

Pb THIS PRODUCT MANUFACTURED WITH LEAD-FREE PROCESSING

DESIGNED & DIMENSIONED IN MILLIMETERS[INCHES]

DO NOT SCALE FROM THIS PRINT

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

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

PLATING

- (SEE NOTE 10 & 14)
- G: LIGHT, 10µ AU / 50µ NI MIN ON CONTACT
- H: HEAVY, 30µ AU / 50µ NI MIN ON CONTACT

KEYING FEATURE
(SEE NOTE 4)(SEE SHEET 6)

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

STYLE

-M: METAL

END 2

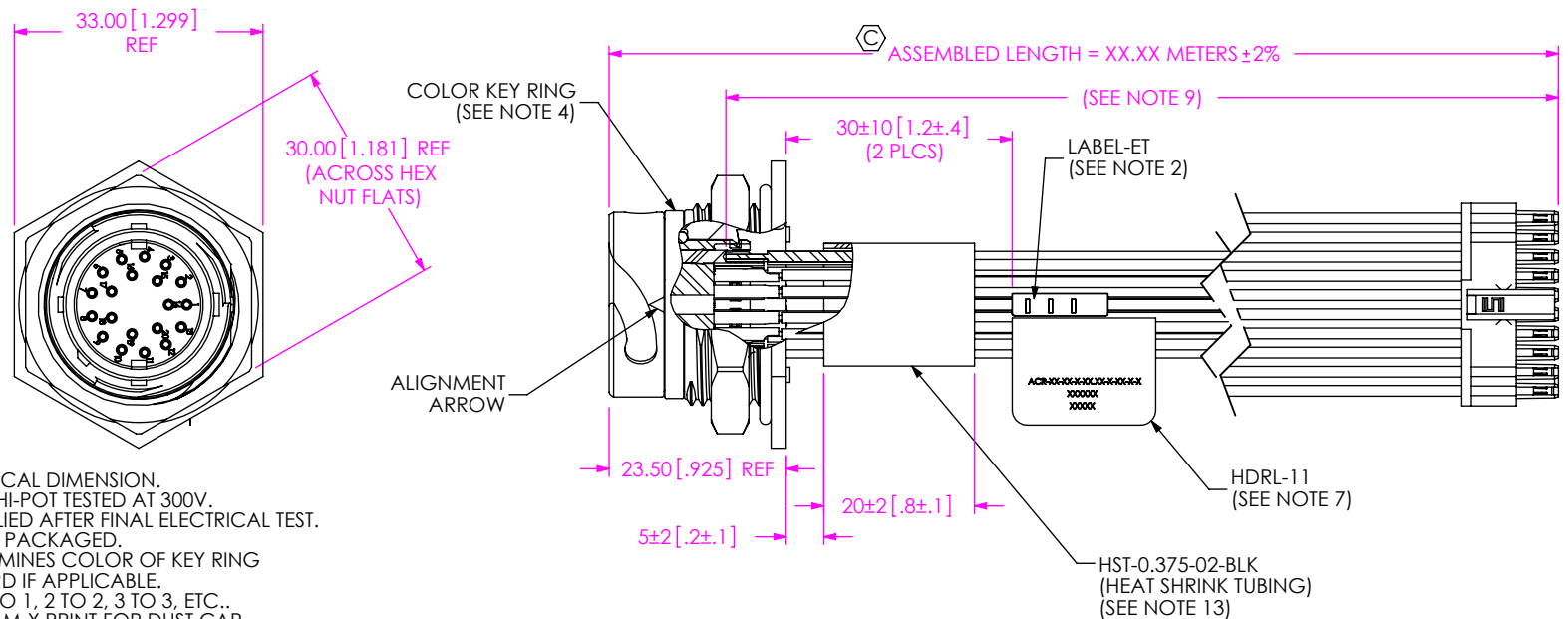
-BC: BLUNT CUT CONNECTOR (DETERMINED BY LEAD STYLE)

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% HI-POT TESTED 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-22-M-X PRINT FOR DUST CAP.
7. PLACE HDRL-11 (LABEL) IN FLAG STYLE, ON CABLE WHERE SHOWN. LABEL TO CONTAIN:
LINE 1 - PART NUMBER "ACR-22-XX-X-XX.XX-X-XX-M-X"
LINE 2 - SHOP ORDER NUMBER "XXXXXX"
LINE 3 - DATE CODE "XXXXXX"
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:
MPSS & MMSD: 10µ MIN GOLD.
RF316: 30µ MIN GOLD ON INNER CONTACT
3µ MIN GOLD ON OUTER CONTACT
3µ MIN GOLD ON REMAINING METAL PARTS.
11. NOTE DELETED.
12. WHEN MOUNTING PRODUCT TO PANEL TORQUE ACPN-22-M TO 15 IN-LBS.
13. APPLY HEAT SHRINK TUBING TO -01, -02, -05, & -06 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].

