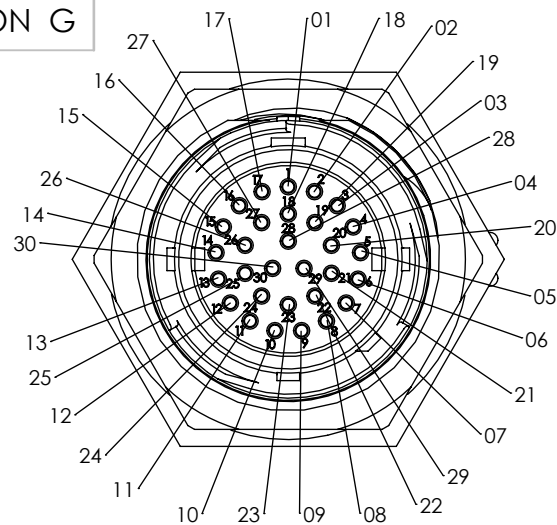
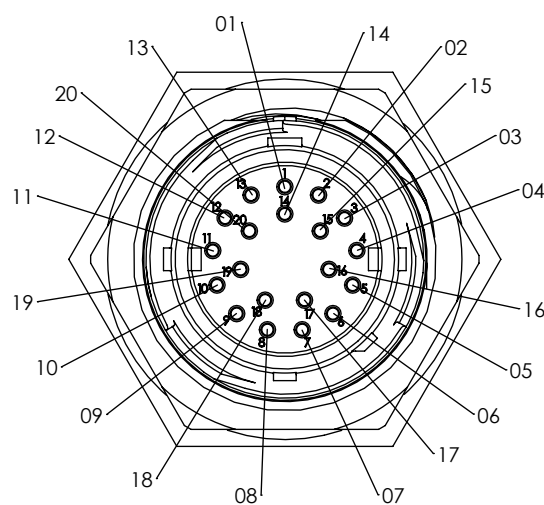
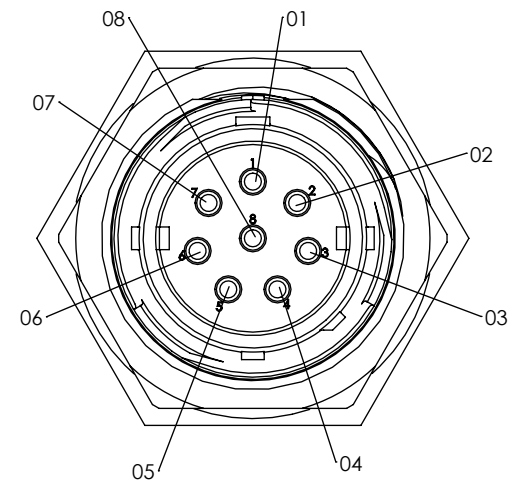




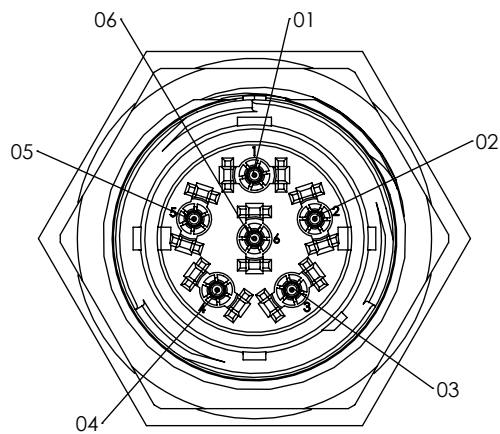
-01: 30 POS
(Ø 1.0 TERMINALS)



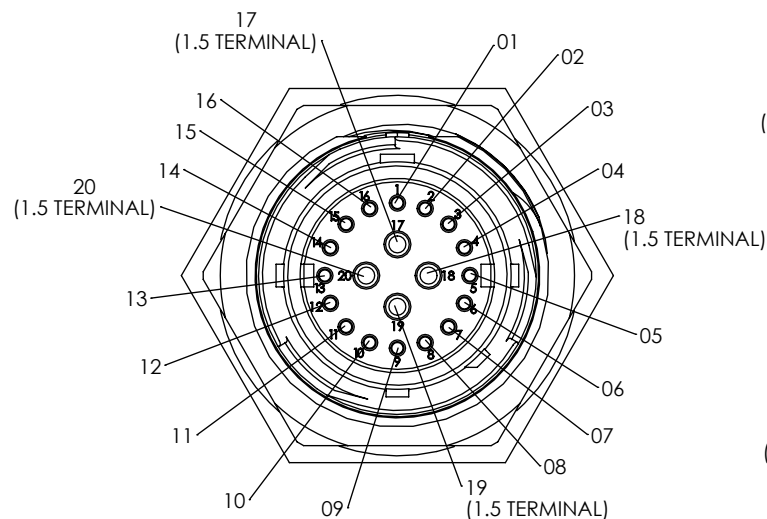
-02: 20 POS
(Ø 1.0 TERMINALS)



