

DO NOT
SCALE FROM
THIS PRINTTHIS PRODUCT MANUFACTURED
WITH LEAD-FREE PROCESSING

ACR-16-XX-X-XX.XX-X-XX-M-X

SIZE

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 10 & 14)
- G: 10u GOLD IN CONTACT AREA
- H: 30u GOLD IN CONTACT AREA

KEYING FEATURE

- (SEE NOTE 4)
- 1: ORANGE
- 2: GREEN
- 3: BLUE
- 4: YELLOW

STYLE

- M: METAL

END 2

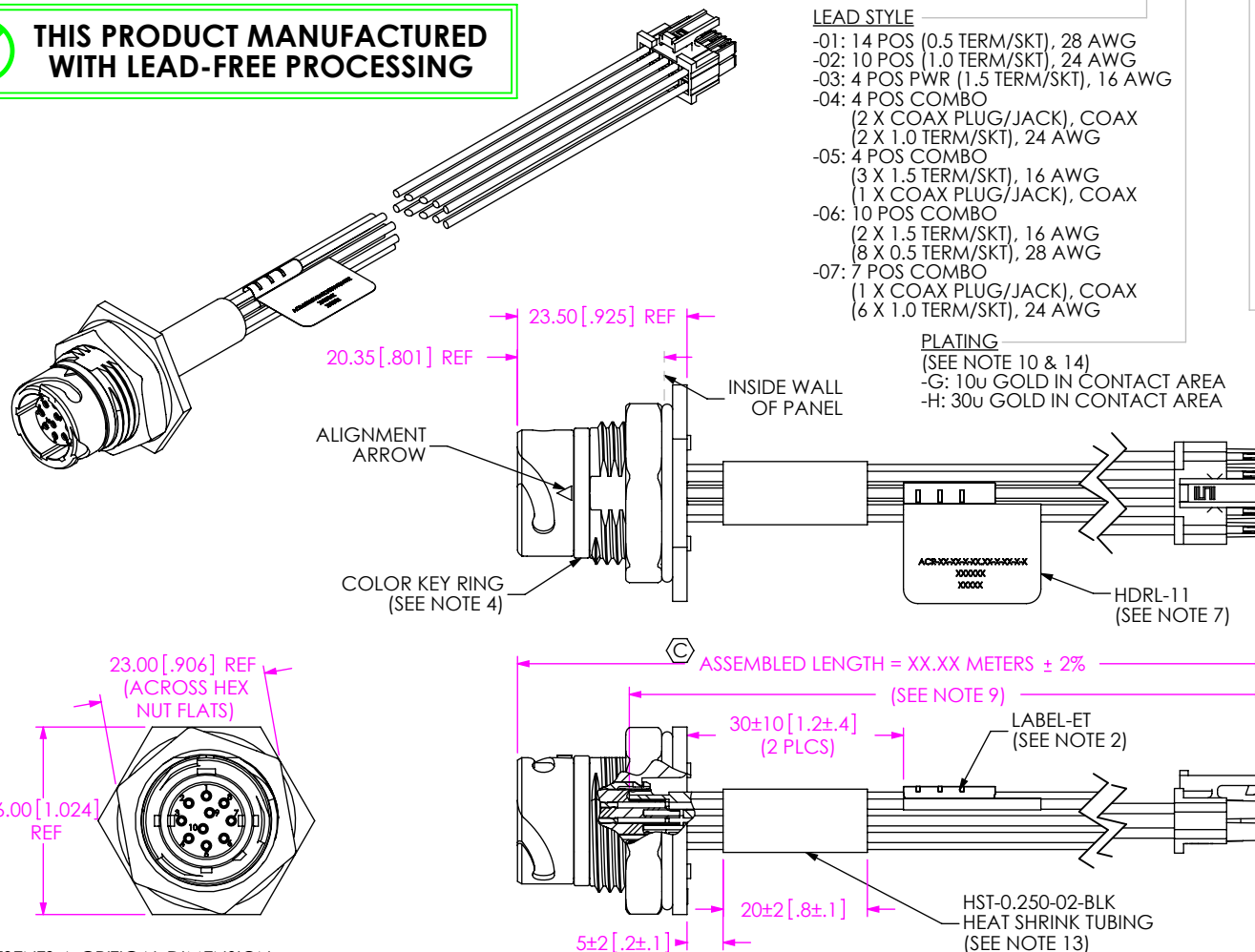
- BC: BLUNT CUT
- S1: CONNECTOR
(DETERMINED BY
LEAD STYLE)

END 1

- T: TERMINAL
- S: SOCKET

ASSEMBLED LENGTH

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



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 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-16-M-X PRINT FOR DUST CAP.
7. PLACE HDRL-11 (LABEL) ON CABLE WHERE SHOWN. LABEL TO CONTAIN
LINE 1 - PART NUMBER "ACR-16-XX-X-XX.XX-X-XX-M-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: SFSD, MMSD & MPSS: 10u GOLD IN CONTACT AREA
RF316: 30u GOLD CENTER CONTACT
3u GOLD OUTER CONTACT
11. NOTE DELETED.
12. WHEN MOUNTING PRODUCT TO PANEL TORQUE ACPN-16-M TO 15 IN-LBS.
13. APPLY HEAT SHRINK TUBING TO -01, -02, -06, & -07 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].

