

DESIGNED & DIMENSIONED  
IN MILLIMETERS [INCHES]

ACP-22-XX-X-XX.XX-X-XX-M-X

DO NOT  
SCALE FROM  
THIS PRINT

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

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

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)

PLATING

- (SEE NOTE 9)
- G: LIGHT, 10µ" GOLD IN  
CONTACT AREA
- H: HEAVY, 30µ" GOLD IN  
CONTACT AREA

ASSEMBLED LENGTH

XX.XX (IN METERS)  
(0.25 METER MIN TO 50.00 METER MAX)  
(1.00 METER MIN FOR -04. & -06  
LEAD STYLES CONTAINING COAX)

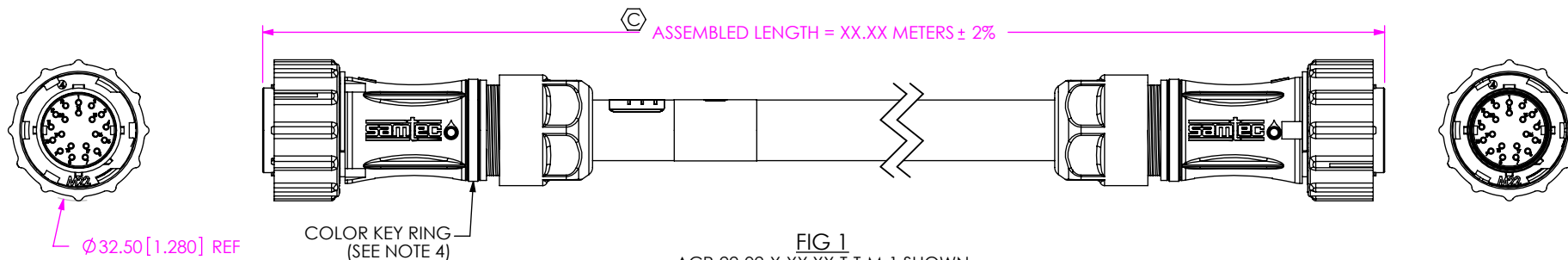
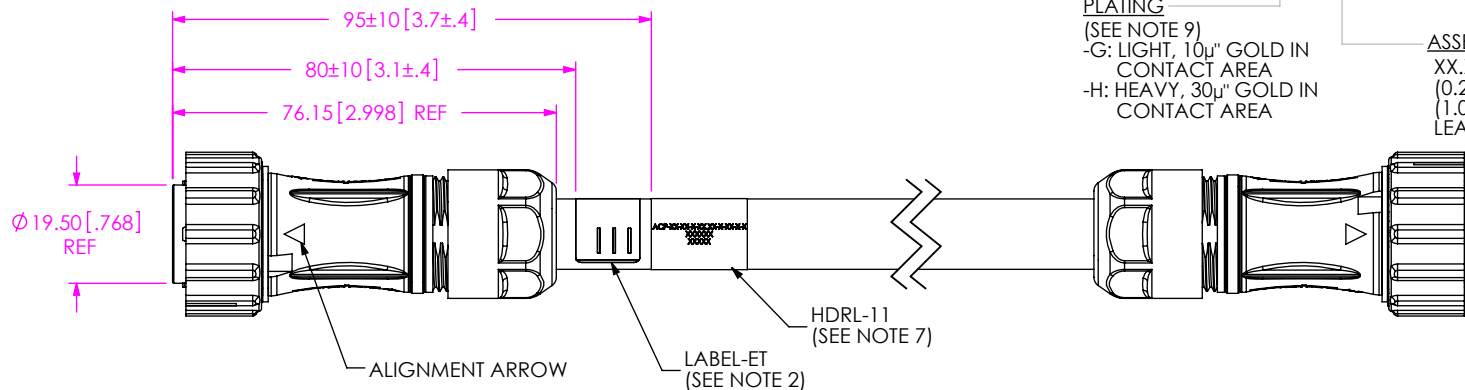


FIG 1  
ACP-22-02-X-XX.XX-T-T-M-1 SHOWN

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-22-M-X PRINT FOR DUST CAP.
7. PLACE HDRL-11 (LABEL) ON CABLE WHERE SHOWN. LABEL TO CONTAIN  
LINE 1 - PART NUMBER "ACP-22-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].