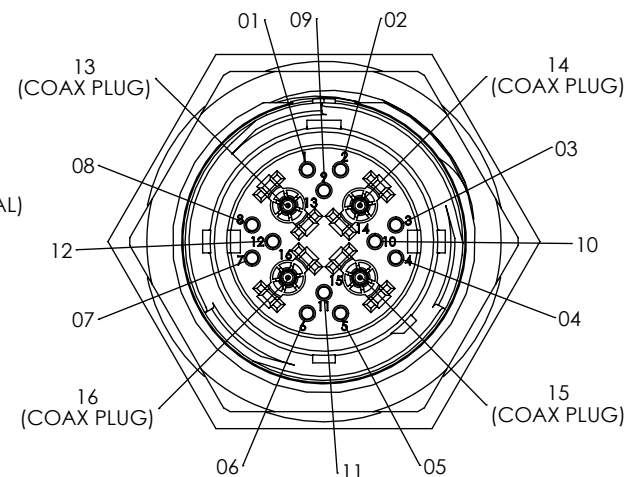
-03: 8 POS
(Ø 1.5 TERMINALS)



-04: 6 POS
(COAX PLUGS)



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



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

-T END OPTIONS

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e-Mail: info@SAMTEC.com code 55322

DESCRIPTION:

M22 CABLE ASSEMBLY

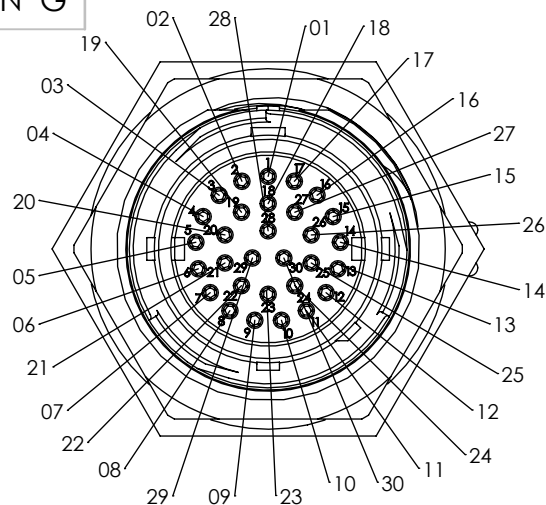
DWG. NO.