FIG 1
ACR-22-02-X-XX.XX-S-1-M-1 SHOWN

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]

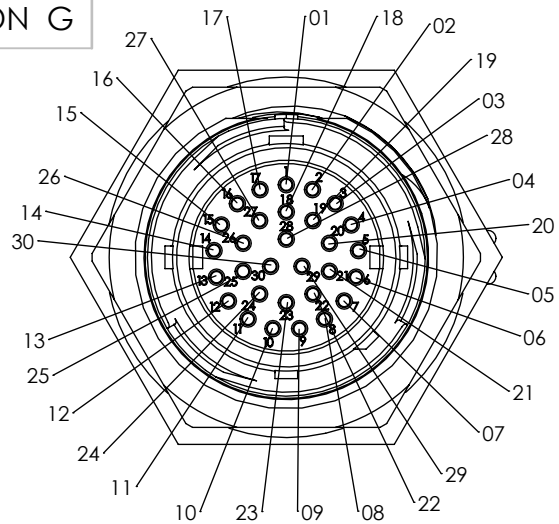
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MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 2:1
SHELL: ZINC ALLOY
INSULATOR: PBT, COLOR: BLACK
TERMINALS: BRASS
CONTACTS: BRASS/BeCu
BAYONET COLLAR: ZINC ALLOY
CABLE NUT: ZINC ALLOY
GROMMET: NBR
GROMMET CAGE: NYLON, COLOR: BLACK
COLOR RING: SILICONE

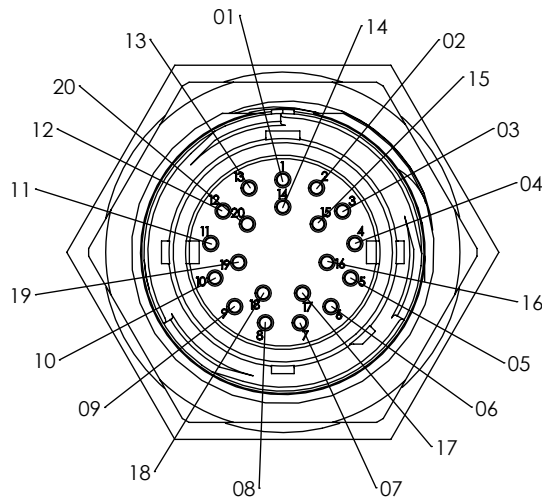


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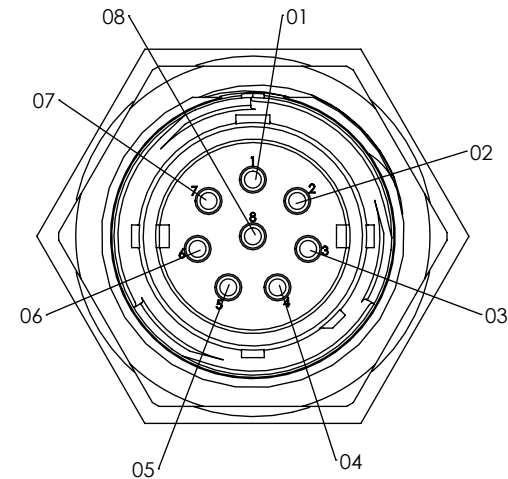
| | |
|--------------|------------------------------|
| DESCRIPTION: | M22 CABLE ASSEMBLY |
| DWG. NO. | ACR-22-XX-X-XX.XX-X-XX-M-X |
| BY: | CLAY W 9/8/2010 SHEET 1 OF 8 |



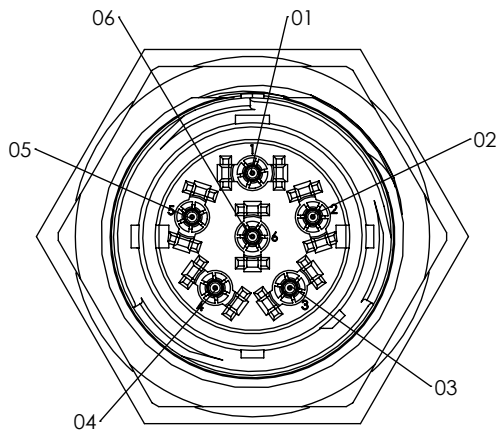
-01: 30 POS
(\varnothing 1.0 TERMINALS)