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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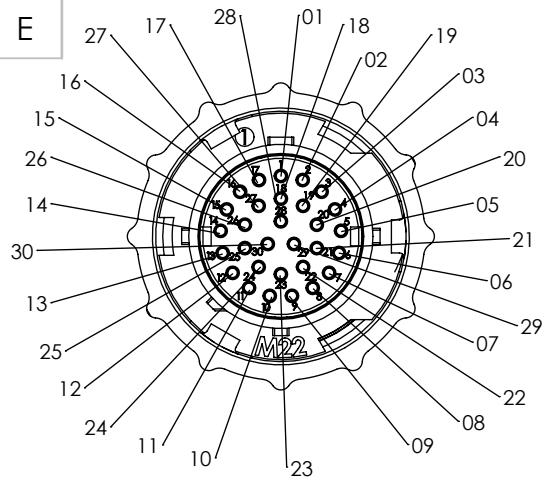
MATERIAL: DO NOT SCALE DRAWING  
SHELLS: ZINC ALLOY  
INSULATOR: PBT, COLOR: BLACK  
TERMINALS: BRASS  
CONTACTS: BRASS/BeCu  
BAYONET COLLAR: ZINC ALLOY  
CABLE NUT: ZINC ALLOY  
GROMMET: NBR  
GROMMET CAGE: NYLON, COLOR: BLACK  
COLOR RINGS: SILICONE

SHEET SCALE: 2:3

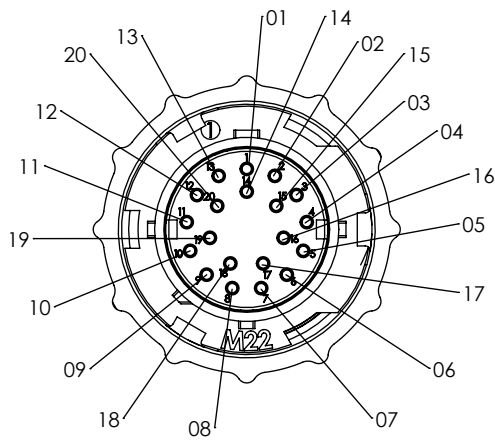


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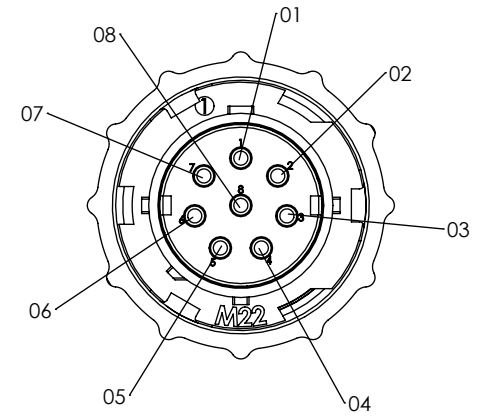
DESCRIPTION:  
ACCLIMATE CIRC. CABLE ASSEMBLY  
DWG. NO.  
ACP-22-XX-X-XX.XX-X-XX-M-X  
BY: CLAY W 9/5/2010 SHEET 1 OF 7



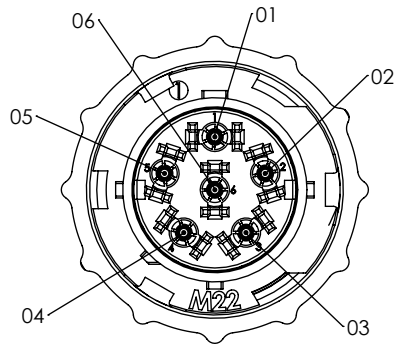
-01: 30 POS  
(1.0 TERMINALS)



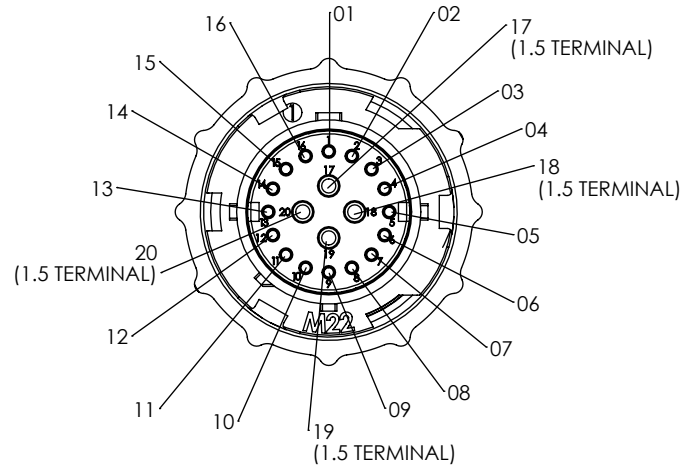
-02: 20 POS  
(1.0 TERMINALS)



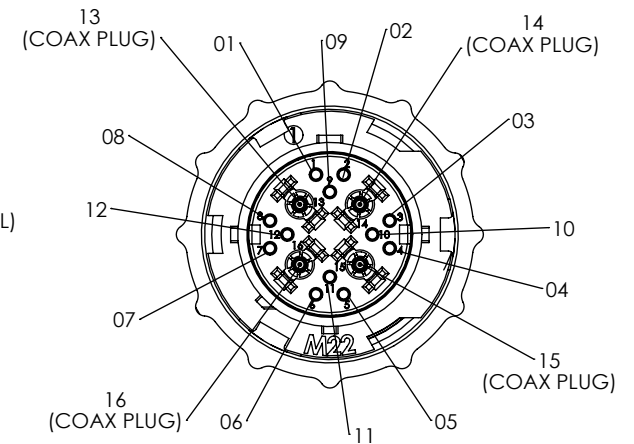
-03: 8 POS  
(1.5 TERMINALS)



