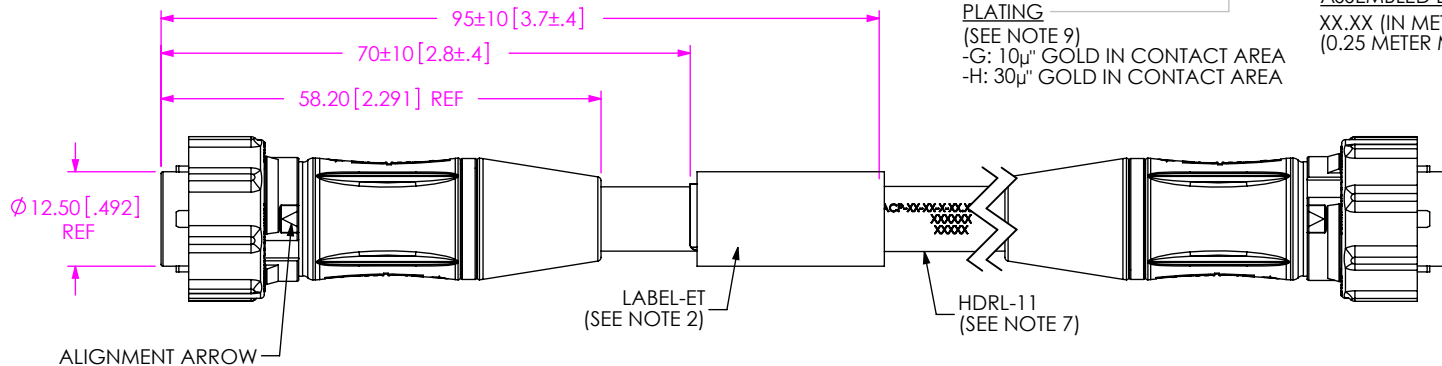


DO NOT  
SCALE FROM  
THIS PRINT

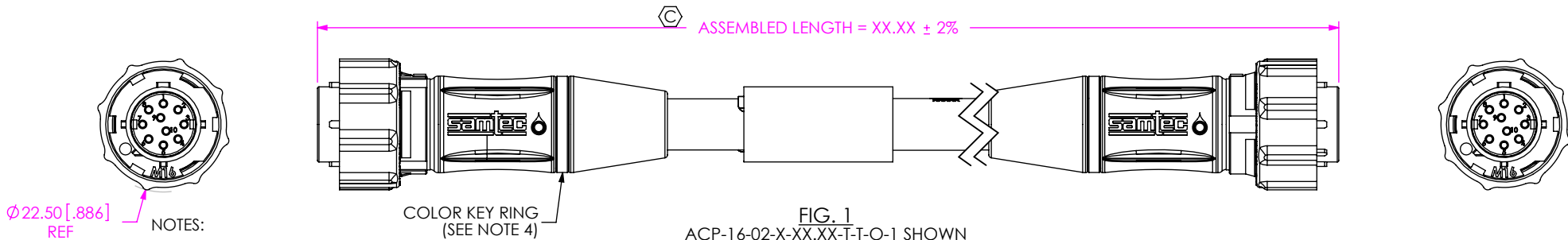


**THIS PRODUCT MANUFACTURED  
WITH LEAD-FREE PROCESSING**

- PLUG 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), 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
- 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



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 LINKS 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

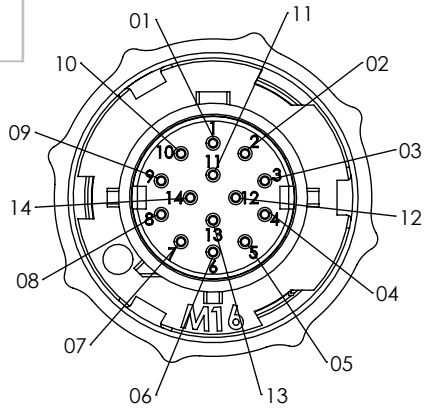


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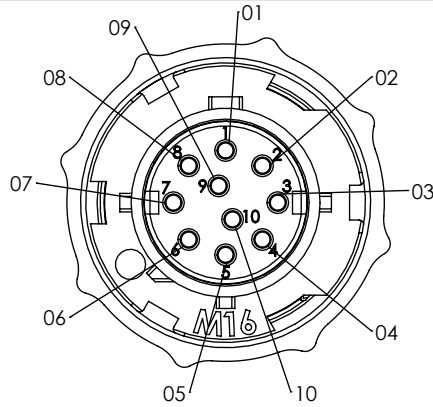
DESCRIPTION:  
ACCLIMATE CIRC. CABLE ASSEMBLY