ACR-22-XX-X-XX.XX-X-XX-M-X

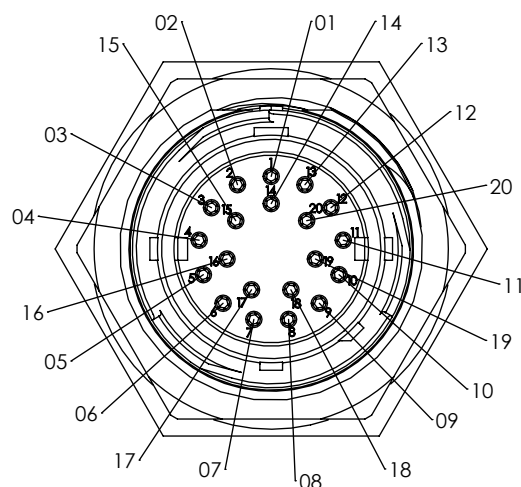
BY: CLAY W

9/8/2010

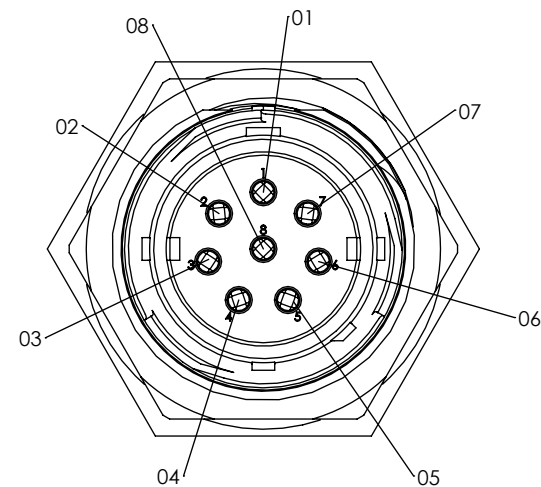
SHEET 2 OF 8



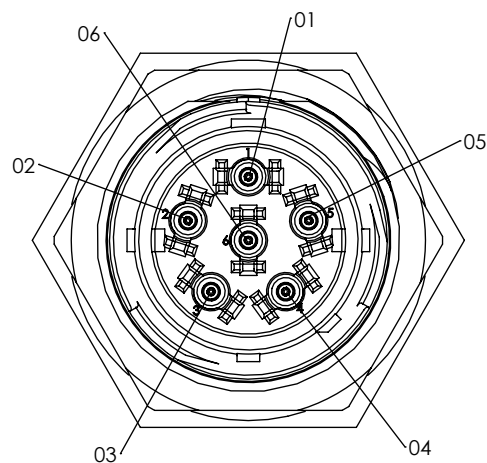
-01: 30 POS
(Ø 1.0 SOCKETS)



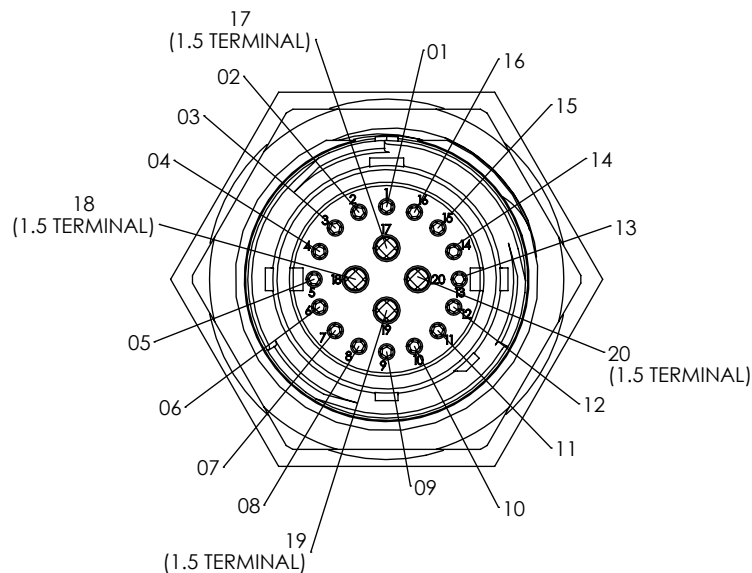
-02: 20 POS
(Ø 1.0 SOCKETS)



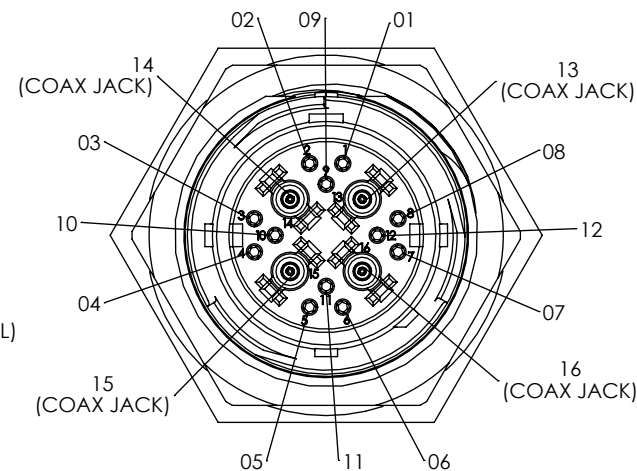
-03: 8 POS
(Ø 1.5 SOCKETS)



-04: 6 POS
(COAX JACKS)



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



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

-S END OPTIONS

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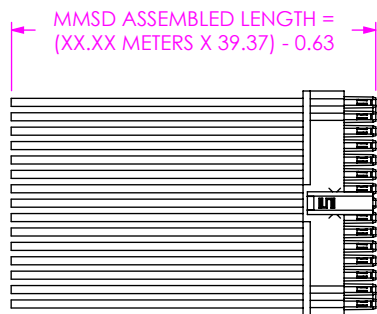
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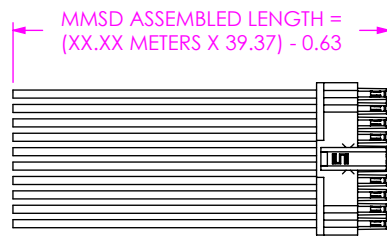
DESCRIPTION:
M22 CABLE ASSEMBLY

