

DO NOT
SCALE FROM
THIS PRINT



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

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), CCA-316
(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), CCA-316
- 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), CCA-316
(6 X 1.0 TERM/SKT), 24 AWG

PLUG
SIZE

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

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

OVERMOLDED PLASTIC

END 2
-T: TERMINAL
-S: SOCKET
-BC: BLUNT CUT

END 1
-T: TERMINAL
-S: SOCKET (NOT AVAILABLE
WITH END 2 -T)

ASSEMBLED LENGTH
XX.XX (IN METERS)
(0.25 METER MIN TO 50.00 METER MAX)

PLATING

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

* = NOT RELEASED

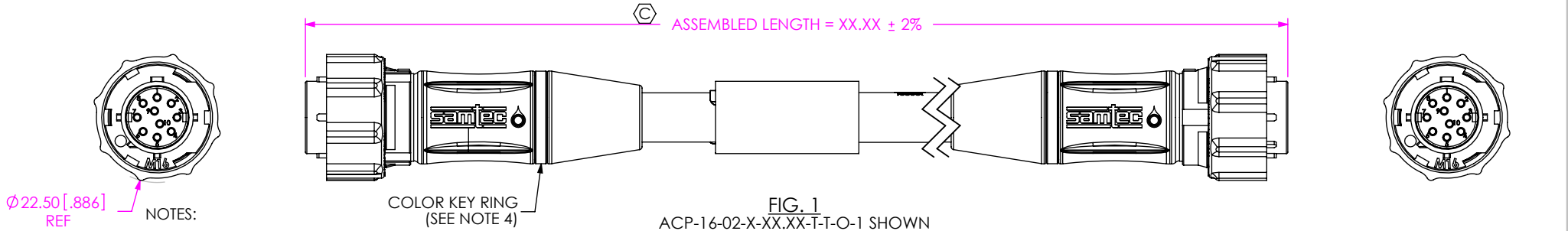
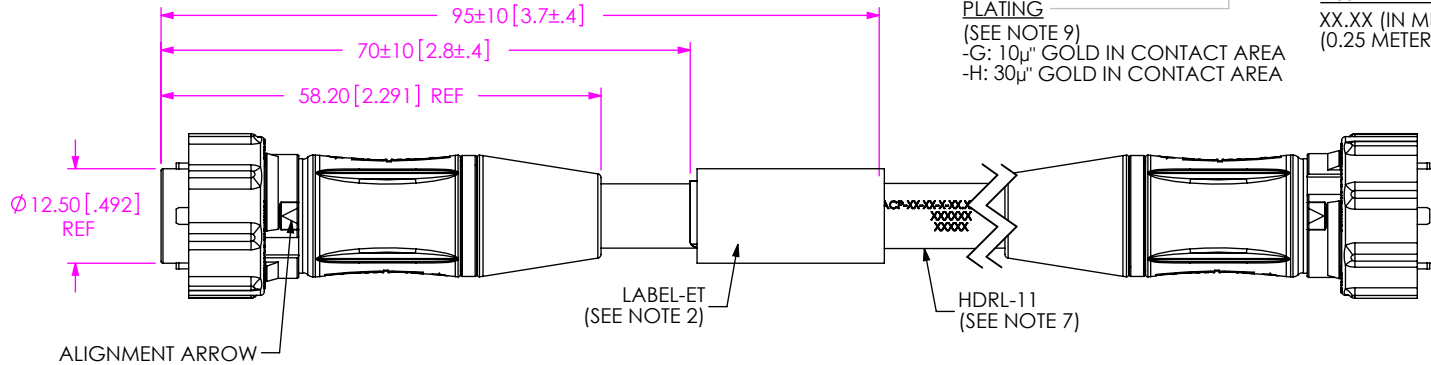


FIG. 1
ACP-16-02-X-XX.XX-T-T-O-1 SHOWN

Ø22.50 [.886]
REF

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-ACP-16-P-X PRINT FOR DUST CAP.
7. PLACE HDRL-11 (LABEL) ON CABLE WHERE SHOWN. LABEL TO CONTAIN:
LINE 1 - PART NUMBER "ACP-16-XX-X-XX.XX-X-XX-O-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 SHEET SCALE: 1:1

SHELL: NYLON, COLOR: BLACK
INSULATOR: PBT
PREMOLD: MD-NYL-MA-OM646-BK
OVERMOLD: MD-NYL-ZY-70G13-BK
TERMINALS: BRASS
CONTACTS: BRASS/BeCu