-04: 6 POS  
(COAX PLUGS)



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



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

-T END OPTIONS

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SHEET SCALE: 1.5:1

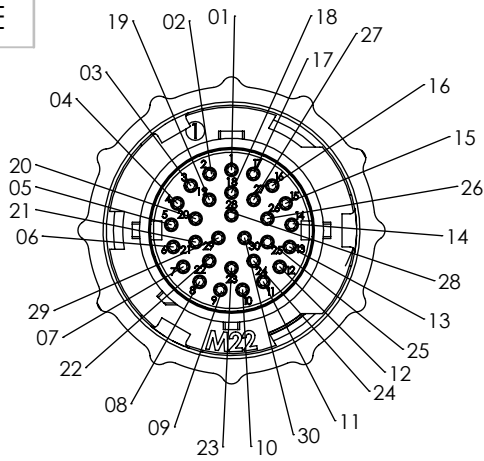


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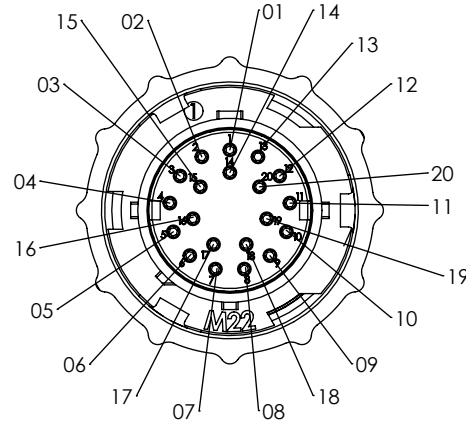
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DWG. NO. ACP-22-XX-X-XX.XX-X-XX-M-X

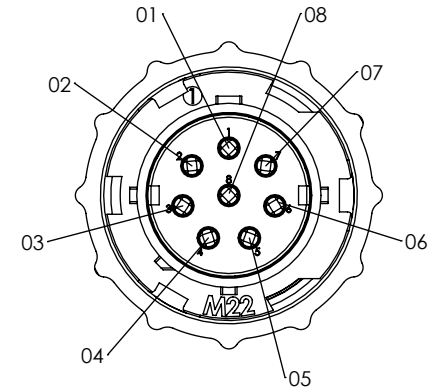
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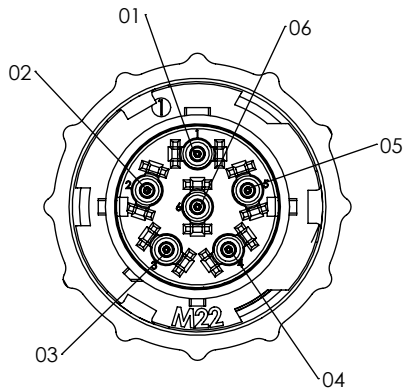
-01: 30 POS  
(1.0 SOCKETS)



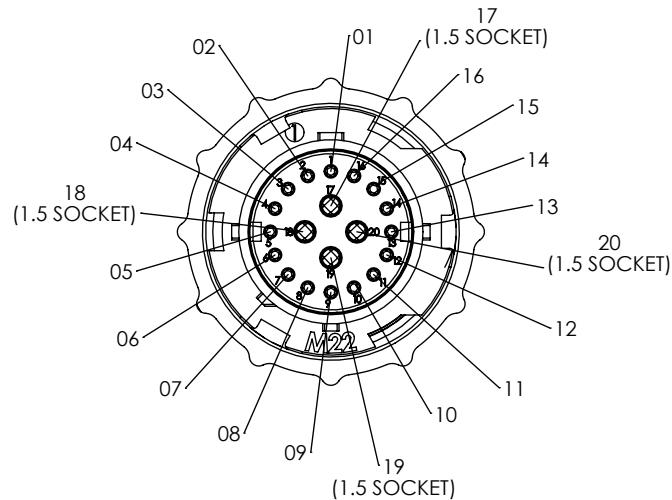
-02: 20 POS  
(1.0 SOCKETS)



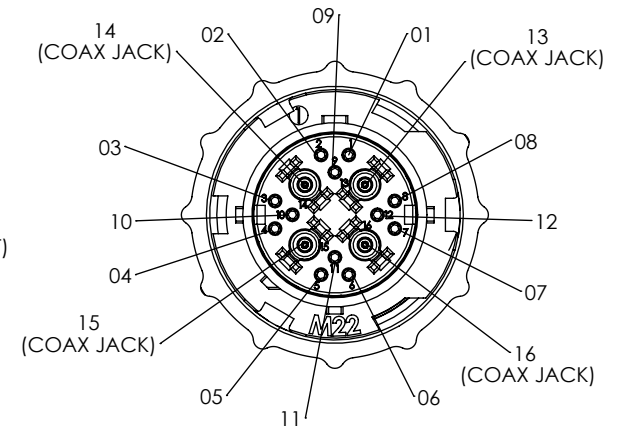
-03: 8 POS  
(1.5 SOCKETS)