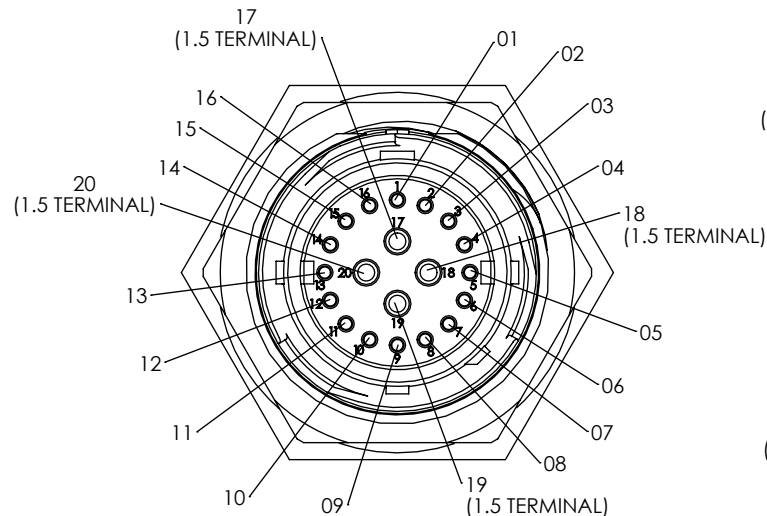
-02: 20 POS
(\varnothing 1.0 TERMINALS)



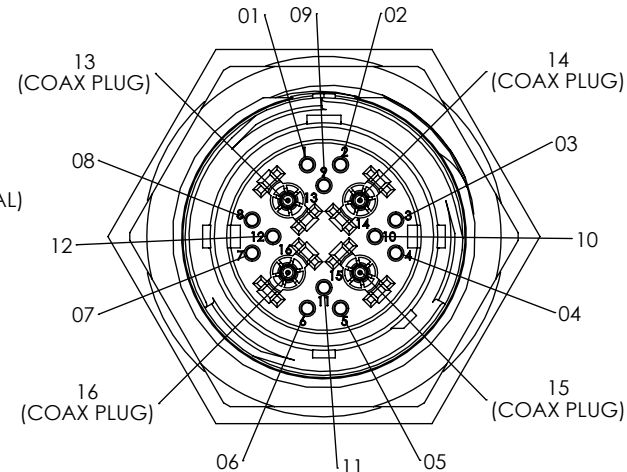
-03: 8 POS
(\varnothing 1.5 TERMINALS)



-04: 6 POS
(COAX PLUGS)



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



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

-T END OPTIONS

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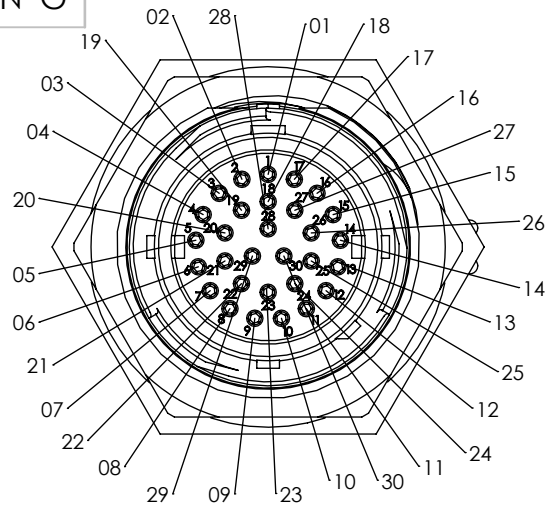


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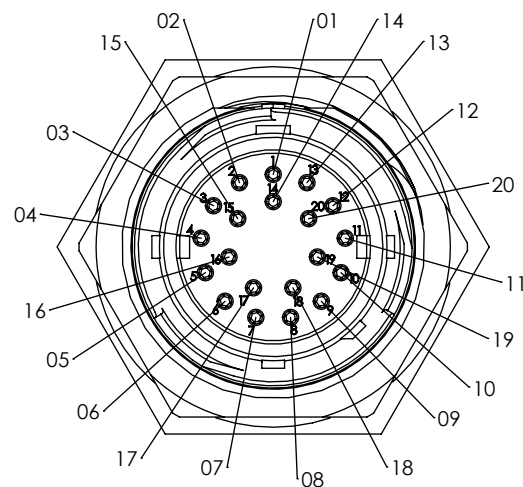
DESCRIPTION: M22 CABLE ASSEMBLY

