

ACRK Series Assembly/Wiring Instructions

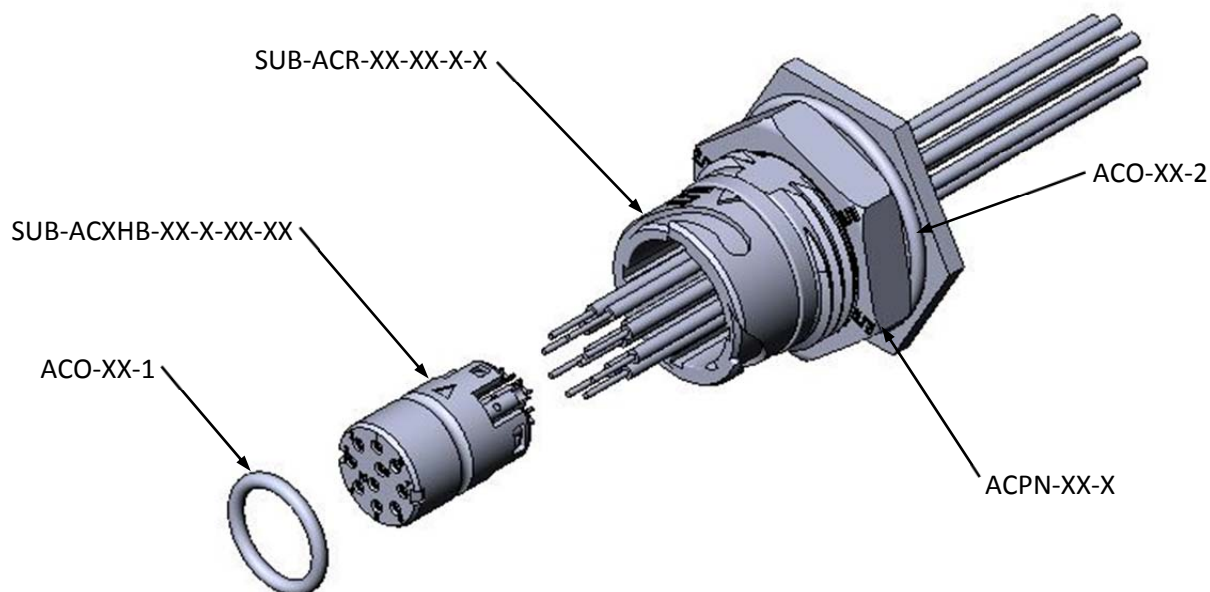
For Use with Non-RF Lead styles

Following are instructions for assembling Samtec's ACRK-XX Series AccliMate™ sealed panel assembly using our Field Termination Kit. AccliMate™ products come in three shell sizes:

ACRK-12 Series – 12mm

ACRK-16 Series – 16mm

ACRK-22 Series- 22mm



STRIP WIRES

1. Strip the wires according to FIG 1. Pre tin the tips of the stripped wires. Place the wires through the SUB-ACR-XX-XX-X-X (See FIG 2).

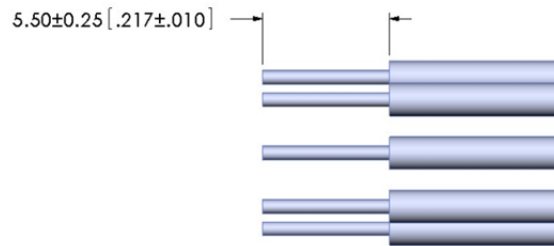
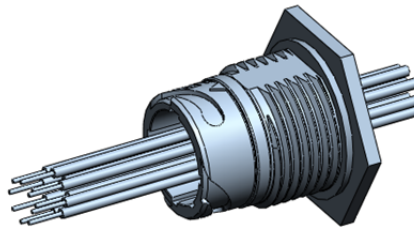


FIG 1 above. FIG 2 below.



SOLDER WIRES

2. Solder stripped and tinned wires into the pins of SUB-ACXHB-XX-X-XX-XX per IPC-A-620 standards. Arrows indicate alignment (See FIG 3). The front and back of the SUB-ACXHB-XX-X-XX-XX are marked with position numbers.