-04: 6 POS  
(COAX JACKS)



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



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

-S END OPTIONS

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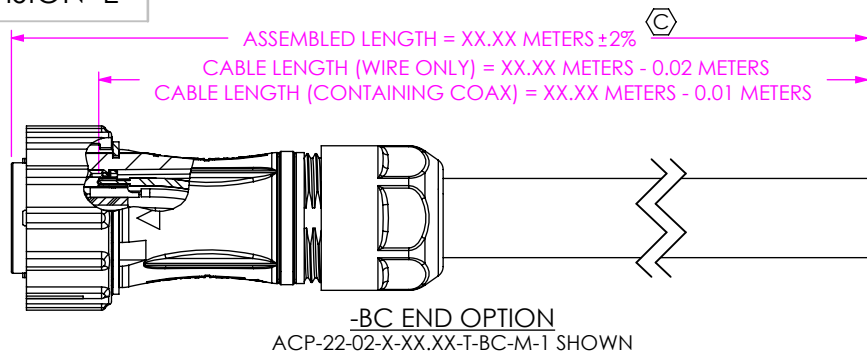
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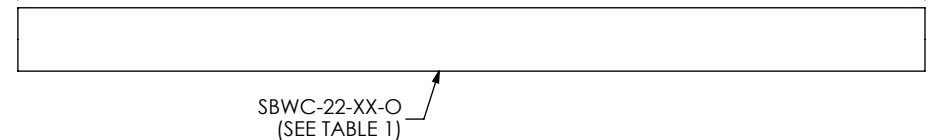
DWG. NO. ACP-22-XX-X-XX.XX-X-XX-M-X

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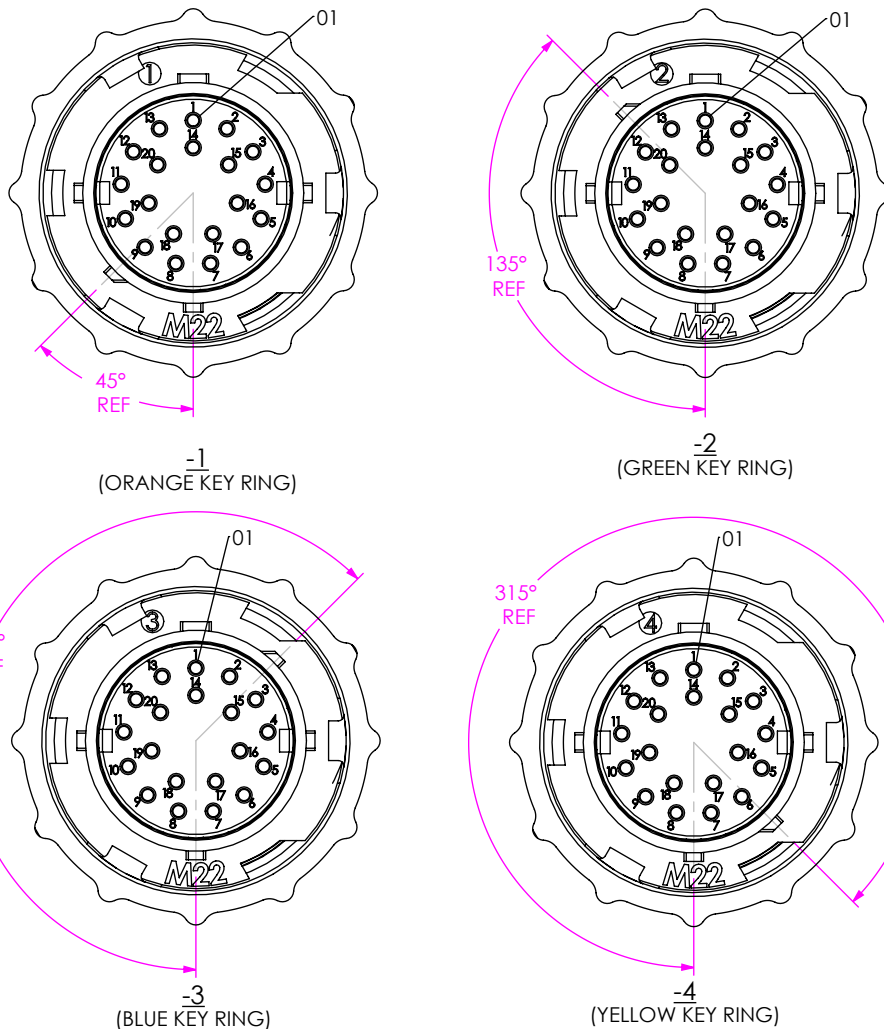
REVISION E