c:\enterprise\vauf\DWG\MISC\MKTG\ACR-16-XX-X-XX.XX-X-XX-M-X-MKT.SLDDRW

FIG 1
ACR-16-02-X-XX.XX-S-S1-M-1UNLESS 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:

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

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SHEET SCALE: 1:1

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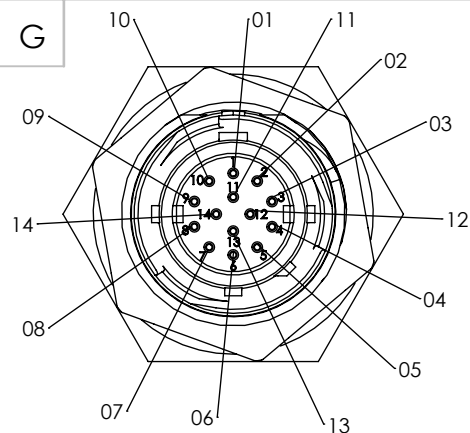
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M16 CABLE ASSEMBLY

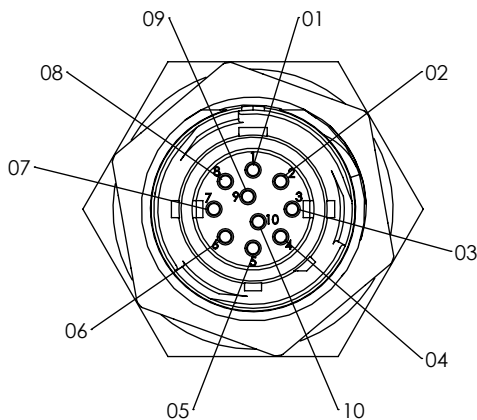
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ACR-16-XX-X-XX.XX-X-XX-M-X

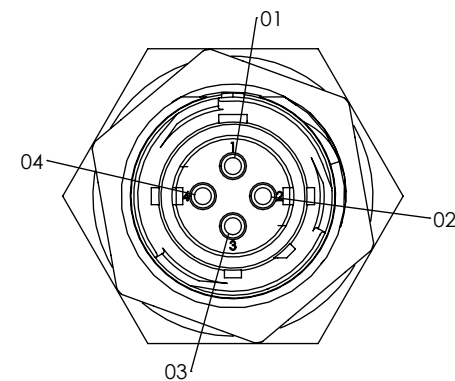
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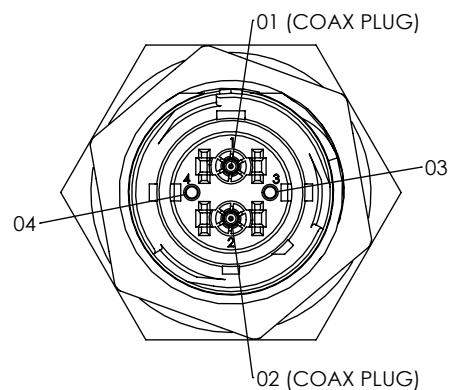
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(Ø 0.5 TERMINALS)



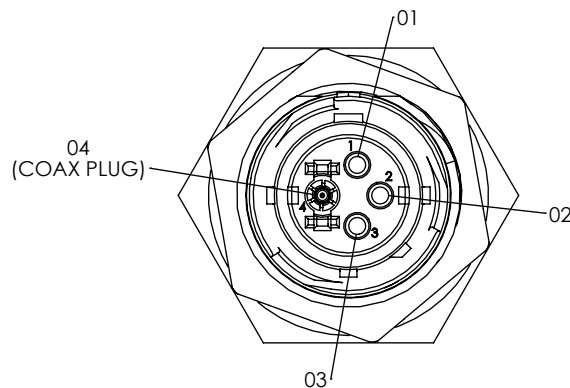
-02: 10 POS
(Ø 1.0 TERMINALS)



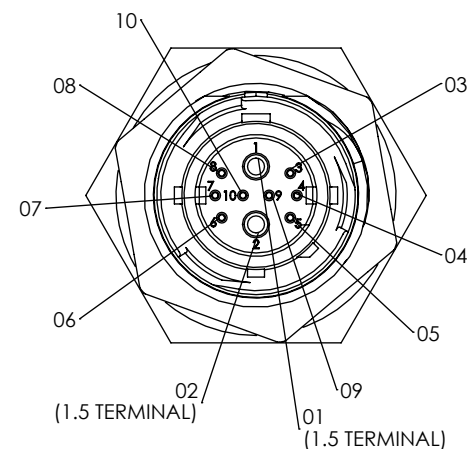
-03: 4 POS
(Ø 1.5 TERMINALS)



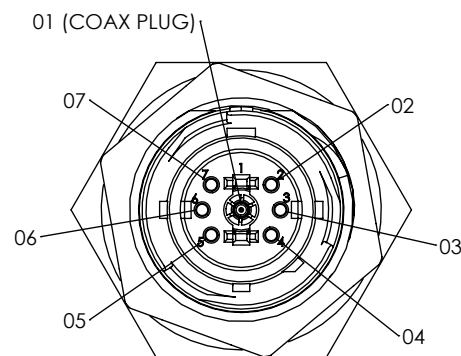
-04: 4 POS COMBO
(2 X COAX PLUGS)
(2 X Ø 1.0 TERMINALS)



-05: 4 POS COMBO
(3 X Ø 1.5 TERMINALS)
(1 X COAX PLUG)