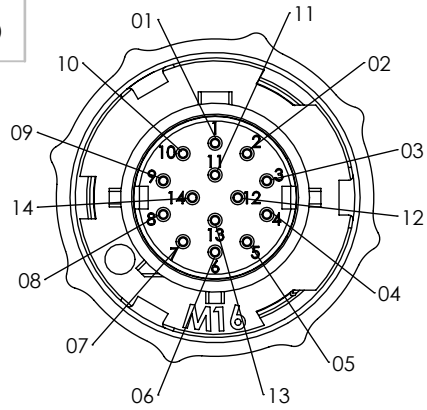


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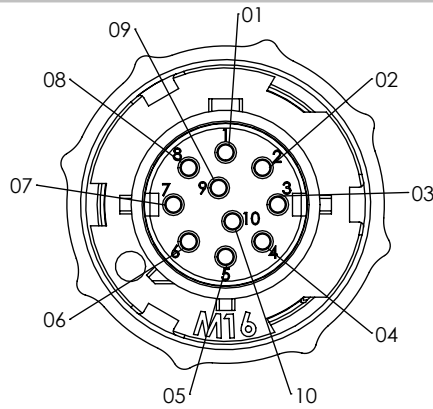
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ACCLIMATE CIRC. CABLE ASSEMBLY

DWG. NO.
ACP-16-XX-X-XX.XX-X-XX-O-X

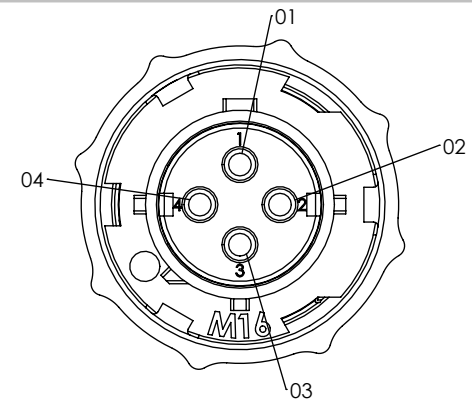
BY: D.SCHMELZ 04/30/2010 SHEET 1 OF 7



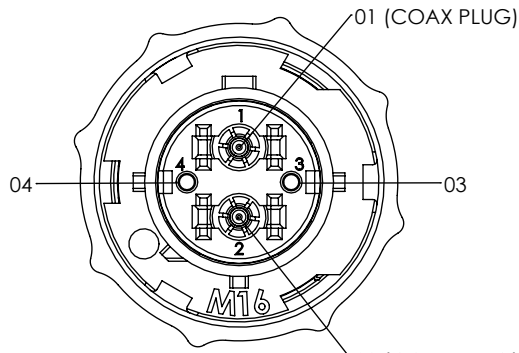
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(0.5 TERMINALS)



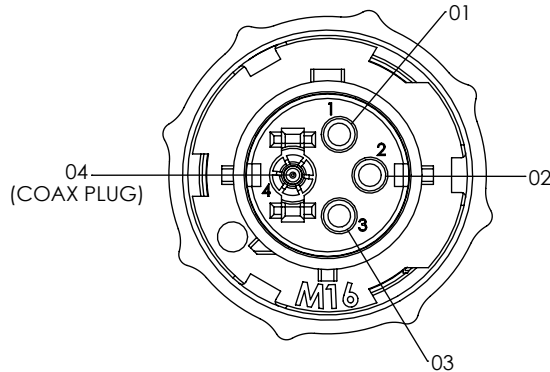
-02: 10 POS
(1.0 TERMINALS)



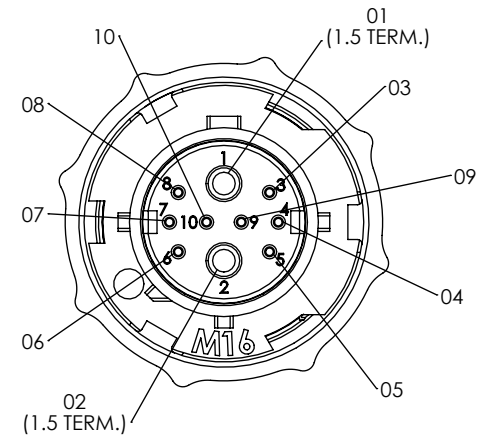
-03: 4 POS
(1.5 TERMINALS)



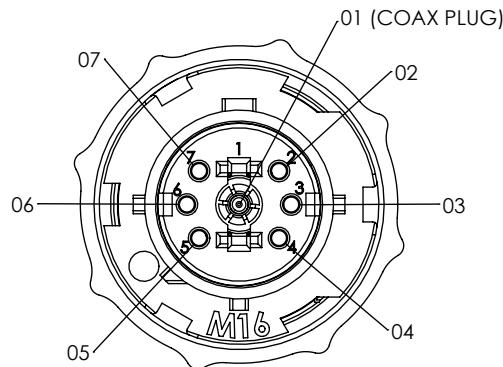
-04: 4 POS COMBO
(2 X COAX PLUGS)
(2 X Ø 1.0 TERMINALS)