⊕ CABLE LENGTH (WIRE ONLY) = (XX.XX METERS - 0.03 METERS) ± 2%  
 CABLE LENGTH (CONTAINING COAX) = (XX.XX METERS) ± 2%  
 -BC CABLE LENGTH (WIRE ONLY) = ((XX.XX METERS x 2) + 0.02 METERS) ± 2%  
 -BC CABLE LENGTH (CONTAINING COAX) = ((XX.XX METERS x 2) + 0.05 METERS) ± 2%



**IN-PROCESS 1**  
 CUT SBWC CABLE TO LENGTH SHOWN



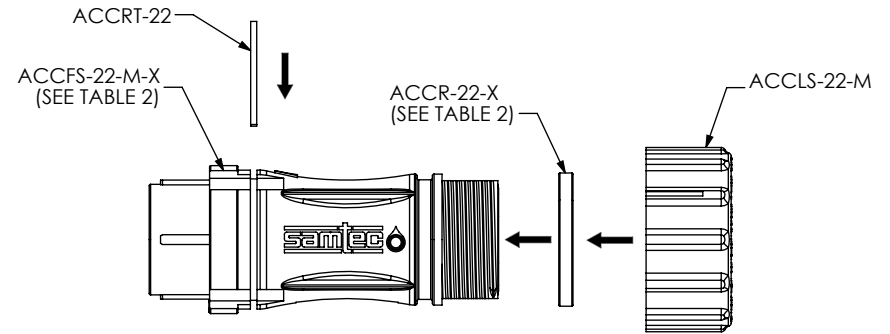
**KEYING FEATURE**  
 (SEE NOTE 4)

**TABLE 1**

LEAD STYLES	SBWC PART #
-01	SBWC-22-01-O
-02	SBWC-22-02-O
-03	SBWC-22-03-O
-04	SBWC-22-04-O
-05	SBWC-22-05-O
-06	SBWC-22-06-O

**TABLE 2**

KEYING FEATURE	ACCFS-22-M-X	ACCR-22-X
-1	ACCFS-22-M-1	ACCR-22-1
-2	ACCFS-22-M-2	ACCR-22-2
-3	ACCFS-22-M-3	ACCR-22-3
-4	ACCFS-22-M-4	ACCR-22-4



**IN-PROCESS 2**  
 STRETCH ACCR-22-X OVER ACCFS-22-M-X UNTIL IT SEATS IN GROOVE  
 PUSH ACCLS-22-M ONTO ACCFS-22-M-X UNTIL IT BOTTOMS OUT AGAINST FLANGE. SNAP ACCRT-22 (RETAINING RING) INTO GROOVE IN ACCFS-22-M-X TO HOLD ACCLS-22-M IN PLACE