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

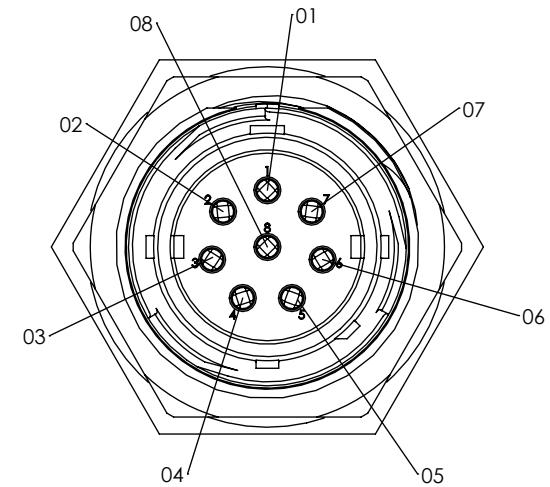
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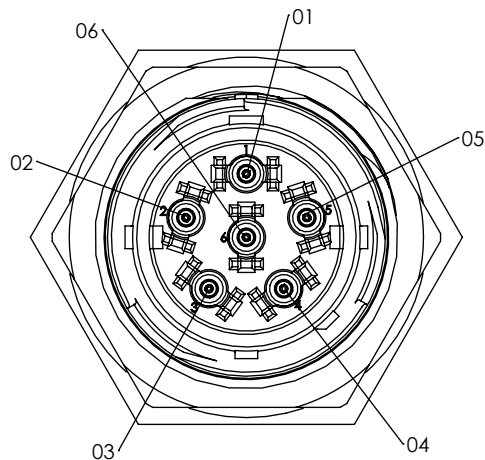
-01: 30 POS
(Ø 1.0 SOCKETS)



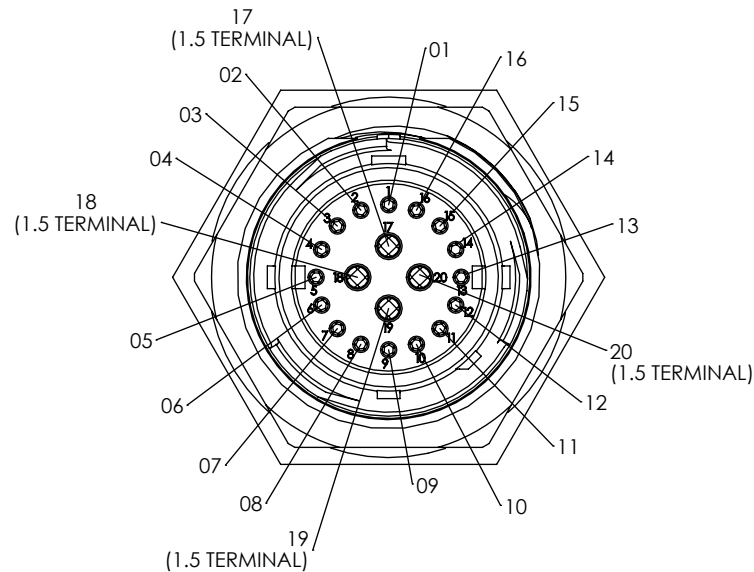
-02: 20 POS
(Ø 1.0 SOCKETS)



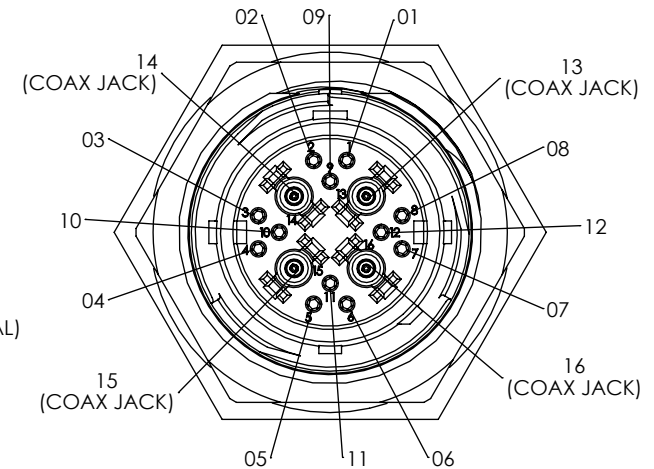
-03: 8 POS
(Ø 1.5 SOCKETS)



-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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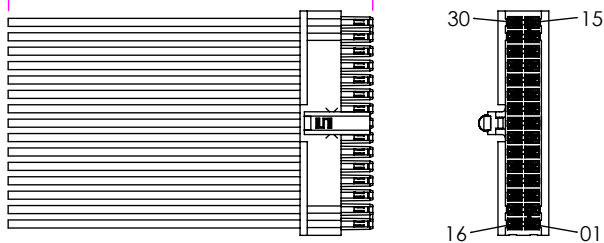
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DESCRIPTION: M22 CABLE ASSEMBLY