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

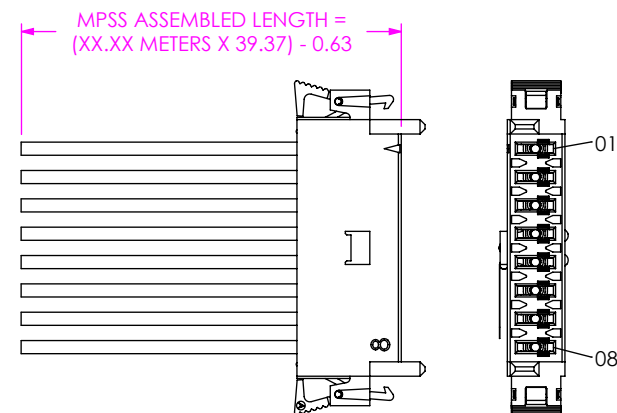
BY: CLAY W 9/8/2010 SHEET 3 OF 8



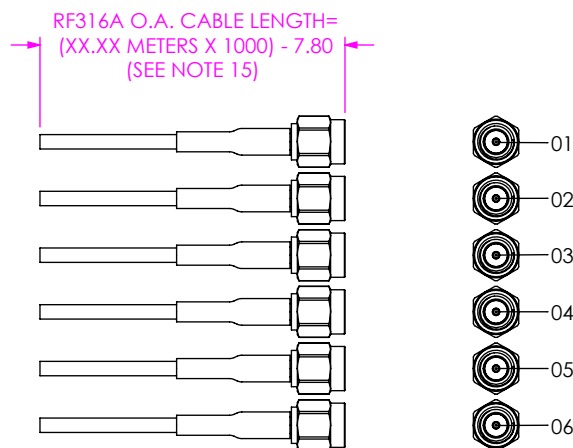
-01: 30 POS
(MMSD-15-24-L-XX.XX-S-K)



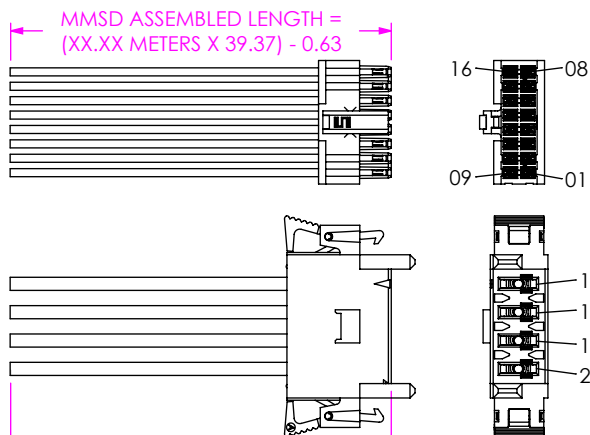
-02: 20 POS
(MMSD-10-24-L-XX.XX-S-K)



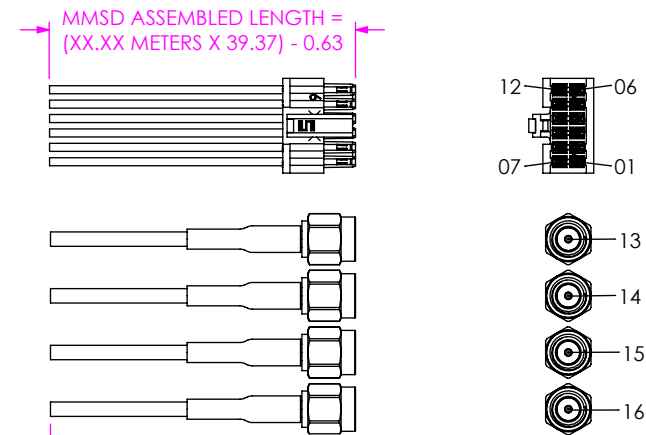
-03: 8 POS
(MPSS-08-16-L-XX.XX-SR)