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SHEET SCALE: 1:1

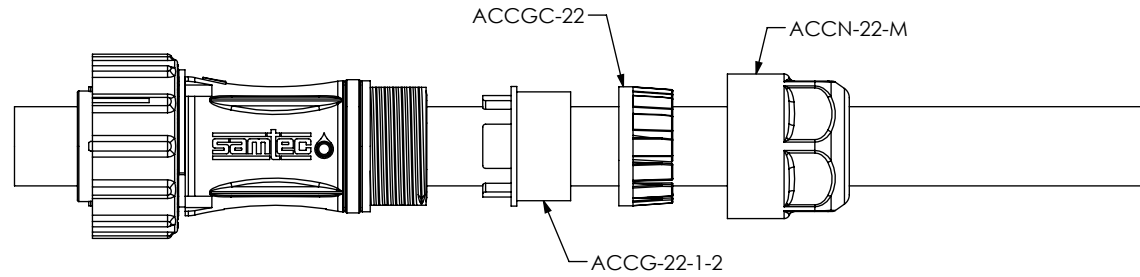


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DESCRIPTION:  
**ACCLIMATE CIRC. CABLE ASSEMBLY**

DWG. NO.  
**ACP-22-XX-X-XX.XX-X-XX-M-X**

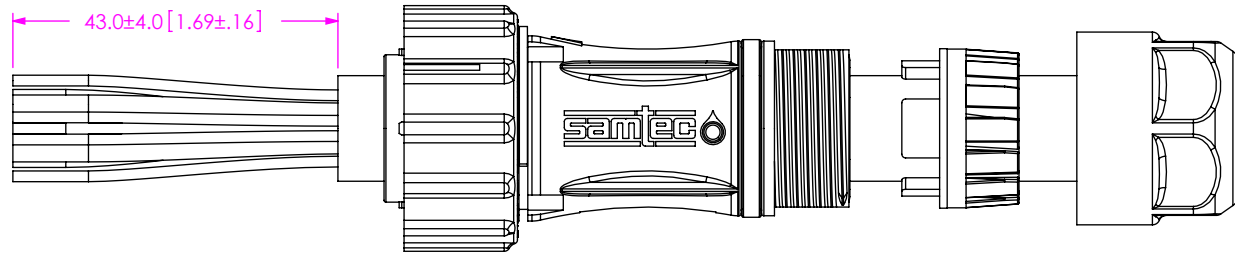
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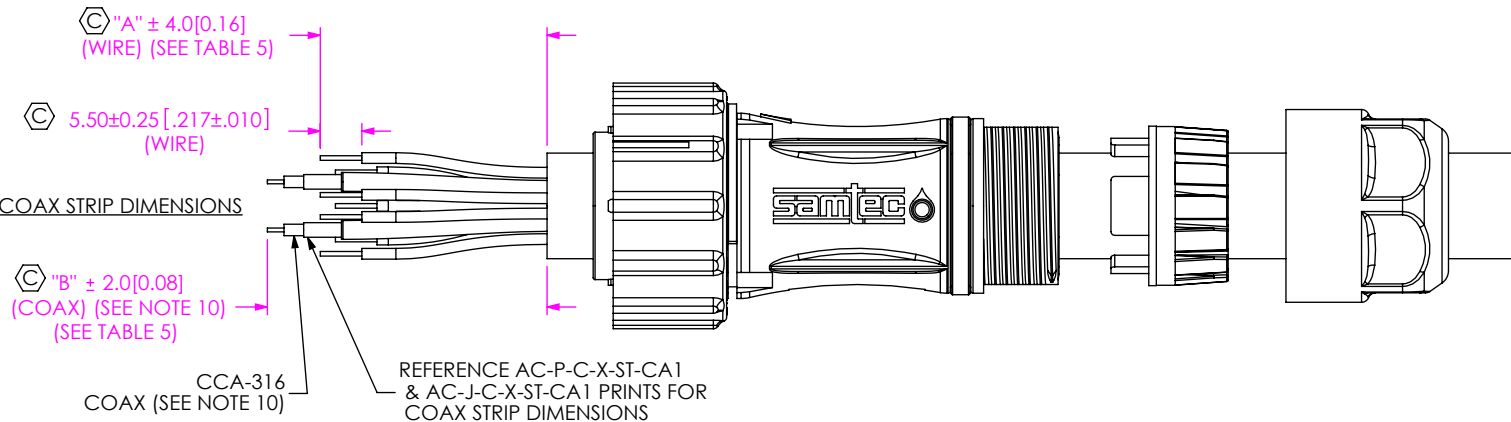
**IN-PROCESS 3**

FEED SBWC-22-XX-O BUNDLED CABLE THROUGH ACCN-22-M, ACCGC-22, ACCG-22-1-2, & ACCFS-22-M-X)

INITIAL WIRE & COAX STRIP DIMENSIONS  
(ONLY APPLIES TO -04 & -06 LEAD STYLES)



FINAL WIRE & COAX STRIP DIMENSIONS



**IN-PROCESS 4**

STRIP OUTER JACKET & INNER WIRES/COAX TO DIMENSIONS SHOWN & TIN INNER CONDUCTORS. PUSH ACCGC-22 ON TO ACCG-22-1-2 UNTIL IT BOTTOMS OUT AGAINST FLANGE OF ACCG-22-1-2.

LEAD STYLES	"A"	"B"
-01	30.00 [1.181]	NA
-02	30.00 [1.181]	NA
-03	30.00 [1.181]	NA
-04	NA	43.00 [1.693]
-05	30.00 [1.181]	NA
-06	34.00 [1.339]	37.00 [1.457]