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

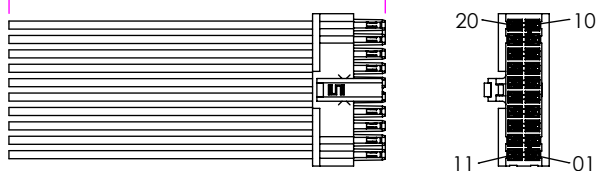
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MMSD ASSEMBLED LENGTH =
(XX.XX METERS X 39.37) - 0.63



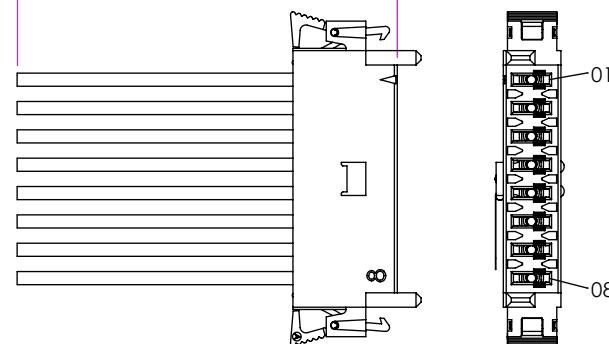
-01: 30 POS
(MMSD-15-24-L-XX.XX-S-K)

MMSD ASSEMBLED LENGTH =
(XX.XX METERS X 39.37) - 0.63



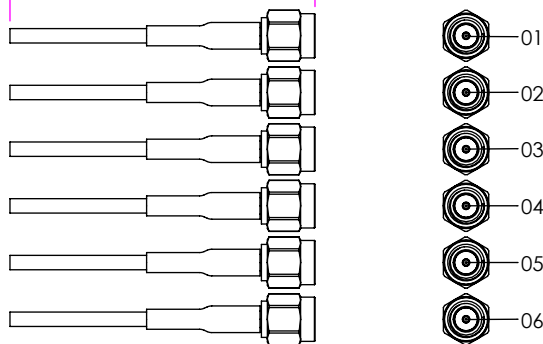
-02: 20 POS
(MMSD-10-24-L-XX.XX-S-K)

MPSS ASSEMBLED LENGTH =
(XX.XX METERS X 39.37) - 0.63



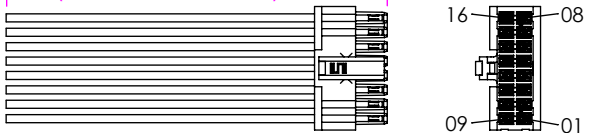
-03: 8 POS
(MPSS-08-16-L-XX.XX-SR)

RF316A O.A. CABLE LENGTH=
(XX.XX METERS X 1000) - 7.80
(SEE NOTE 15)

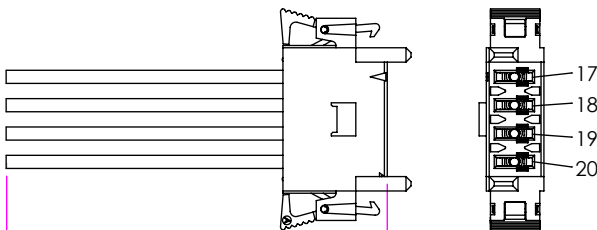


-04: 6 POS
(6 X RF316A-01SP1-SING-XXXX)

MMSD ASSEMBLED LENGTH =
(XX.XX METERS X 39.37) - 0.63



MPSS ASSEMBLED LENGTH=
(XX.XX METERS X 39.37) - 0.63

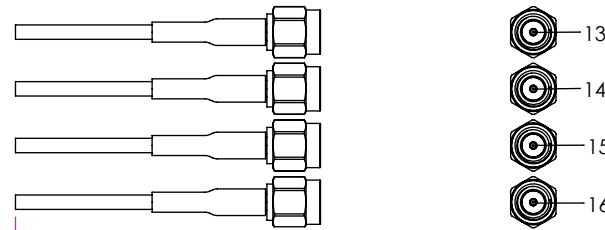


-05: 20 POS COMBO
(1 X MMSD-08-24-L-XX.XX-S-K)
(1 X MPSS-04-16-L-XX.XX-SR)

MMSD ASSEMBLED LENGTH =
(XX.XX METERS X 39.37) - 0.63



RF316A O.A. CABLE LENGTH=
(XX.XX METERS X 1000) - 7.80
(SEE NOTE 15)