-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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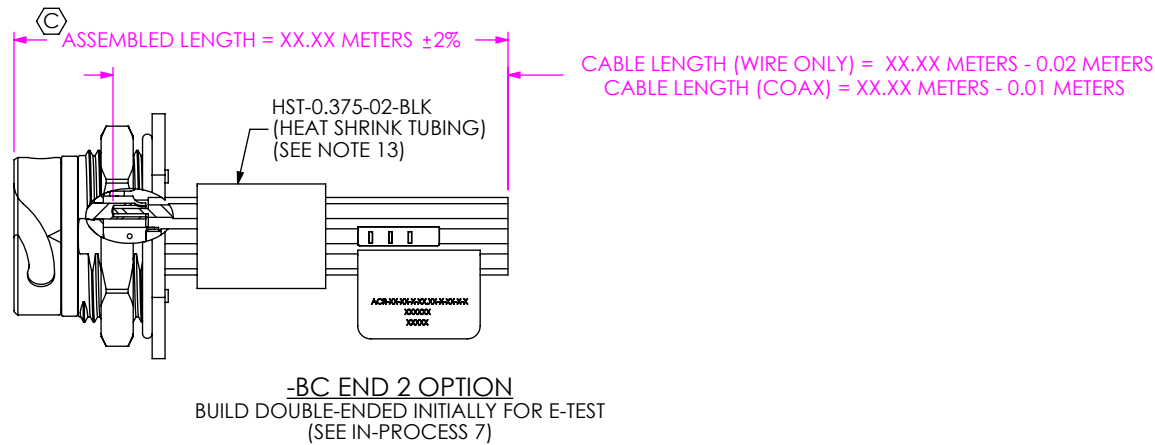


TABLE 2												
LEAD STYLE												
POSITION	-01		-02		-03		-04		-05		-06	
	COLOR	CALLOUT	COLOR	CALLOUT	COLOR	CALLOUT	COLOR	CALLOUT	COLOR	CALLOUT	COLOR	CALLOUT
01	BROWN	DWC-24-01-300	BROWN	DWC-24-01-300	BROWN	DWC-16-01-300	COAX	CCS-174525-01-CC	BROWN	DWC-24-01-300	BROWN	DWC-24-01-300
02	RED	DWC-24-02-300	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	NA	NA	NA	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				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	NA	NA	NA	NA	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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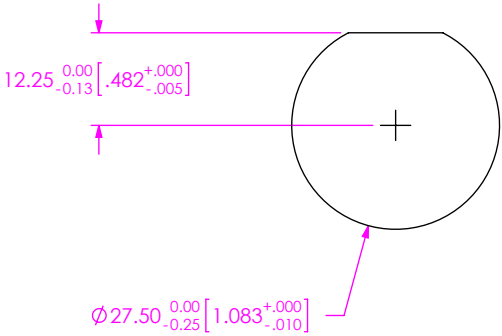
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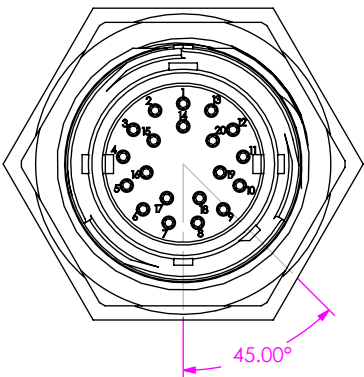
DESCRIPTION:
M22 CABLE ASSEMBLY

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

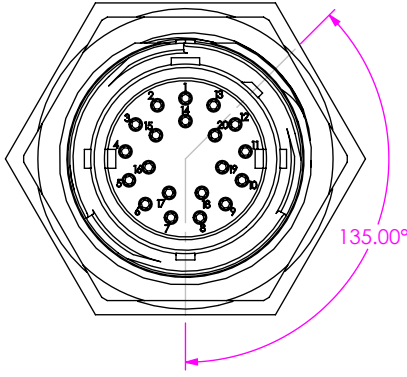
BY: CLAY W 9/8/2010 SHEET 5 OF 8



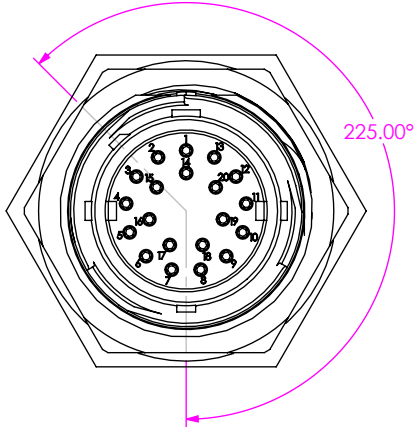
RECOMMENDED PANEL OPENING
(SEE NOTE 8)