-06: 10 POS COMBO
(2 X Ø 1.5 TERMINALS)
(8 X Ø 0.5 TERMINALS)



-07: 7 POS COMBO
(1 X COAX PLUG)
(6 X Ø 1.0 TERMINALS)

-T END OPTIONS

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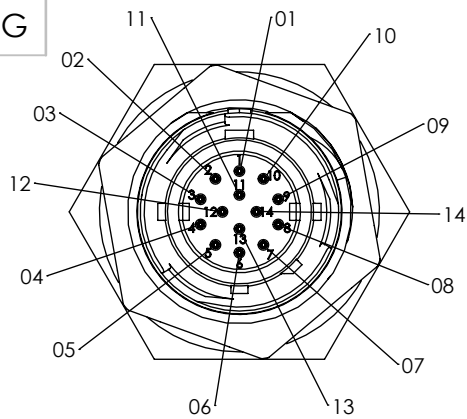
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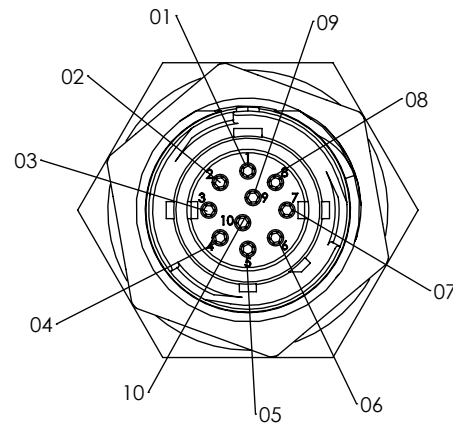
DWG. NO.

ACR-16-XX-X-XX.XX-X-XX-M-X

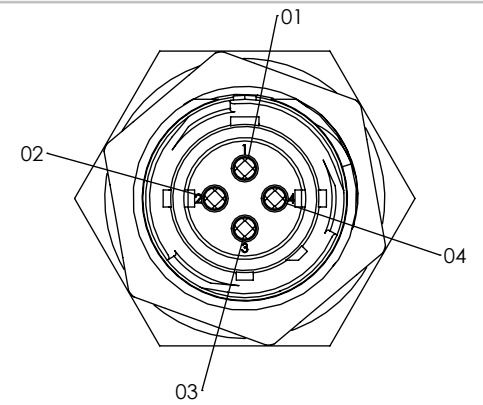
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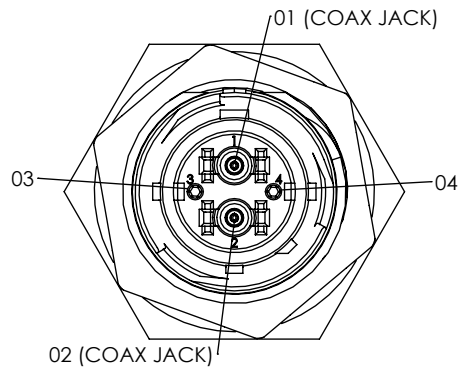
-01: 14 POS
(Ø0.5 SOCKETS)



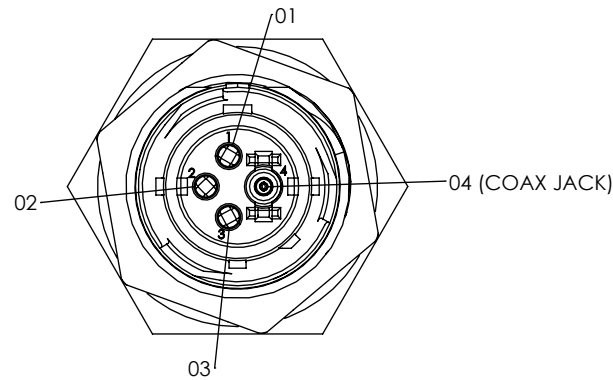
-02: 10 POS
(Ø1.0 SOCKETS)



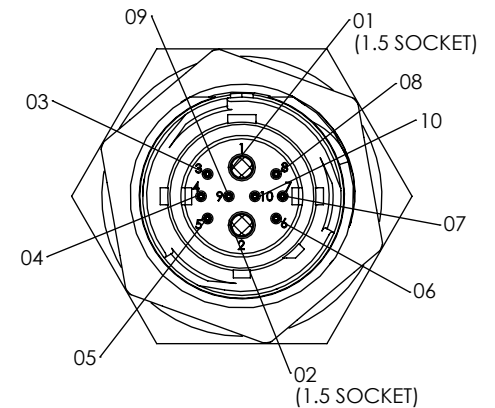
-03: 4 POS
(Ø1.5 SOCKETS)



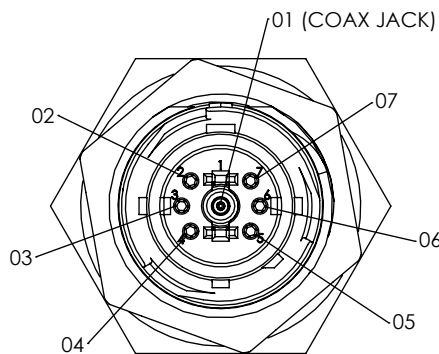
-04: 4 POS COMBO
(2 X COAX JACKS)
(2 X Ø1.0 SOCKETS)