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



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



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

-T END OPTIONS

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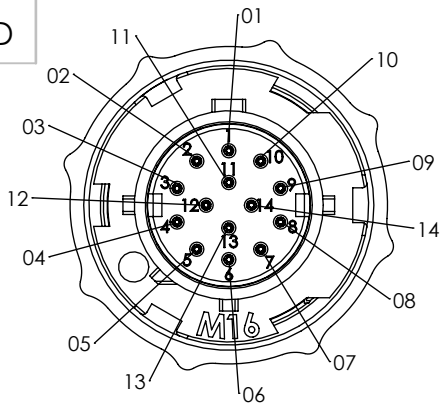


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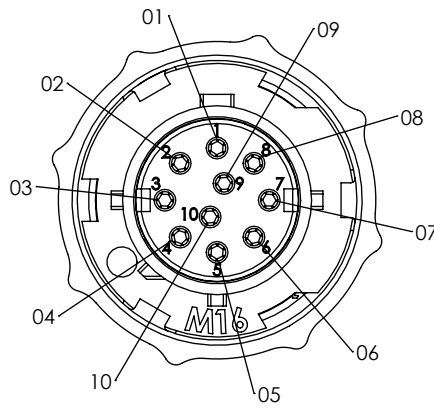
DESCRIPTION: **ACCLIMATE CIRC. CABLE ASSEMBLY**

DWG. NO. **ACP-16-XX-X-XX.XX-X-XX-O-X**

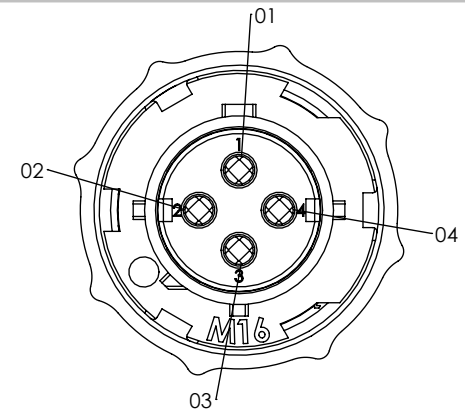
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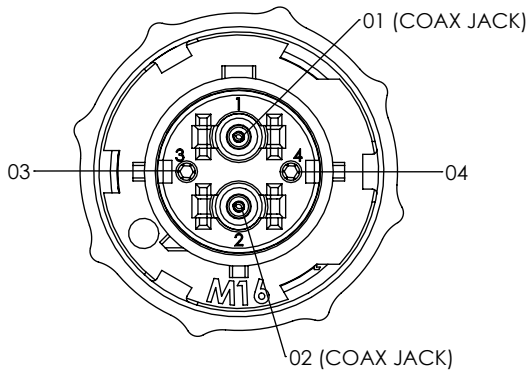
-01: 14 POS
(\varnothing 0.5 SOCKET)



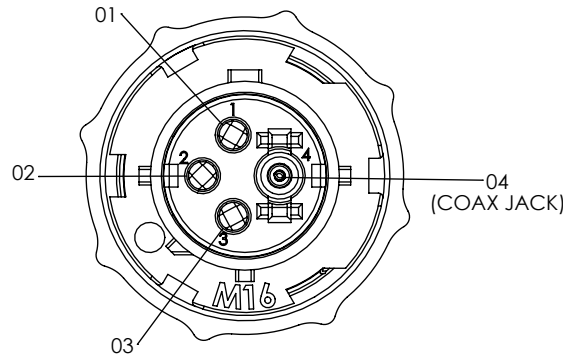
-02: 10 POS
(\varnothing 1.0 SOCKET)



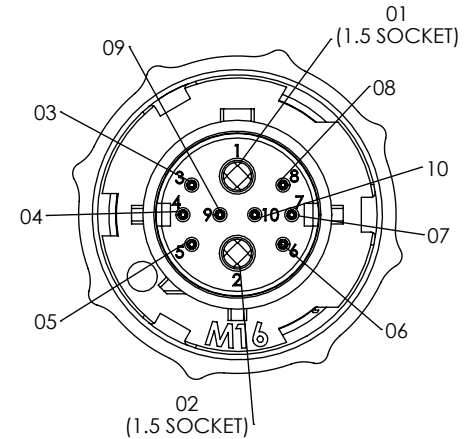
-03: 4 POS
(\varnothing 1.5 SOCKET)