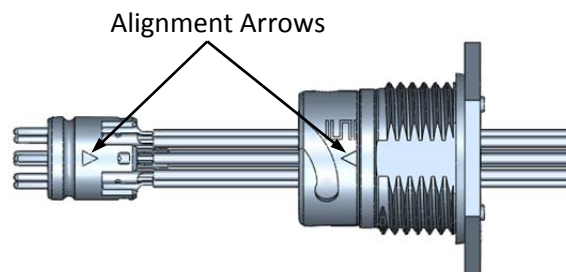


FIG 3

INSTALL O-RING

3. Roll ACO-XX-1 over SUB-ACXHB-XX-X-XX-XX until it rests in the trough as shown (See FIG 4).



FIG 4

INSTALL HOLDER BODY

4. Samtec suggests assembling the ACRK Series using the CAT-AC-XX-M which is sold separately. Additional protection of the individual discrete wires can be achieved by applying heat shrink tubing (not supplied) over the soldered connections. **Keeping arrows aligned** and using the wide end of the tool, which is marked ACR-XX, align the two keying features on the CAT-AC-XX-M with the keying features on SUB-ACXHB-XX-X-XX-XX. Then support SUB-ACXHB-XX-X-XX-XX with tool CAT-AC-XX-M while pushing SUB-ACR-XX-XX-X-X until hearing a “click”. Then remove tool (See FIG 5).

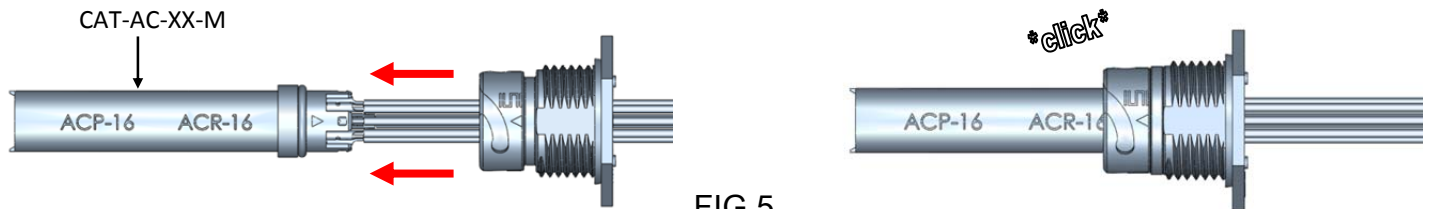
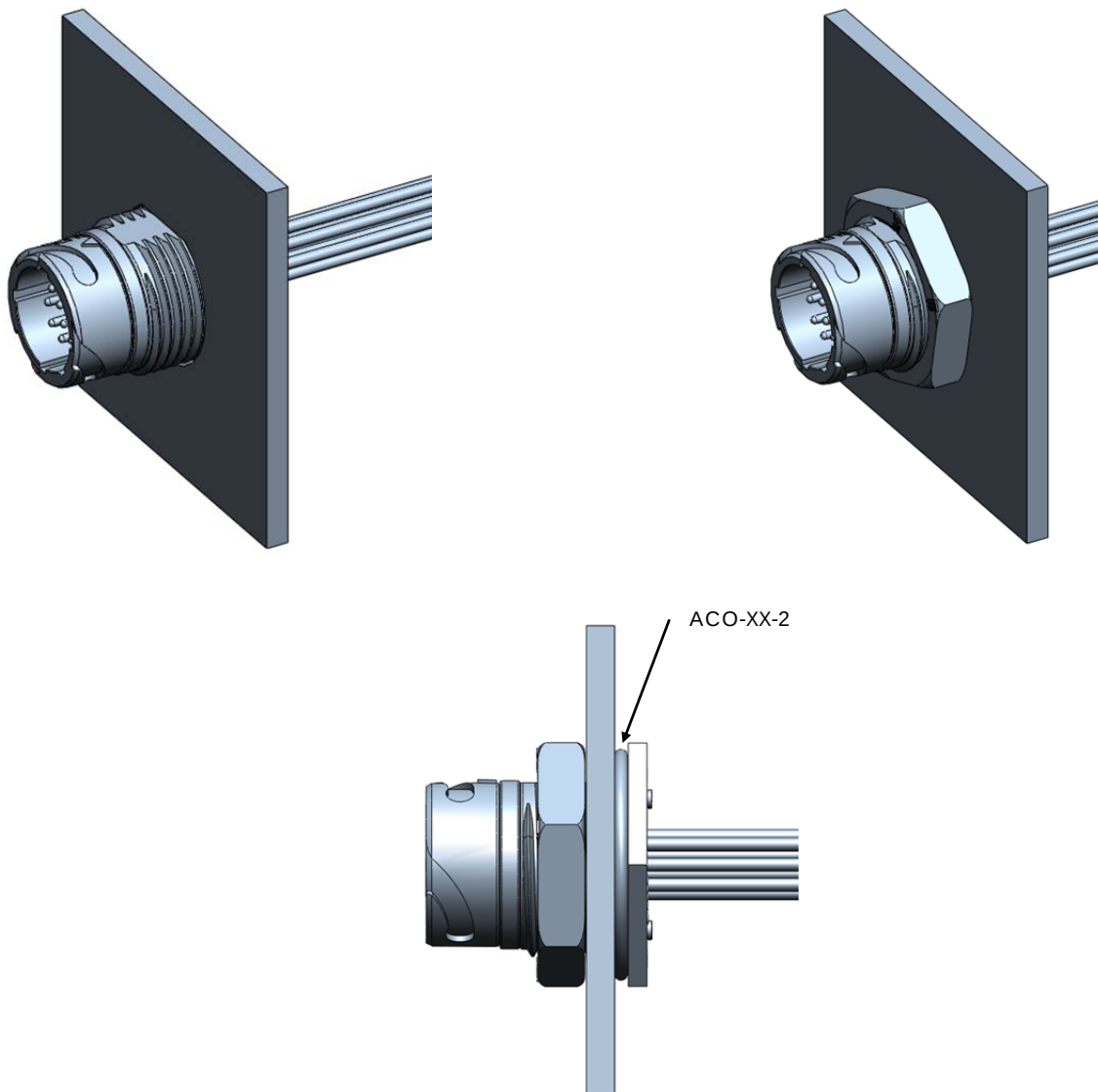