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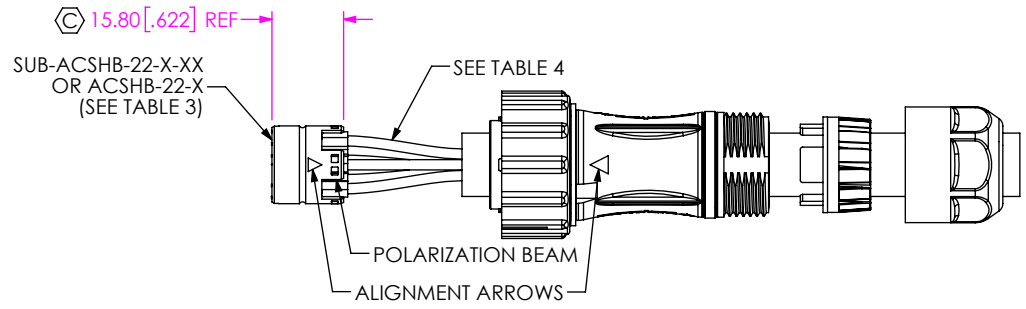
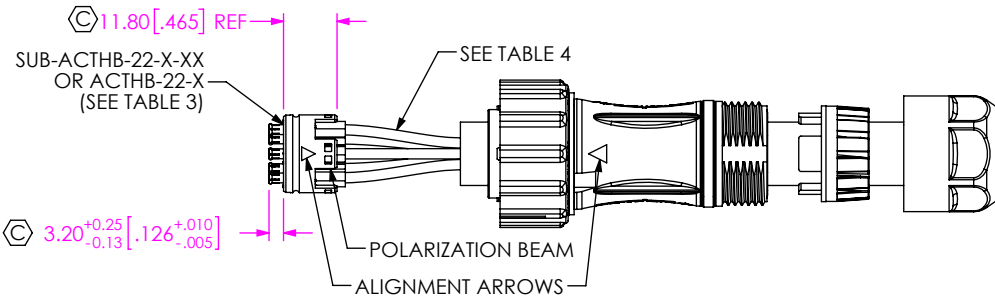
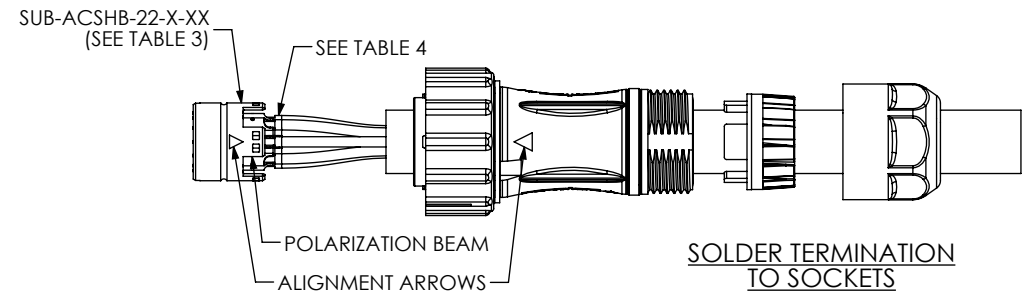
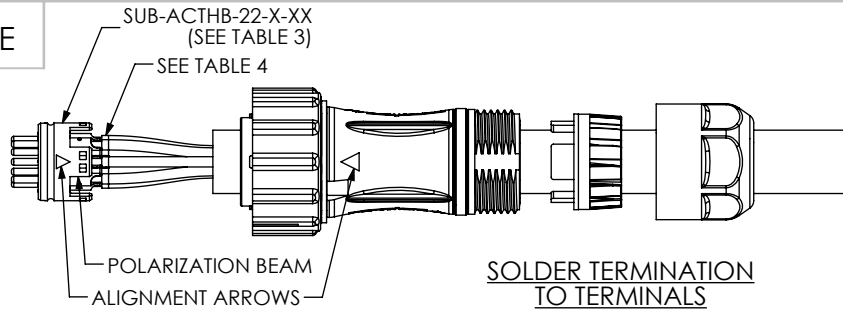
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DESCRIPTION:  
ACCLIMATE CIRC. CABLE ASSEMBLY

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

BY: CLAY W 9/5/2010 SHEET 5 OF 7

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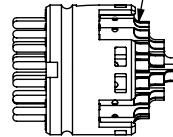


**COAX PLUG INSERTION**  
AFTER TERMINATION, PUSH COAX PLUG INTO CORE UNTIL RETENTION BEAMS ENGAGE AND LOCK IT INTO PLACE

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

**IN-PROCESS 5**  
TERMINATE WIRES/COAX TO TERMINAL/SOCKETS  
(SEE AC-P-C-X-ST-CA1 & AC-J-C-X-ST-CA1 PRINTS FOR COAX TERMINATION)  
(SEE NOTE 5)

