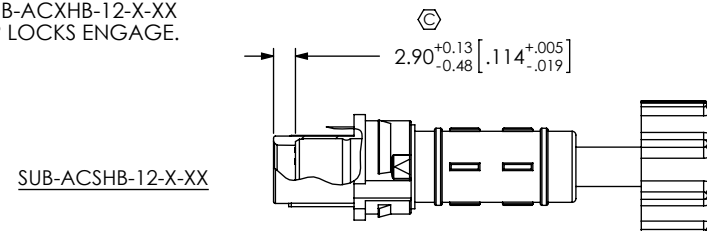
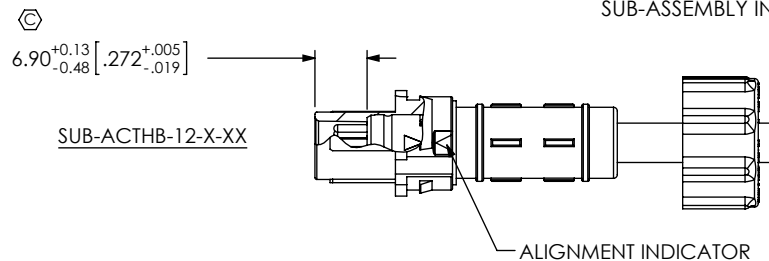
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DWG. NO.

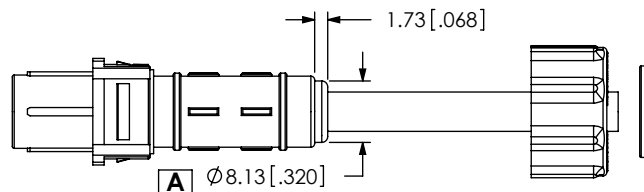
ACP-12-XX-X-XX.XX-X-XX-O-X

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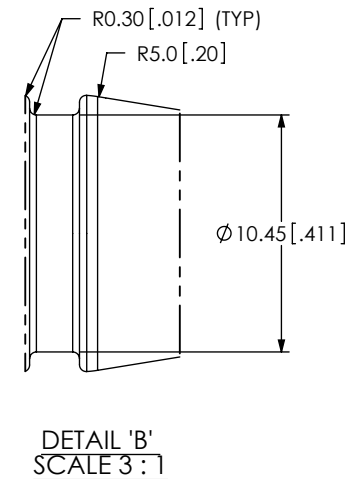
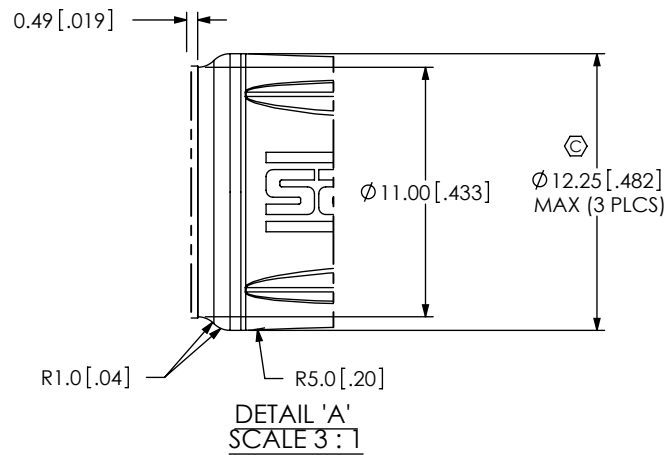
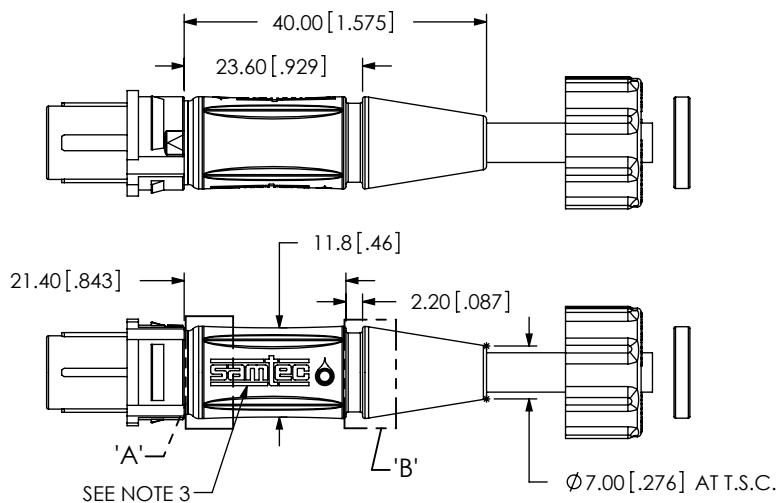
IN-PROCESS 5
WHILE MAKING SURE ALIGNMENT ARROWS LINE UP TO AID
POLARIZATION BEAM ENGAGEMENT, INSERT SUB-ACXHB-12-X-XX
SUB-ASSEMBLY INTO ACCOS-12-P-X UNTIL SNAP LOCKS ENGAGE.
(SEE NOTE 9)



IN-PROCESS 6
PREMOLD



IN-PROCESS 7
APPLY OVERMOLD GRIP



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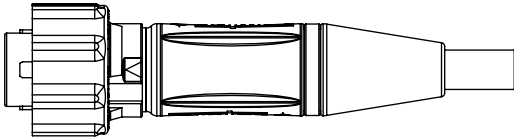
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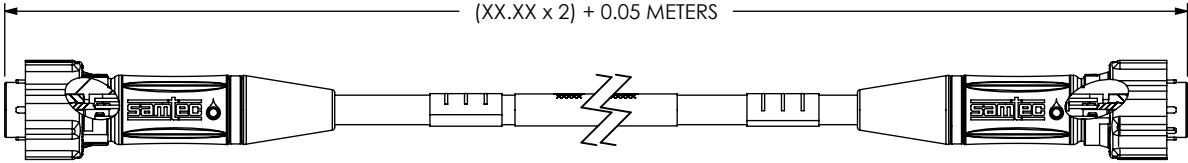
ACP-12-XX-X-XX.XX-X-XX-O-X

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IN-PROCESS 8
PUSH ACCLS-12-L OVER OVERMOLD
AND ACCOS-12-P-X UNTIL IT SNAPS.
STRETCH ACCR-12-X OVER OVERMOLD
UNTIL IT SEATS IN GROOVE.



IN-PROCESS 9
(-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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