FIG 5

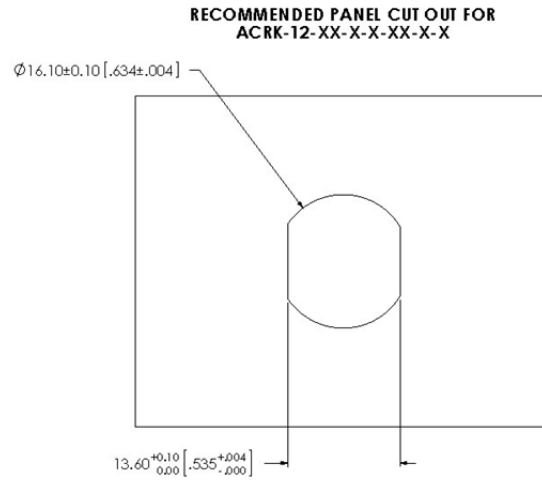
INSTALLING ACRK INTO PANEL

5. Remove panel nut (ACPN-XX-X). Insert assembly into panel (See Appendix 1 for recommended panel cutout). Screw nut ACPN-XX-X onto assembly and torque to 15.0 in-lbs securing the assembly onto the panel and sealing the gap.

CAUTION: Over tightening the nut could dislodge the ACO-XX-2 o-ring resulting in an imperfect seal.



APPENDIX 1



**RECOMMENDED PANEL CUT OUT FOR
ACRK-16-XX-X-X-XX-X-X/ACRK-22-XX-X-X-XX-X-X**

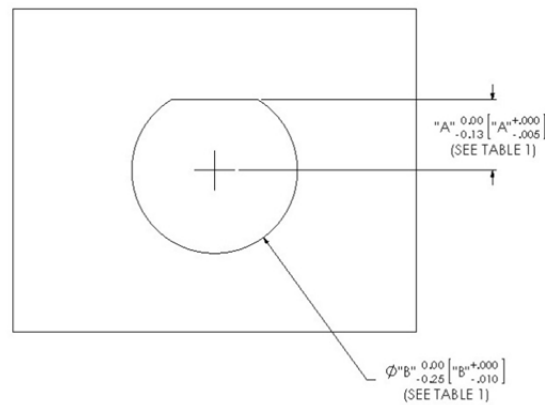


TABLE 1		
PART NUMBER	"A"	"B"
ACRK-16-XX-X-X-XX-X-X	8.75 [0.344]	20.50 [0.807]
ACRK-22-XX-X-X-XX-X-X	12.25 [0.482]	27.50 [1.083]

For additional questions regarding assembling any of Samtec's AccliMate™ line of sealed systems, please contact Samtec's Interconnect Processing Group at 1-800-SAMTEC-9 (USA & Canada) or 812-944-6733 or email us at ipg@samtec.com.