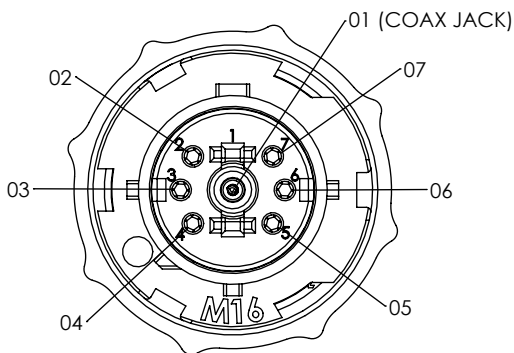
-04: 4 POS COMBO
(2 X COAX JACKS)
(2 X \varnothing 1.0 SOCKETS)



-05: 4 POS COMBO
(3 X \varnothing 1.5 SOCKETS)
(1 X COAX JACK)



-06: 10 POS COMBO
(2 X \varnothing 1.5 SOCKET)
(8 X \varnothing 0.5 SOCKET)



-07: 7 POS COMBO
(1 X COAX JACK)
(6 X \varnothing 1.0 SOCKETS)

-S END OPTIONS

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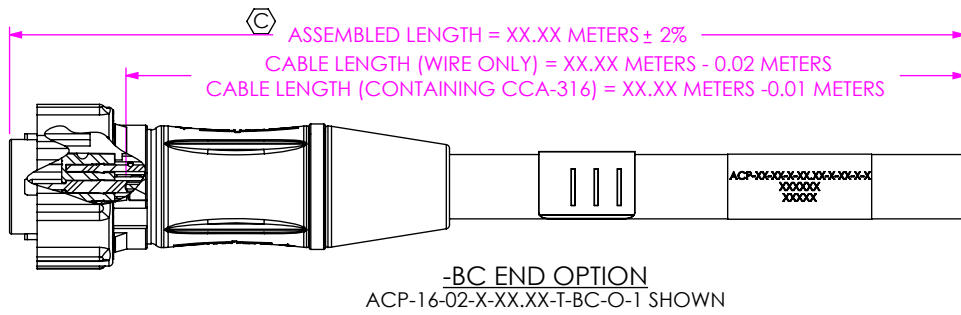