-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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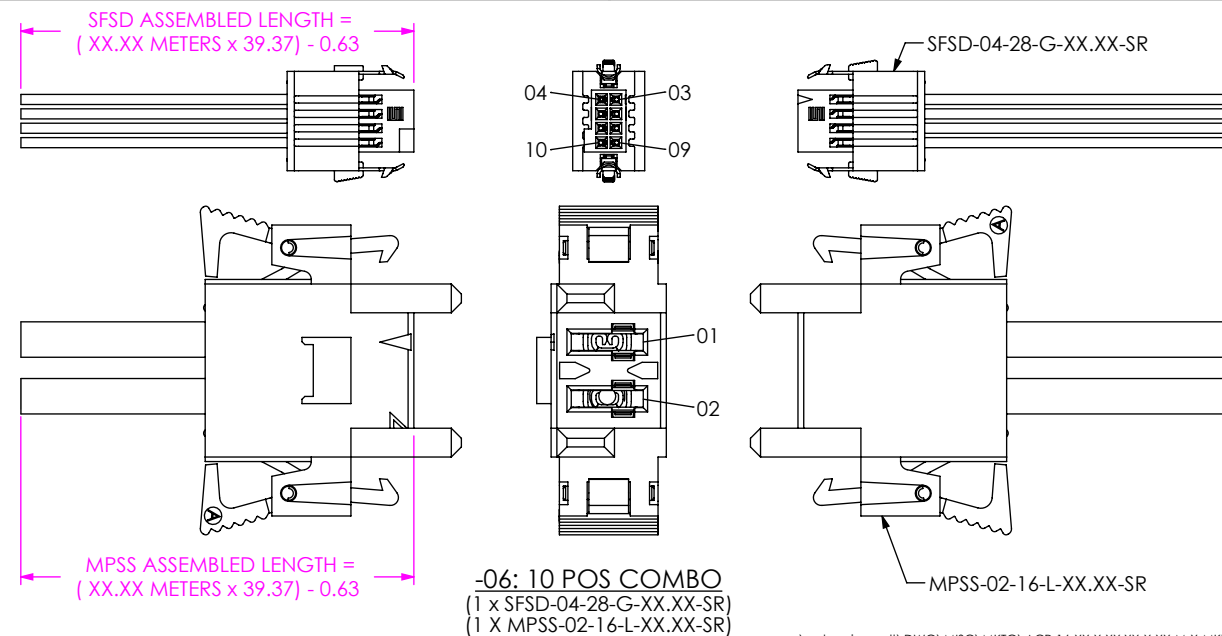
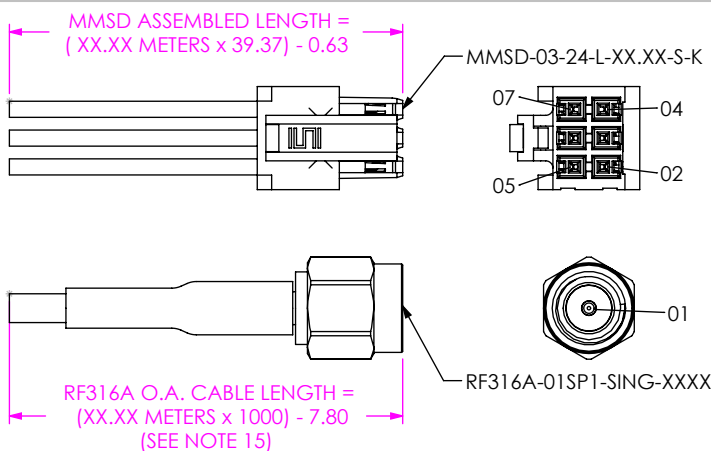
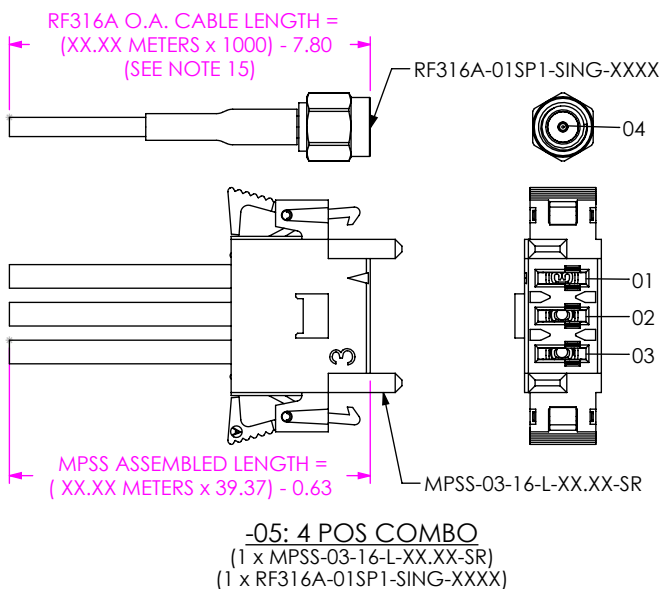
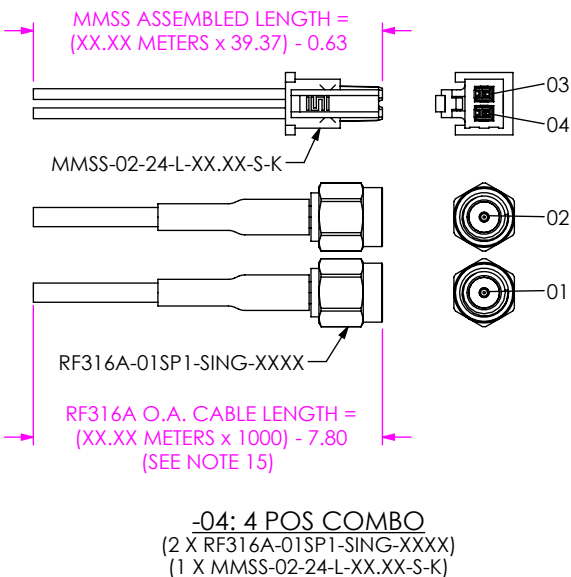
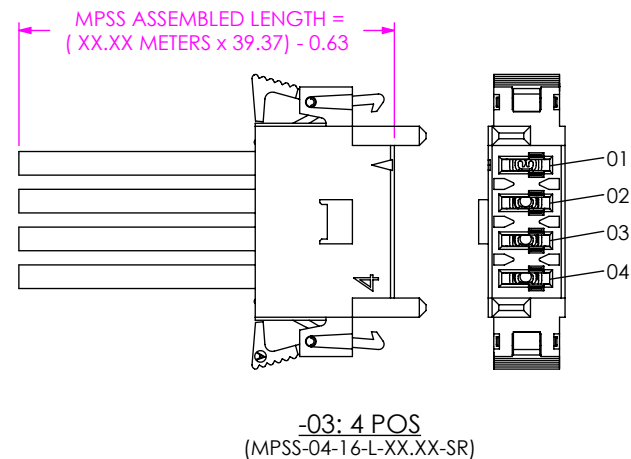
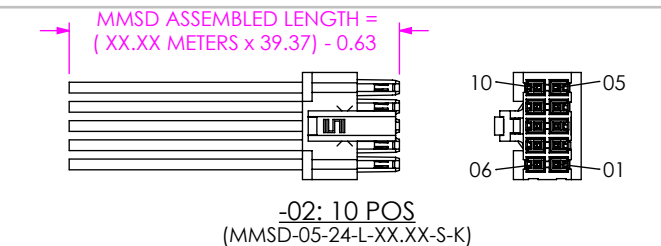
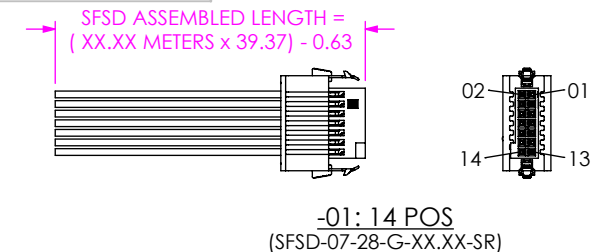
DESCRIPTION:
M16 CABLE ASSEMBLY