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

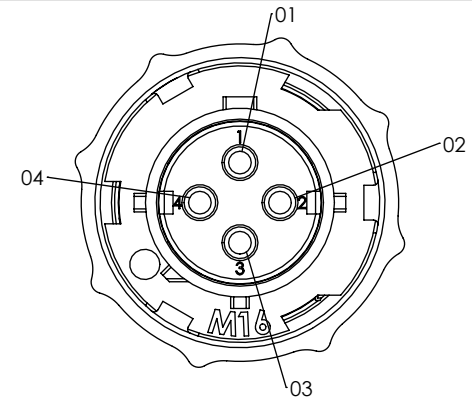
BY: D.SCHMELZ 04/30/2010 SHEET 1 OF 7



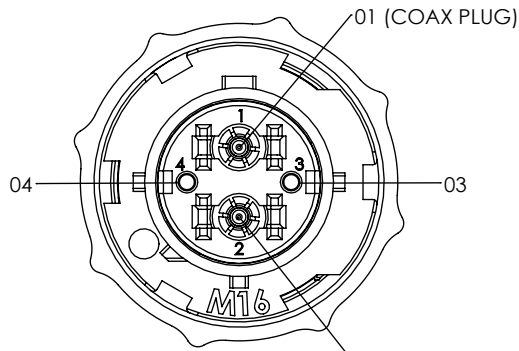
**-01: 14 POS**  
(0.5 TERMINALS)



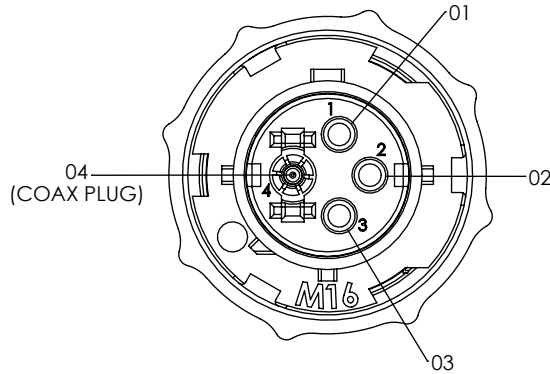
**-02: 10 POS**  
(1.0 TERMINALS)



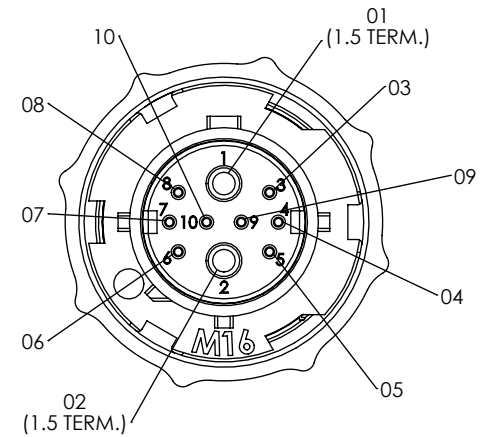
**-03: 4 POS**  
(1.5 TERMINALS)



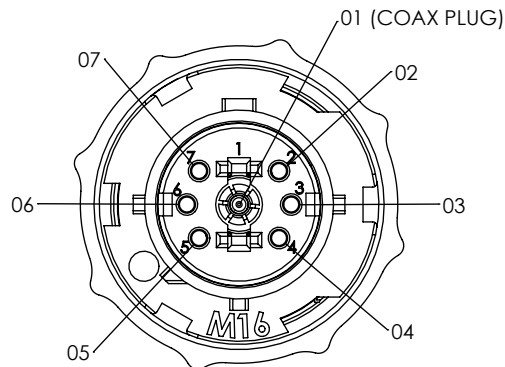
**-04: 4 POS COMBO**  
(2 X COAX PLUGS)  
(2 X Ø 1.0 TERMINALS)



**-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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SHEET SCALE: 1.5:1

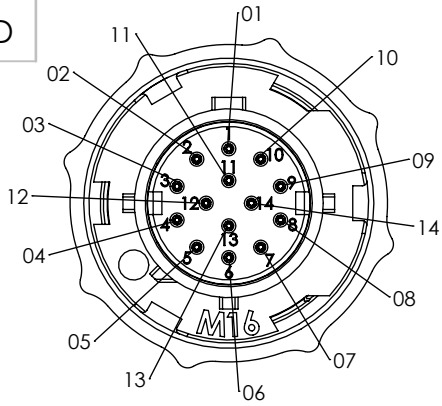


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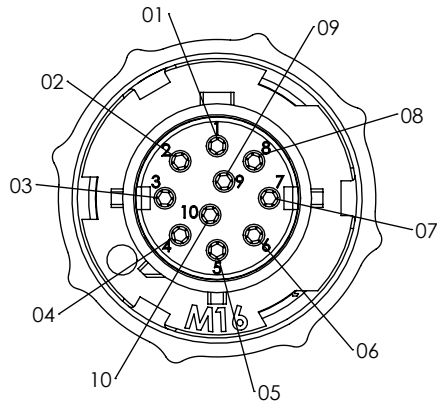
DESCRIPTION: ACCLIMATE CIRC. CABLE ASSEMBLY