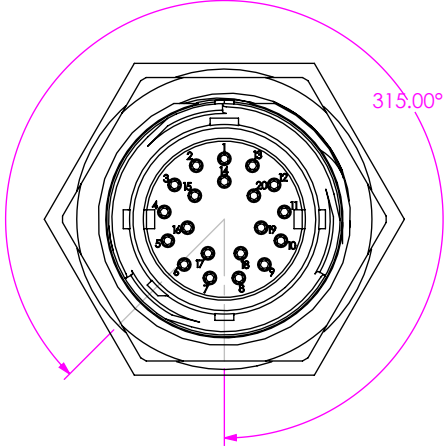
-1
(ORANGE KEY RING)



-2
(GREEN KEY RING)



-3
(BLUE KEY RING)



-4
(YELLOW KEY RING)

KEYING FEATURE
(SEE NOTE 4)

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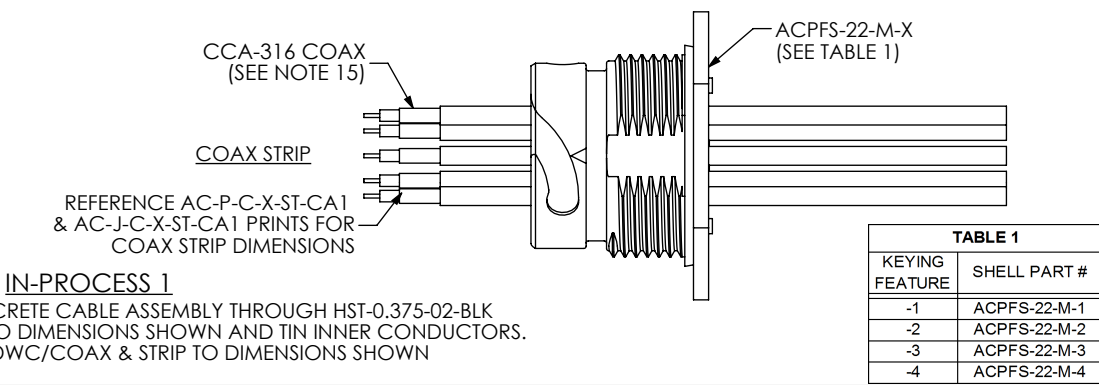
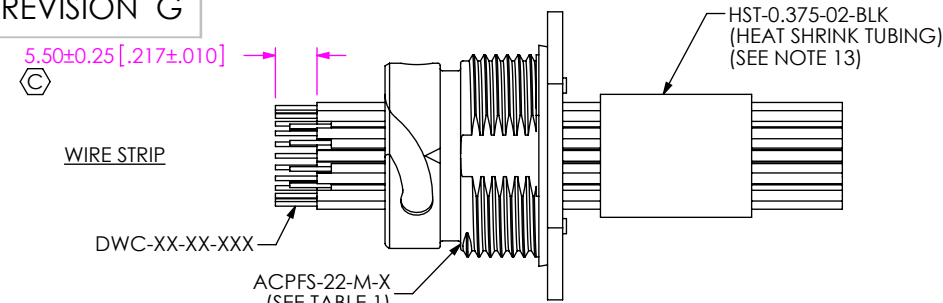
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e-Mail info@SAMTEC.com code 55322