-06: 16 POS COMBO
(1 X MMSD-06-24-L-XX.XX-S-K)
(4 X RF316A-01SP1-SING-XXXX)

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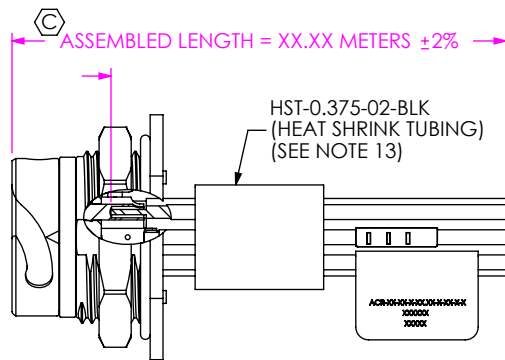


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DWG. NO.
ACR-22-XX-X-XX.XX-X-XX-M-X

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-BC END 2 OPTION
 BUILD DOUBLE-ENDED INITIALLY FOR E-TEST
 (SEE IN-PROCESS 7)

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 | | | | | 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 | | | |
| 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 | | | NA | GREEN / WHITE | DWC-16-19-300 | | | |
| 20 | DARK BLUE / WHITE | DWC-24-20-300 | DARK BLUE / WHITE | DWC-24-20-300 | | | NA | DARK BLUE / WHITE | DWC-16-20-300 | | | |
| 21 | VIOLET / WHITE | DWC-24-21-300 | | | | | | | | | | |
| 22 | GRAY / WHITE | DWC-24-22-300 | | | | | | | | | | |
| 23 | WHITE / BLACK | DWC-24-23-300 | | | | | | | | | NA | |
| 24 | BLACK / WHITE | DWC-24-24-300 | | | | | | | | | | |
| 25 | GREEN / YELLOW | DWC-24-25-300 | | | | | | | | | | |
| 26 | TAN / WHITE | DWC-24-26-300 | NA | | | | | | NA | | | |
| 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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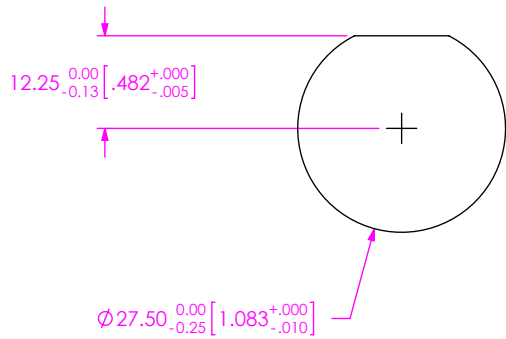


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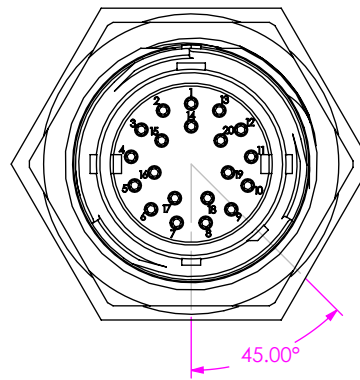
DESCRIPTION: M22 CABLE ASSEMBLY

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

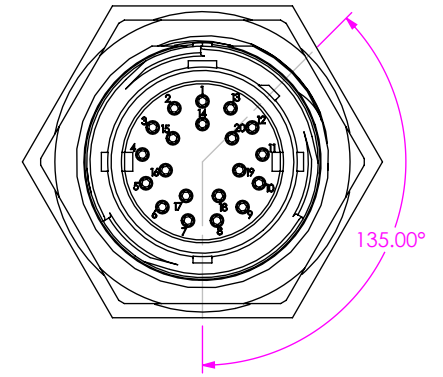
BY: CLAY W 9/8/2010 SHEET 5 OF 8



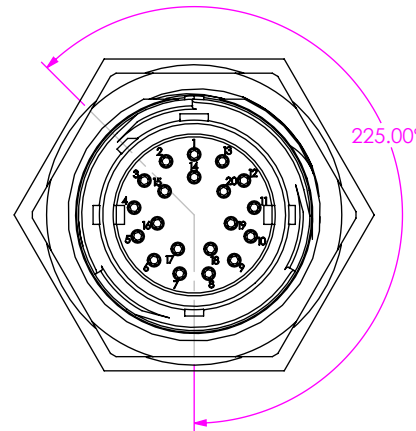
RECOMMENDED PANEL OPENING
(SEE NOTE 8)