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

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REVISION G

END 2 OPTIONS



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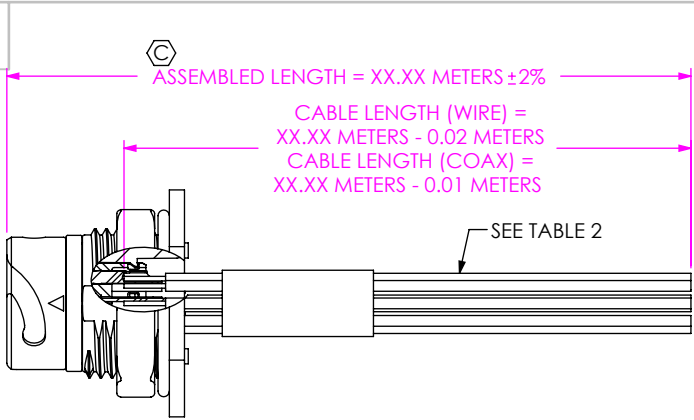
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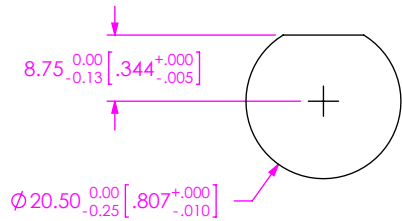
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ACR-16-XX-X-XX.XX-X-XX-M-X

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-BC END OPTION
(BUILD DOUBLE-ENDED INITIALLY FOR E-TEST)
(SEE TABLE 2 FOR DWC CALLOUTS/SIGNAL MAPPING)
(SEE IN-PROCESS 7)



RECOMMENDED PANEL OPENING
(SEE NOTE 8 & 12)