DESCRIPTION:
M22 CABLE ASSEMBLY

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

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

REVISION G



IN-PROCESS 1

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

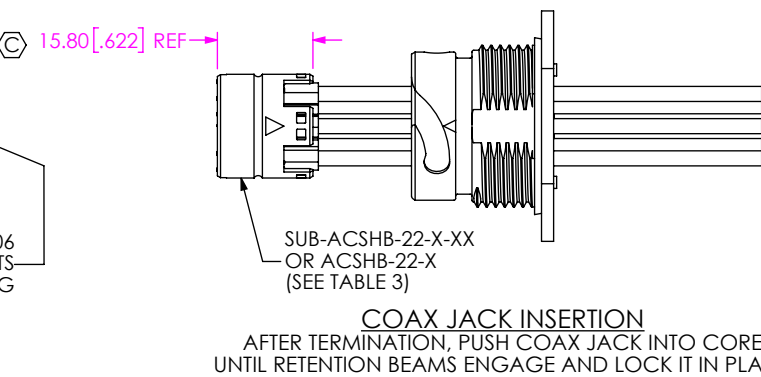
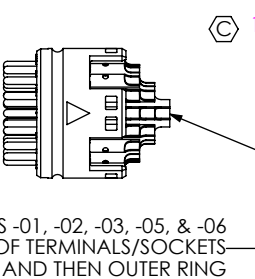
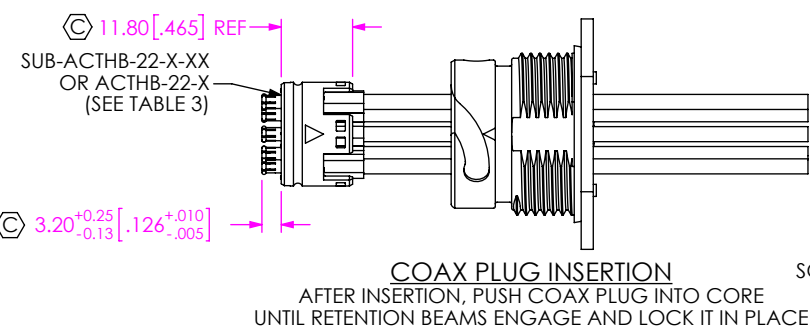
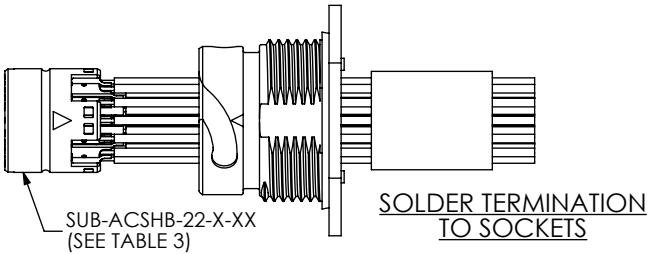
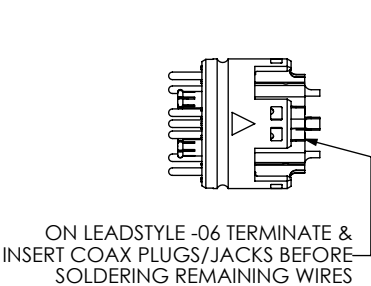
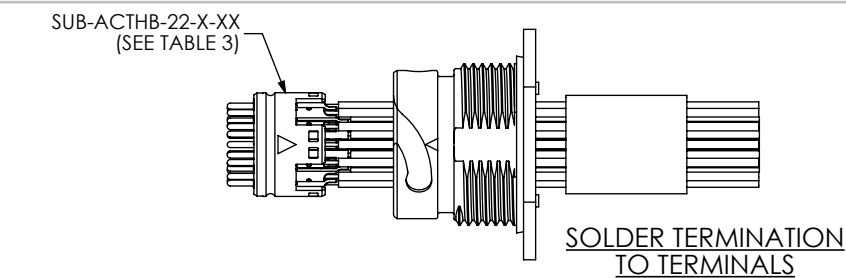