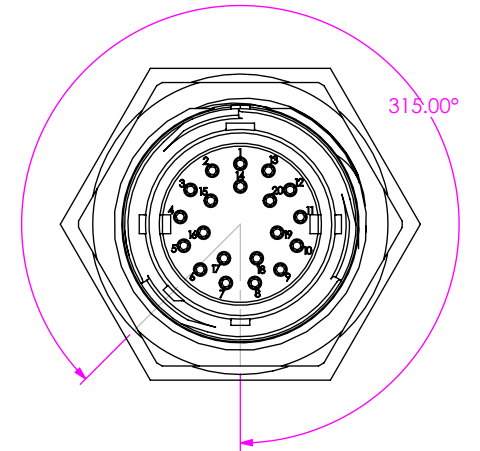
-1
(ORANGE KEY RING)



-2
(GREEN KEY RING)



-3
(BLUE KEY RING)



-4
(YELLOW KEY RING)

KEYING FEATURE
(SEE NOTE 4)

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SHEET SCALE: 3:4



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

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

REVISION G

5.50±0.25 [.217±.010]

WIRE STRIP

DWC-XX-XX-XXX

ACPFS-22-M-X
(SEE TABLE 1)

HST-0.375-02-BLK
(HEAT SHRINK TUBING)
(SEE NOTE 13)

CCA-316 COAX
(SEE NOTE 15)

COAX STRIP

REFERENCE AC-P-C-X-ST-CA1
& AC-J-C-X-ST-CA1 PRINTS FOR
COAX STRIP DIMENSIONS

ACPFS-22-M-X
(SEE TABLE 1)

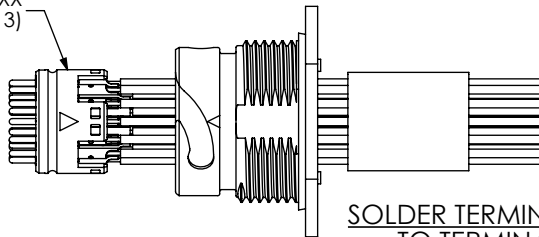
TABLE 1

| KEYING FEATURE | SHELL PART # |
|----------------|--------------|
| -1 | ACPFS-22-M-1 |
| -2 | ACPFS-22-M-2 |
| -3 | ACPFS-22-M-3 |
| -4 | ACPFS-22-M-4 |

IN-PROCESS 1

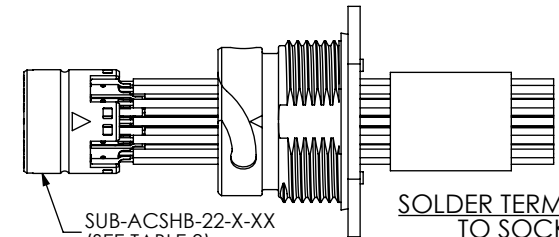
FEED CABLES FROM END 2 DISCRETE CABLE ASSEMBLY THROUGH HST-0.375-02-BLK & ACPFS-22-M-X & STRIP CABLES TO DIMENSIONS SHOWN AND TIN INNER CONDUCTORS. FOR -BC OPTION, FEED DWC/COAX & STRIP TO DIMENSIONS SHOWN

SUB-ACTHB-22-X-XX
(SEE TABLE 3)



SOLDER TERMINATION
TO TERMINALS

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



SOLDER TERMINATION
TO SOCKETS

SUB-ACSHB-22-X-XX
(SEE TABLE 3)

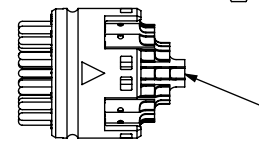
11.80 [.465] REF
SUB-ACTHB-22-X-XX
OR ACTHB-22-X
(SEE TABLE 3)

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

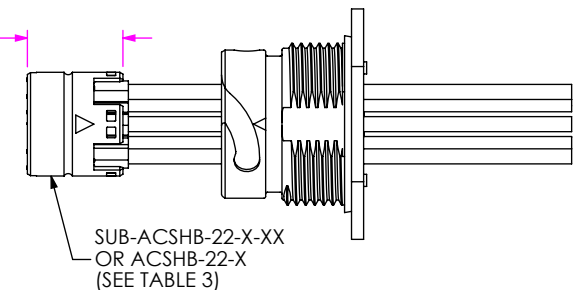
COAX PLUG INSERTION

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

15.80 [.622] REF



ON LEADSTYLES -01, -02, -03, -05, & -06
SOLDER INNER RING OF TERMINALS/SOCKETS
FIRST AND THEN OUTER RING



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)