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

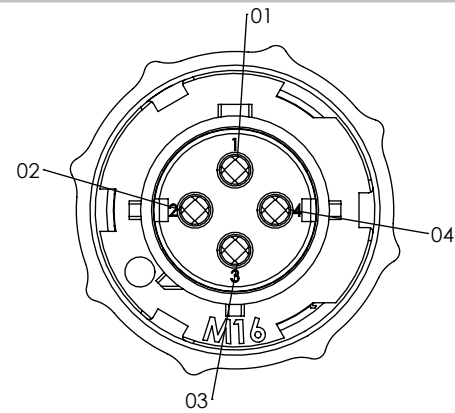
BY: D.SCHMELZ 04/30/2010 SHEET 2 OF 7



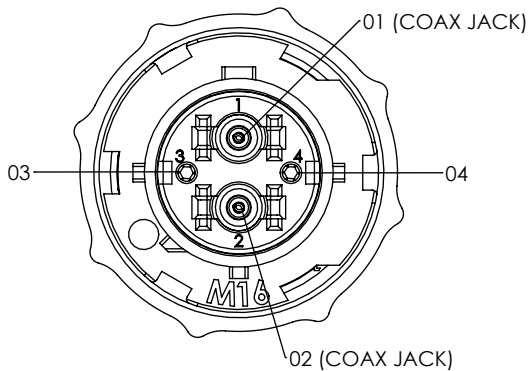
-01: 14 POS  
(Ø0.5 SOCKET)



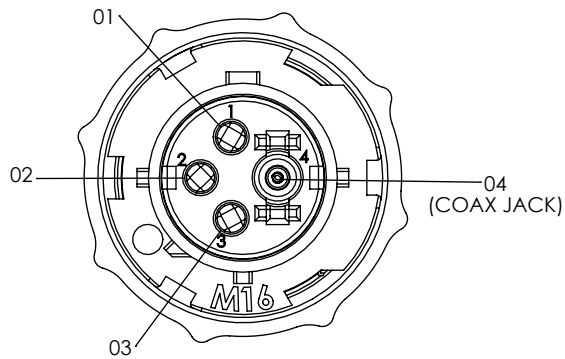
-02: 10 POS  
(Ø1.0 SOCKET)



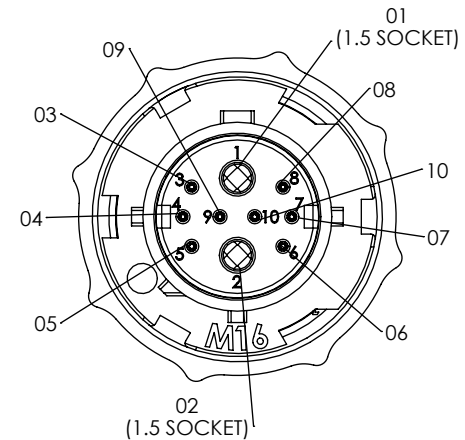
-03: 4 POS  
(Ø1.5 SOCKET)



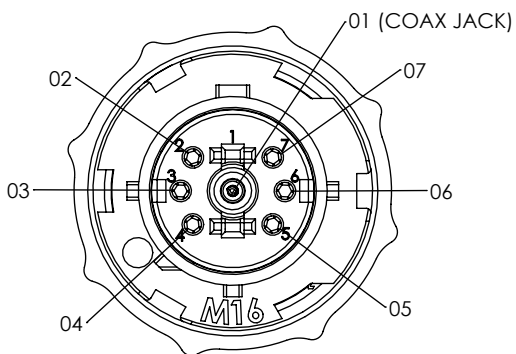
-04: 4 POS COMBO  
(2 X COAX JACKS)  
(2 X Ø1.0 SOCKETS)



-05: 4 POS COMBO  
(3 X Ø1.5 SOCKETS)  
(1 X COAX JACK)



-06: 10 POS COMBO  
(2 X Ø1.5 SOCKET)  
(8 X Ø0.5 SOCKET)



-07: 7 POS COMBO  
(1 X COAX JACK)  
(6 X Ø1.0 SOCKETS)