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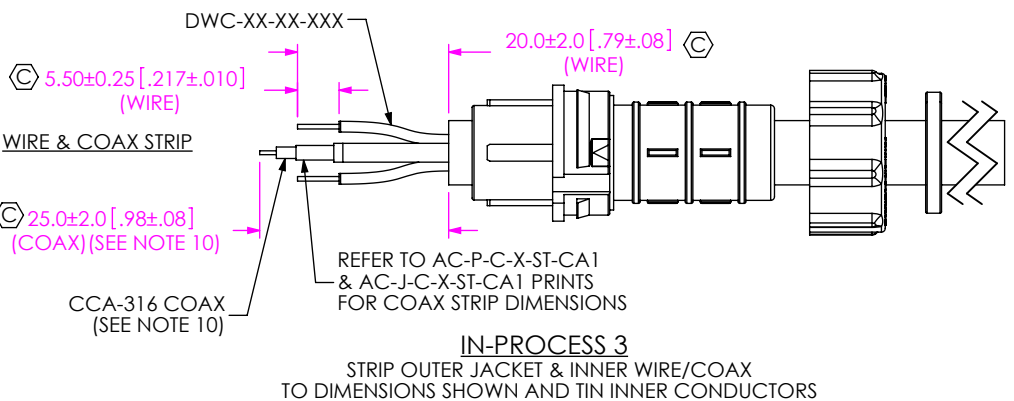
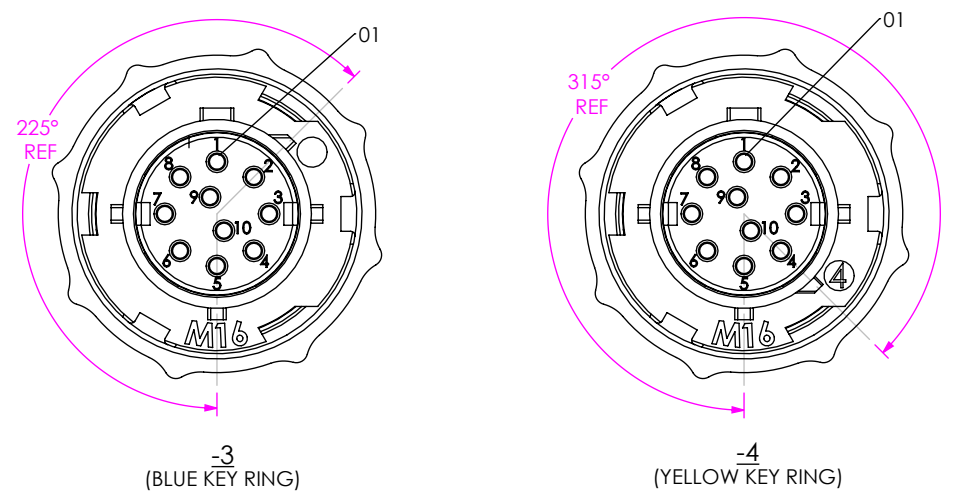
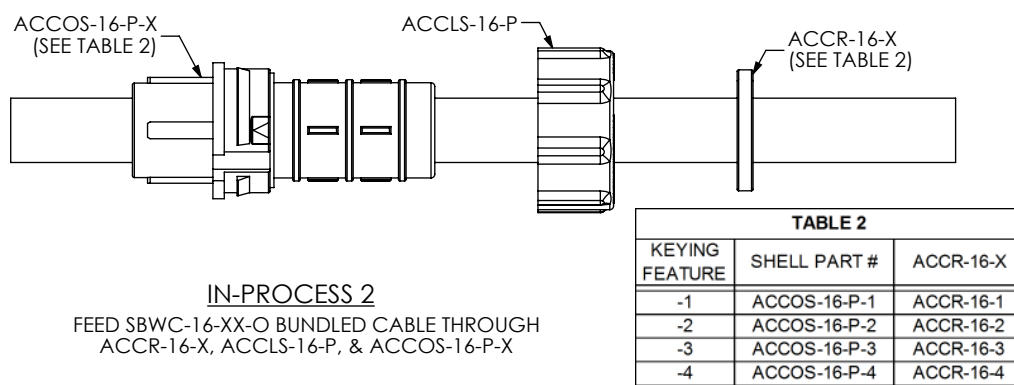
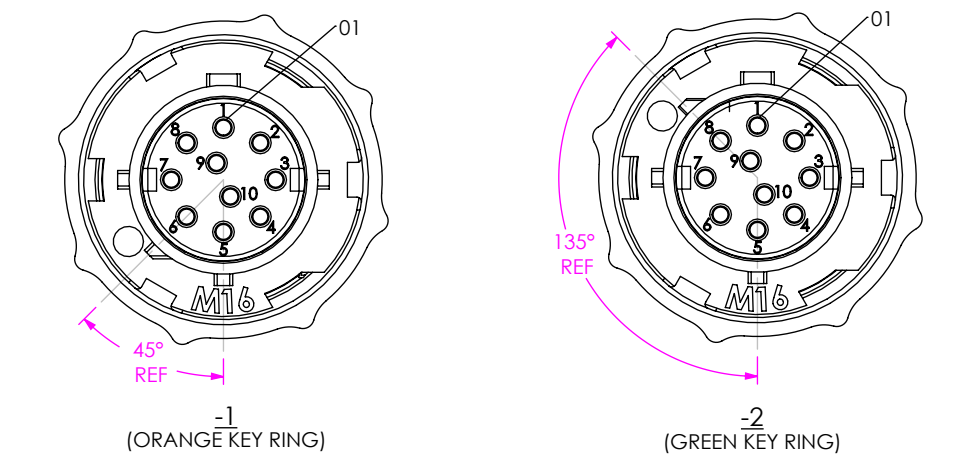
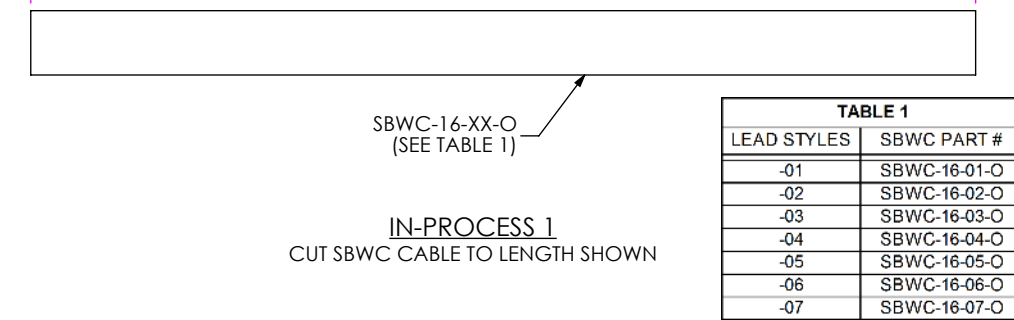
DESCRIPTION: ACCLIMATE CIRC. CABLE ASSEMBLY

DWG. NO. ACP-16-XX-X-XX.XX-X-XX-O-X

BY: D.SCHMELZ 04/30/2010 SHEET 3 OF 7



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



KEYING OPTIONS
 (SEE NOTE 4)