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



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

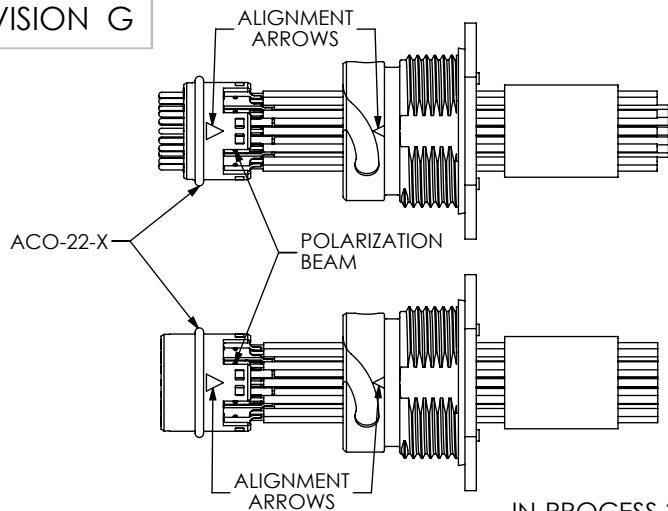
DWG. NO.

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

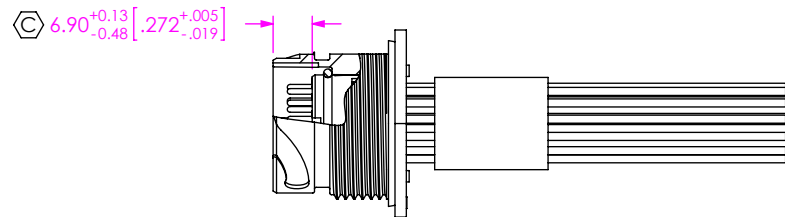
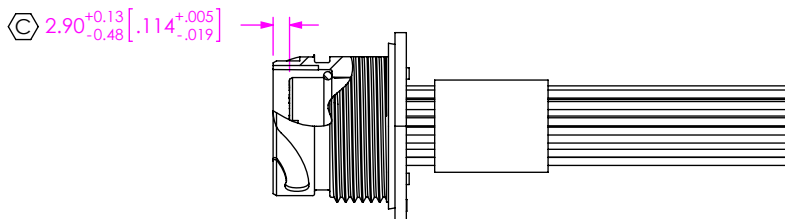
BY: CLAY W

9/8/2010

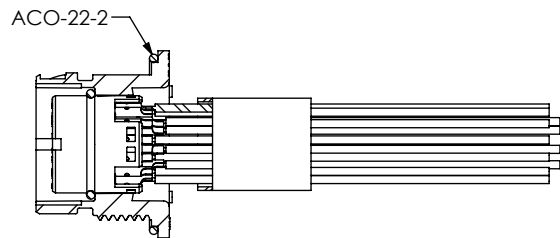
SHEET 7 OF 8



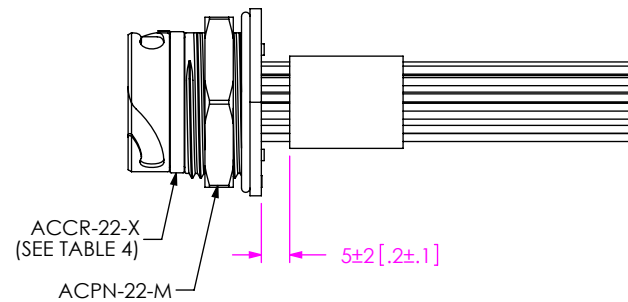
IN-PROCESS 3
 PUSH ACO-22-1 ORING ONTO SUB-ACTHB-22-X-X
 OR SUB-ACSHB-22-X-X SUB-ASSEMBLIES



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

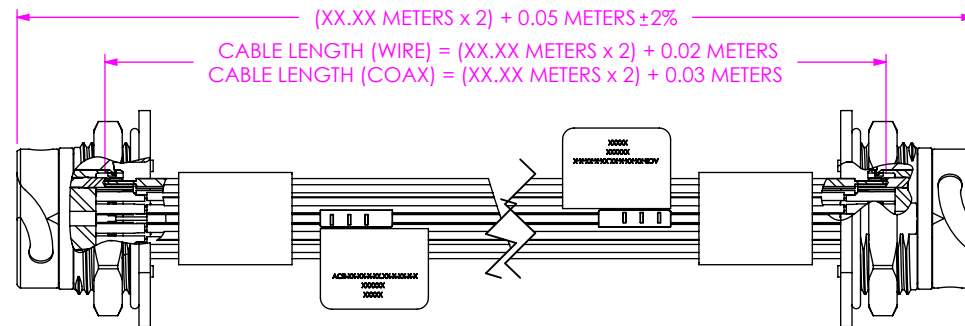


IN-PROCESS 5
 INSERT ACO-22-2 WHERE SHOWN



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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 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