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



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

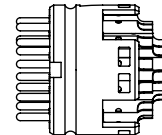


TABLE 4						
WIRE COLOR						
POSITION	LEAD STYLE					
	-01	-02	-03	-04	-05	-06
01	BROWN	BROWN	BROWN	COAX	BROWN	BROWN
02	RED	RED	RED	COAX	RED	RED
03	ORANGE	ORANGE	ORANGE	COAX	ORANGE	ORANGE
04	YELLOW	YELLOW	YELLOW	COAX	YELLOW	YELLOW
05	GREEN	GREEN	GREEN	COAX	GREEN	GREEN
06	DARK BLUE	DARK BLUE	DARK BLUE	COAX	DARK BLUE	DARK BLUE
07	VIOLET	VIOLET	VIOLET		VIOLET	VIOLET
08	GRAY	GRAY	GRAY		GRAY	GRAY
09	WHITE	WHITE			WHITE	WHITE
10	BLACK	BLACK			BLACK	BLACK
11	GREEN / BLACK	GREEN / BLACK			GREEN / BLACK	GREEN / BLACK
12	TAN	TAN			TAN	TAN
13	DARK BLUE / YELLOW	DARK BLUE / YELLOW			DARK BLUE / YELLOW	COAX
14	PINK	PINK			PINK	COAX
15	BROWN / WHITE	BROWN / WHITE			BROWN / WHITE	COAX
16	RED / WHITE	RED / WHITE			RED / WHITE	COAX
17	ORANGE / WHITE	ORANGE / WHITE			ORANGE / WHITE	
18	YELLOW / WHITE	YELLOW / WHITE			YELLOW / WHITE	
19	GREEN / WHITE	GREEN / WHITE			GREEN / WHITE	
20	DARK BLUE / WHITE	DARK BLUE / WHITE	NA		DARK BLUE / WHITE	
21	VIOLET / WHITE					
22	GRAY / WHITE					
23	WHITE / BLACK					
24	BLACK / WHITE					
25	GREEN / YELLOW					
26	TAN / WHITE	NA			NA	
27	DARK BLUE / PINK					
28	PINK / WHITE					
29	BROWN / BLACK					
30	RED / BLACK					

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

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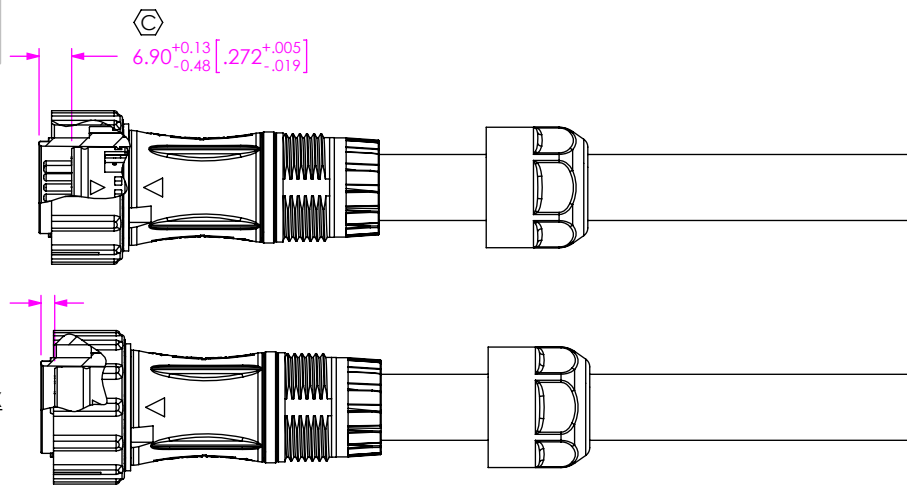
SHEET SCALE: 1:1

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ACCLIMATE CIRC. CABLE ASSEMBLY

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

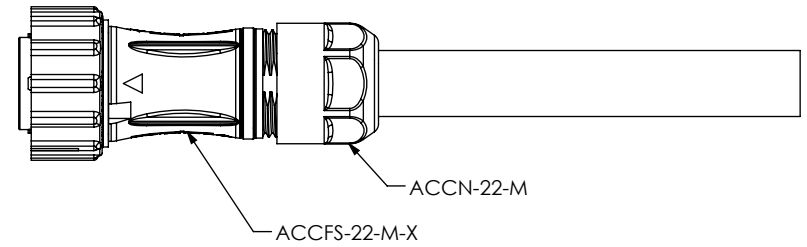
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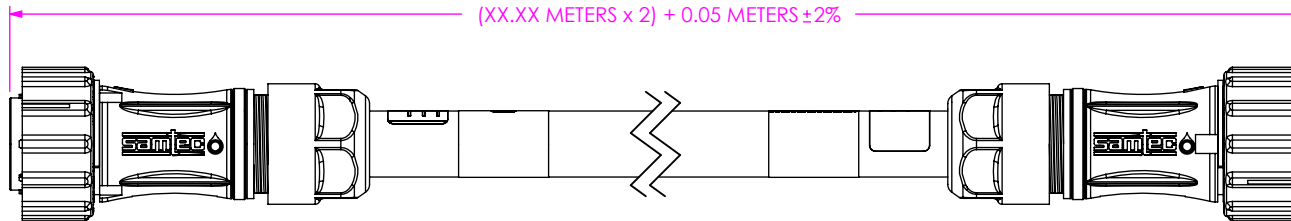
**IN-PROCESS 6**

WHILE MAKING SURE ALIGNMENT ARROWS LINE UP TO AID POLARIZATION BEAM ENGAGEMENT, INSERT SUB-ACXHB-22-X-XX SUB-ASSEMBLY INTO ACCFS-22-M-X UNTIL SNAP LOCKS ENGAGE. PUSH ACCGC-22 & ACCG-22-1-2 UP AGAINST BACK OF ACCFS-22-M-X



**IN-PROCESS 7**

THREAD ACCN-22-M ONTO ACCFS-22-M-X TO 15.00 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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