TABLE 2 LEAD STYLE														
POSITION	-01		-02		-03		-04		-05		-06		-07	
	COLOR	CABLE PART #	COLOR	CABLE PART #	COLOR	CABLE PART #	COLOR	CABLE PART #	COLOR	CABLE PART #	COLOR	CABLE PART #	COLOR	CABLE PART #
01	BROWN	DWC-28H-01-300	BROWN	DWC-24-01-300	BROWN	DWC-16-01-300	COAX	CCS-174525-01-CC	BROWN	DWC-16-01-300	BROWN	DWC-16-01-300	COAX	CCS-174525-01-CC
02	RED	DWC-28H-02-300	RED	DWC-24-02-300	RED	DWC-16-02-300	COAX	CCS-174525-01-CC	RED	DWC-16-02-300	RED	DWC-16-02-300	RED	DWC-24-02-300
03	ORANGE	DWC-28H-03-300	ORANGE	DWC-24-03-300	ORANGE	DWC-16-03-300	ORANGE	DWC-24-03-300	ORANGE	DWC-16-03-300	ORANGE	DWC-28H-03-300	ORANGE	DWC-24-03-300
04	YELLOW	DWC-28H-04-300	YELLOW	DWC-24-04-300	YELLOW	DWC-16-04-300	YELLOW	DWC-24-04-300	COAX	CCS-174525-01-CC	YELLOW	DWC-28H-04-300	YELLOW	DWC-24-04-300
05	GREEN	DWC-28H-05-300	GREEN	DWC-24-05-300							GREEN	DWC-28H-05-300	GREEN	DWC-24-05-300
06	DARK BLUE	DWC-28H-06-300	DARK BLUE	DWC-24-06-300							DARK BLUE	DWC-28H-06-300	DARK BLUE	DWC-24-06-300
07	VIOLET	DWC-28H-07-300	VIOLET	DWC-24-07-300							VIOLET	DWC-28H-07-300	VIOLET	DWC-24-07-300
08	GRAY	DWC-28H-08-300	GRAY	DWC-24-08-300							GRAY	DWC-28H-08-300		
09	WHITE	DWC-28H-09-300	WHITE	DWC-24-09-300							WHITE	DWC-28H-09-300		
10	BLACK	DWC-28H-10-300	BLACK	DWC-24-10-300							BLACK	DWC-28H-10-300		
11	GREEN/BLACK	DWC-28H-11-300												
12	TAN	DWC-28H-12-300												
13	DARK BLUE/YELLOW	DWC-28H-31-300												
14	PINK	DWC-28H-14-300												

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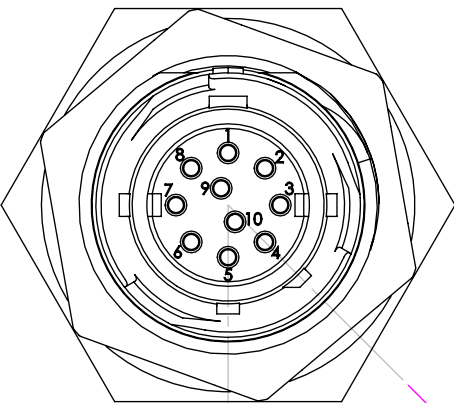


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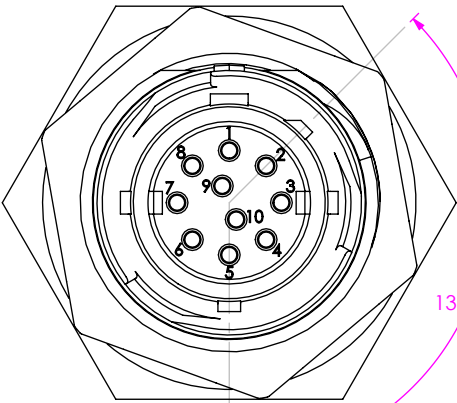
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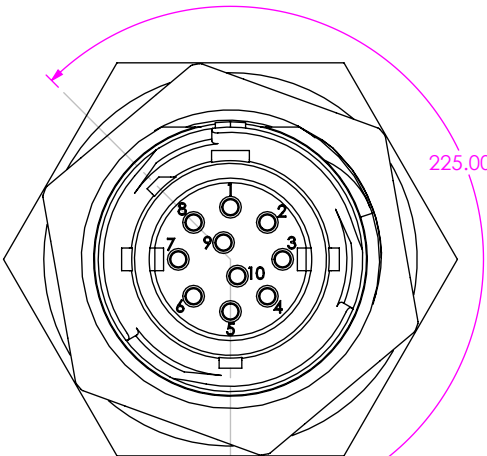
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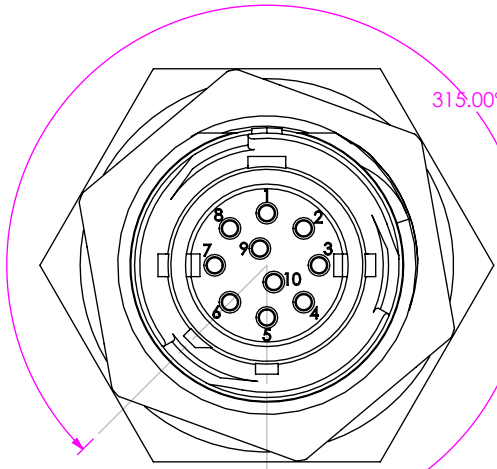
-1
(ORANGE KEY RING)



-2
(GREEN KEY RING)

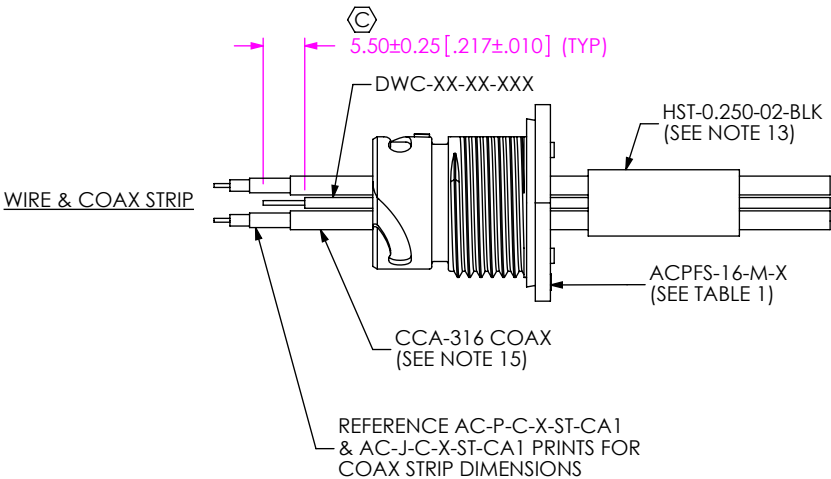


-3
(BLUE KEY RING)