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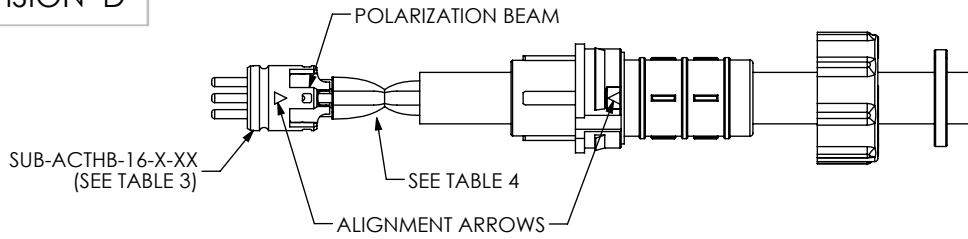
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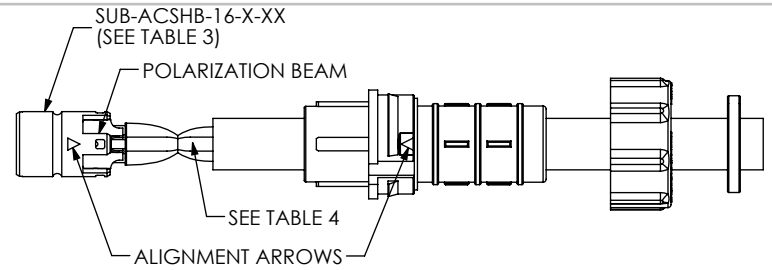
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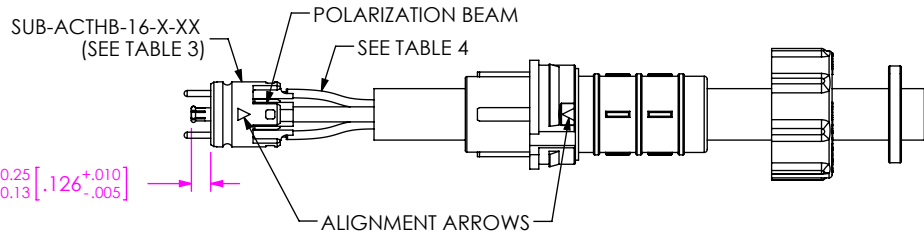
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SOLDER TERMINATION TO TERMINALS

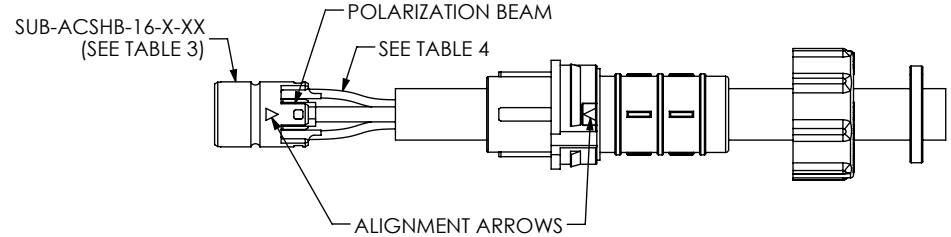


SOLDER TERMINATION TO SOCKETS



COAX PLUG INSERTION

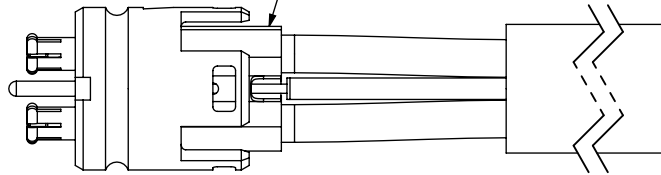
AFTER TERMINATION PUSH COAX PLUG INTO CORE UNTIL RETENTION BEAMS ENGAGE AND LOCK IT INTO PLACE



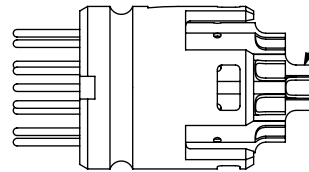
COAX JACK INSERTION

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

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



IN-PROCESS 4

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

TABLE 4
WIRE COLOR

POSITION	LEAD STYLE						
	-01	-02	-03	-04	-05	-06	-07
01	BROWN	BROWN	BROWN	COAX	BROWN	BROWN	COAX
02	RED	RED	RED	COAX	RED	RED	RED
03	ORANGE	ORANGE	ORANGE	ORANGE	ORANGE	ORANGE	ORANGE
04	YELLOW	YELLOW	YELLOW	YELLOW	COAX	YELLOW	YELLOW
05	GREEN	GREEN				GREEN	GREEN
06	DARK BLUE	DARK BLUE				DARK BLUE	DARK BLUE
07	VIOLET	VIOLET				VIOLET	VIOLET
08	GRAY	GRAY				GRAY	
09	WHITE	WHITE				WHITE	
10	BLACK	BLACK	NA	NA	NA	BLACK	
11	GREEN/BLACK						NA
12	TAN						
13	DARK BLUE/YELLOW	NA				NA	
14	PINK						