TABLE 3					
LEAD STYLES	END1/END 2	PLATING		COAX PLUG/JACK PART #	
		-G	-H	AC-X-C-H-ST-CA1	QTY
-01	-T	SUB-ACTHB-22-G-01	SUB-ACTHB-22-H-01	NA	
-02	-T	SUB-ACTHB-22-G-02	SUB-ACTHB-22-H-02	NA	
-03	-T	SUB-ACTHB-22-G-03	SUB-ACTHB-22-H-03	NA	
* -04	-T	ACTHB-22-6	ACTHB-22-6	AC-P-C-H-ST-CA1	6
-05	-T	SUB-ACTHB-22-G-05	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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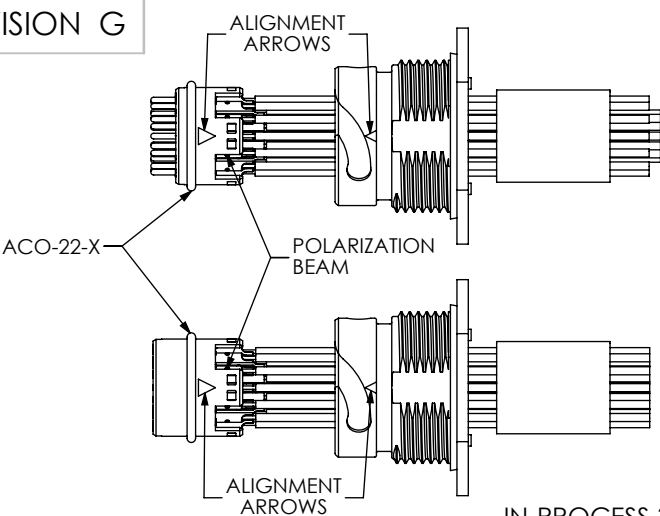
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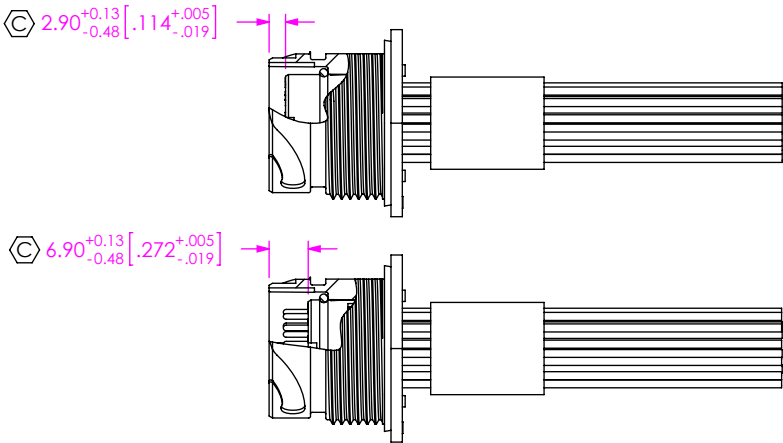
DESCRIPTION:
M22 CABLE ASSEMBLY

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

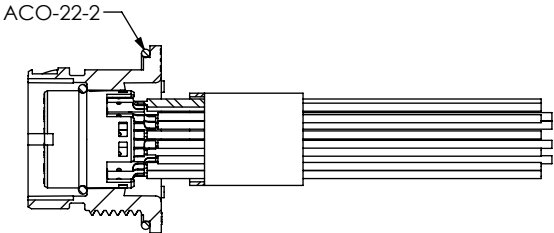
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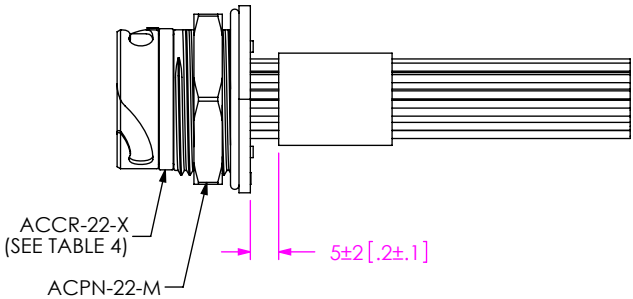
IN-PROCESS 3
PUSH ACO-22-1 ORING ONTO SUB-ACTHB-22-X-X
OR SUB-ACSHB-22-X-X SUB-ASSEMBLIES



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

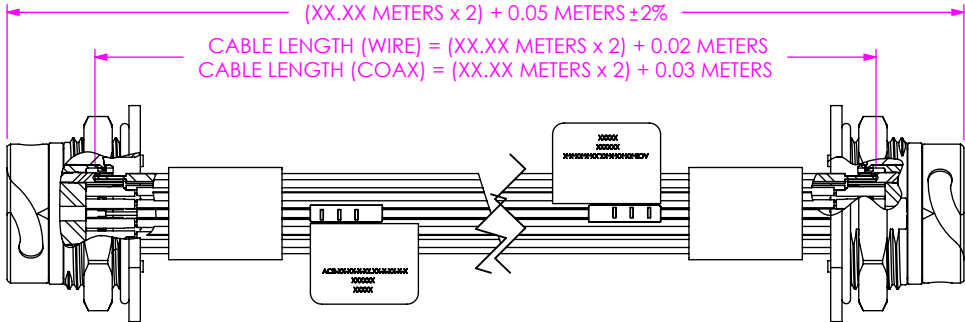


IN-PROCESS 5
INSERT ACO-22-2 WHERE SHOWN



IN-PROCESS 6
THREAD ACPN-22-M ONTO ACPFS-22-M-X
STRETCH ACCR-22-X OVER ACPFS-22-M-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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520 PARK EAST BLVD, NEW ALBANY, IN 47150
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-M-X

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