-4
(YELLOW KEY RING)

KEYING FEATURE
(SEE NOTE 4)



IN-PROCESS 1
FEED CABLES FROM END 2 DISCRETE CABLE ASSEMBLY THROUGH HST-0.250-02-BLK (IF APPLICABLE) & ACPFS-16-M-X. STRIP CABLES TO DIMENSIONS SHOWN & TIN INNER CONNECTORS. FOR -BC OPTION, FEED DWC/COAX & STRIP TO DIMENSION SHOWN. (SEE NOTE 15)

TABLE 1	
KEYING FEATURE	SHELL PART #
-1	ACPFS-16-M-1
-2	ACPFS-16-M-2
-3	ACPFS-16-M-3
-4	ACPFS-16-M-4

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SUB-ACTHB-16-X-XX
(SEE TABLE 3)

SOLDER TERMINATION
TO TERMINALS

SUB-ACSHB-16-X-XX
(SEE TABLE 3)

SOLDER TERMINATION
TO SOCKETS

11.50 [.453] REF
SUB-ACTHB-16-X-XX
(SEE TABLE 3)

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

COAX PLUG INSERTION

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

15.50 [.610] REF

SUB-ACSHB-16-X-XX
(SEE TABLE 3)

COAX JACK INSERTION

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

IN-PROCESS 2

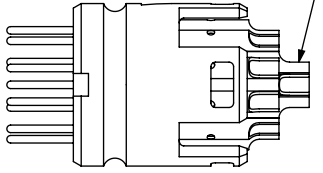
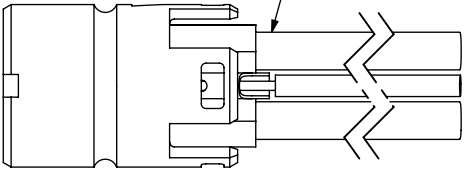
TERMINATE WIRES/COAX TO TERMINALS/sockets
(SEE AC-P-C-X-ST-CA1 & AC-J-C-X-ST-CA1)
PRINTS FOR COAX TERMINATION
(SEE NOTE 5)

ON LEADSTYLES -04, -05, & -07 TERMINATE
& INSERT COAX PLUGS/JACKS BEFORE
SOLDERING REMAINING WIRES

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

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-ACTHB-16-G-01	SUB-ACTHB-16-H-01	NA	
-02	-T	SUB-ACTHB-16-G-02	SUB-ACTHB-16-H-02	NA	
-03	-T	SUB-ACTHB-16-G-03	SUB-ACTHB-16-H-03	NA	
-04	-T	SUB-ACTHB-16-G-04	SUB-ACTHB-16-H-04	AC-P-C-H-ST-CA1	2
-05	-T	SUB-ACTHB-16-G-05	SUB-ACTHB-16-H-05	AC-P-C-H-ST-CA1	1
-06	-T	SUB-ACTHB-16-G-06	SUB-ACTHB-16-H-06	NA	
-07	-T	SUB-ACTHB-16-G-07	SUB-ACTHB-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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DESCRIPTION:

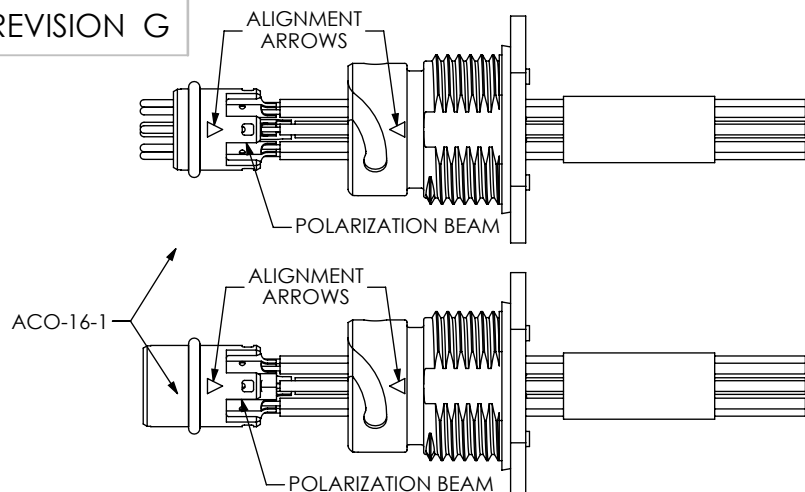
M16 CABLE ASSEMBLY

DWG. NO.