TABLE 3

LEAD STYLES	END1/END 2	SUB-ASSEMBLY/HOLDER BODY PART #		COAX PLUG/JACK PART #	
		PLATING		AC-X-C-H-ST-CA1	QTY
		-G	-H		
-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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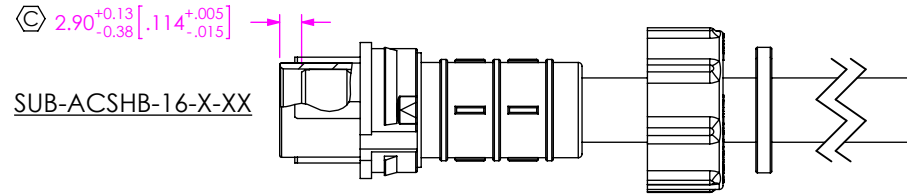
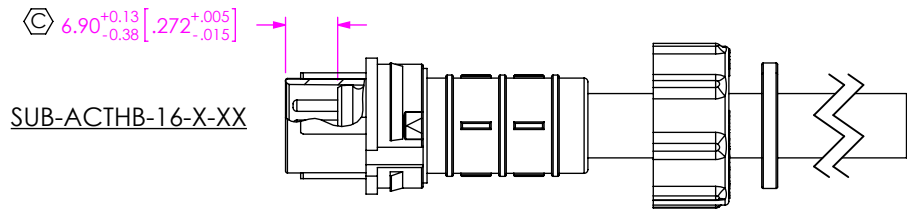
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SHEET SCALE: 1:1

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ACCLIMATE CIRC. CABLE ASSEMBLY

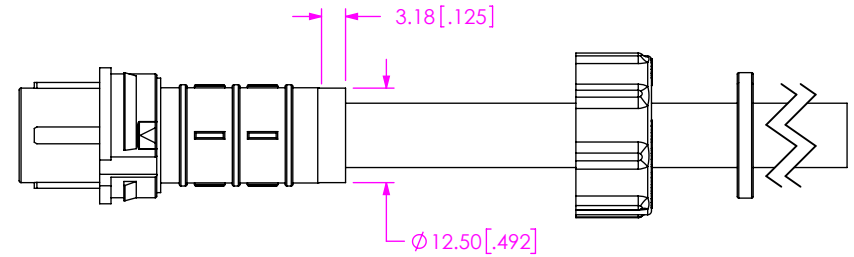
DWG. NO.
ACP-16-XX-X-XX.XX-X-XX-O-X

BY: D.SCHMELZ 04/30/2010 SHEET 5 OF 7



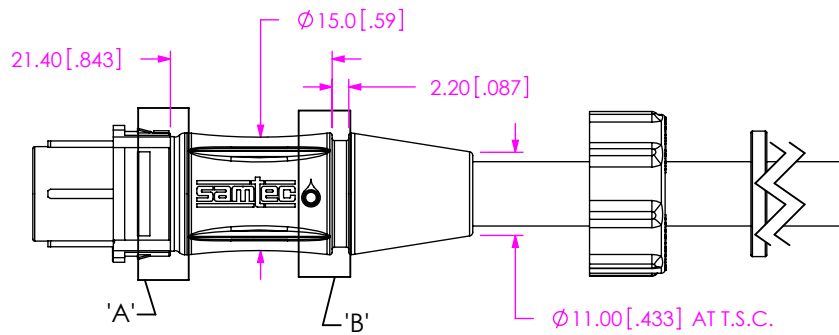
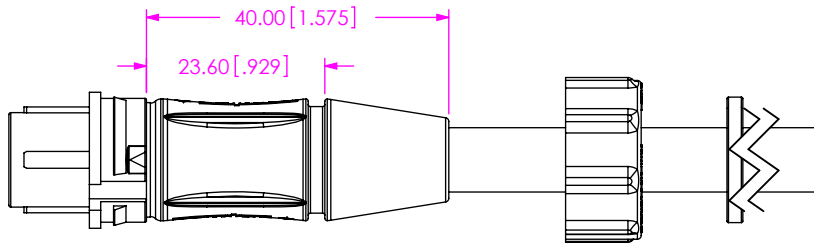
IN-PROCESS 5

WHILE MAKING SURE ALIGNMENT ARROWS LINE UP TO AID POLARIZATION BEAM ENGAGEMENT, INSERT SUB-ACXHB-16-X-XX SUB-ASSEMBLY INTO ACCOS-16-P-X UNTIL SNAP LOCKS ENGAGE.