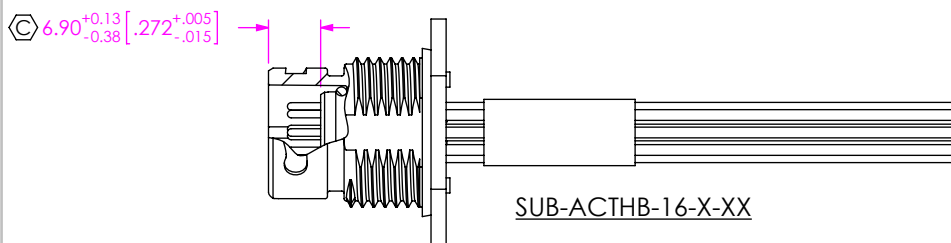
ACR-16-XX-X-XX.XX-X-XX-M-X

BY: D.SCHMELZ 04/27/2010 SHEET 7 OF 8

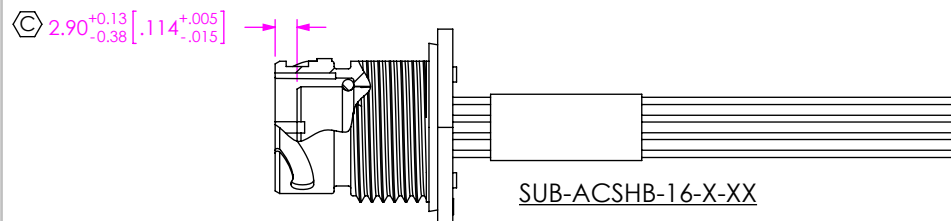
REVISION G



IN-PROCESS 3
PUSH ACO-16-1 O-RING ONTO SUB-ACHTB-16-X-XX,
OR SUB-ACSHB-16-X-XX SUB-ASSEMBLIES

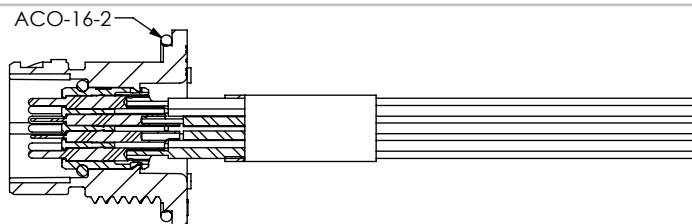


SUB-ACHTB-16-X-XX

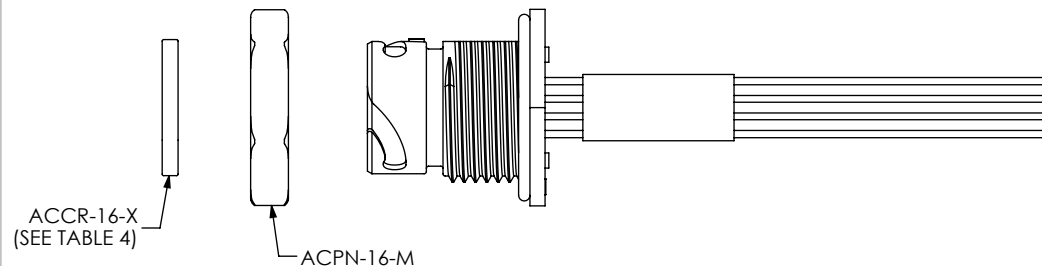


SUB-ACSHB-16-X-XX

IN-PROCESS 4
WHILE MAKING SURE ALIGNMENT ARROWS LINE UP TO AID POLARIZATION BEAM
ENGAGEMENT, INSERT SUB-ACSHB-16-X-XX SUB-ASSEMBLY INTO ACPFS-16-M-X
UNTIL SNAP LOCKS ENGAGE.

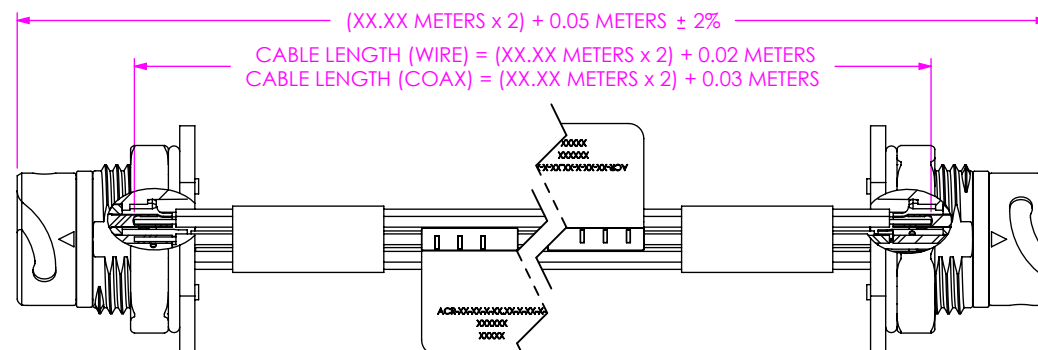


IN-PROCESS 5
INSERT ACO-16-2 AROUND FLANGE



IN-PROCESS 6
THREAD ACPN-16-M ONTO ACPFS-16-M-X
STRETCH ACCR-16-X OVER ACPFS-16-M-X
UNTIL IT SEATS IN GROOVE. ACTIVATE HEAT SHRINK TUBING

TABLE 4	
KEYING FEATURE	ACCR-16-X
-1 (ORANGE)	ACCR-16-1
-2 (GREEN)	ACCR-16-2
-3 (BLUE)	ACCR-16-3
-4 (YELLOW)	ACCR-16-4



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:
M16 CABLE ASSEMBLY

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

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