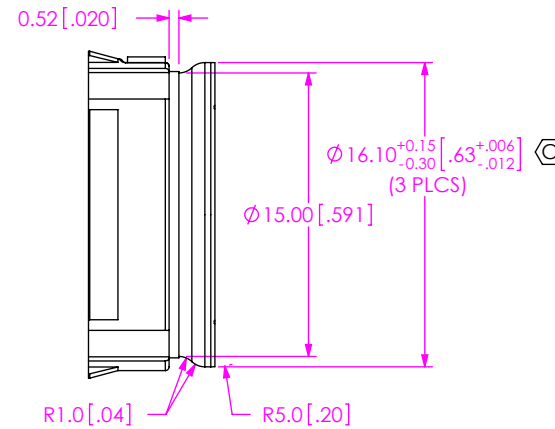


IN-PROCESS 6

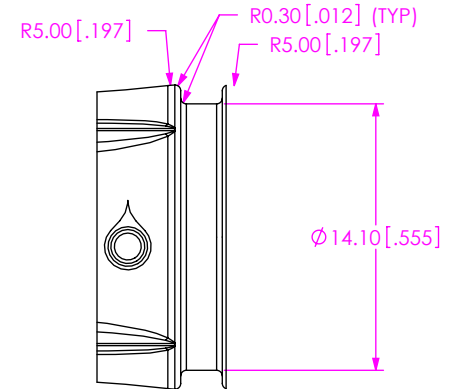
APPLY PRE-MOLD



IN-PROCESS 7
APPLY OVERMOLD GRIP



DETAIL 'A'
SCALE 2.5 : 1



DETAIL 'B'
SCALE 2.5 : 1

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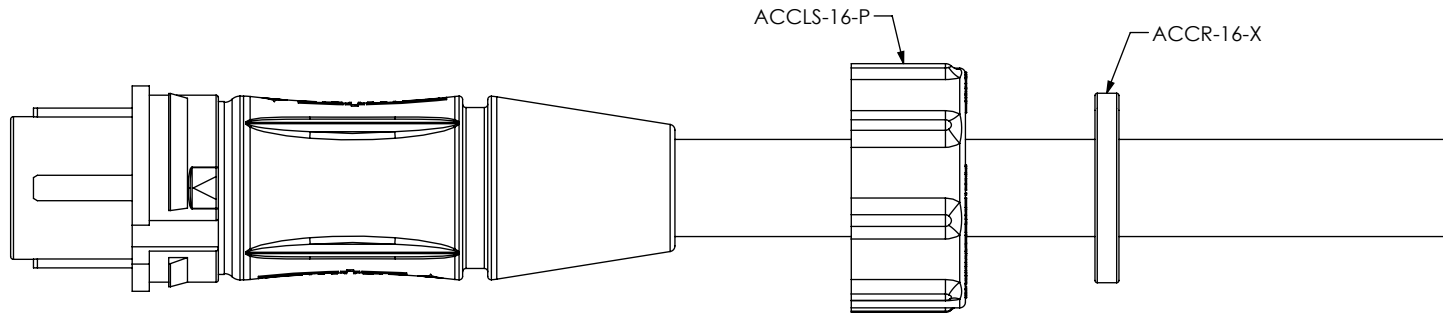


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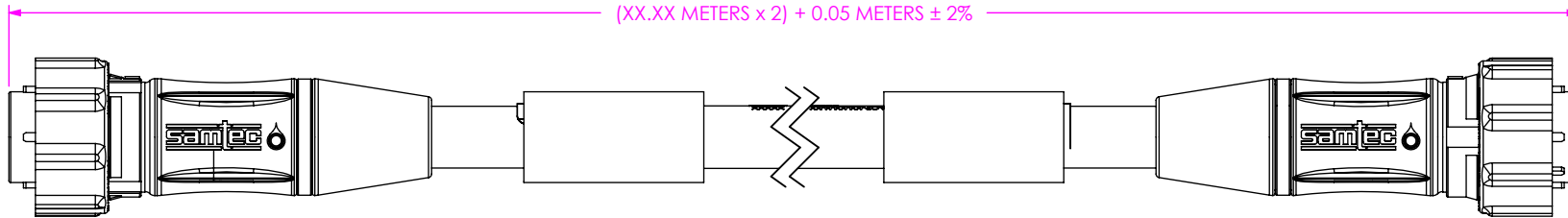
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DWG. NO.
ACP-16-XX-X-XX.XX-X-XX-O-X

BY: D.SCHMELZ 04/30/2010 SHEET 6 OF 7



IN-PROCESS 8
 PUSH ACCLS-16-P OVER OVERMOLD
 AND ACCOS-16-P-X UNTIL IT SNAPS.
 STRETCH ACCR-16-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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