-S END OPTIONS

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SHEET SCALE: 1.5:1

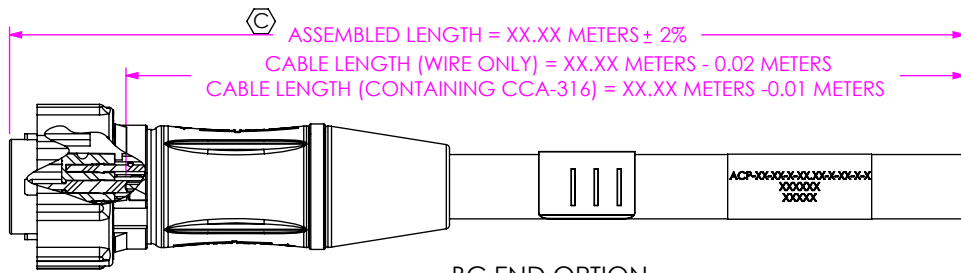


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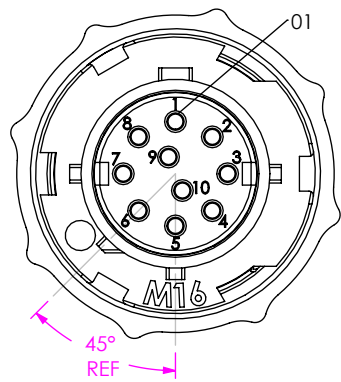
DESCRIPTION: ACCLIMATE CIRC. CABLE ASSEMBLY

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

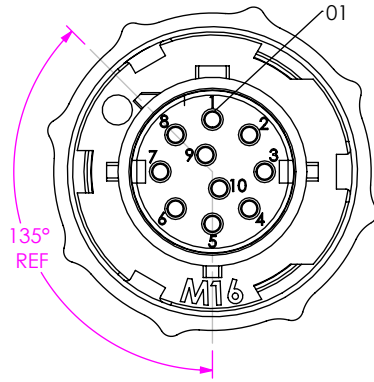
BY: D.SCHMELZ 04/30/2010 SHEET 3 OF 7



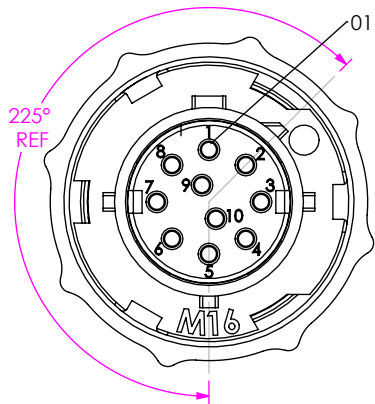
-BC END OPTION  
ACP-16-02-X-XX.XX-T-BC-O-T SHOWN



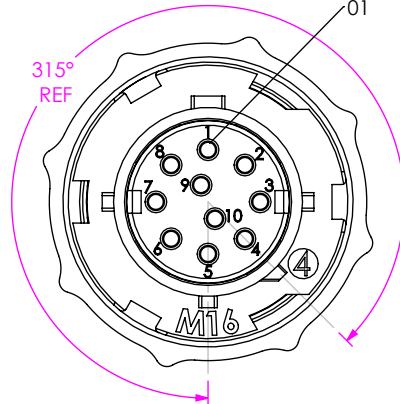
-1  
(ORANGE KEY RING)



-2  
(GREEN KEY RING)



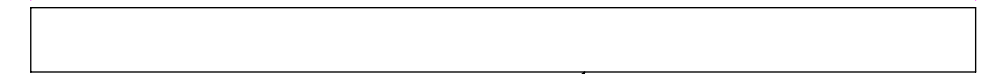
-3  
(BLUE KEY RING)



-4  
(YELLOW KEY RING)

KEYING OPTIONS  
(SEE NOTE 4)

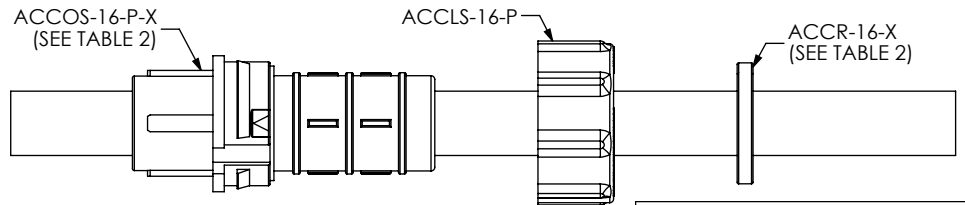
- ⊕ CABLE LENGTH (WIRE ONLY) = (XX.XX METERS - 0.03 METERS) ± 2%
- ⊕ CABLE LENGTH (CONTAINING COAX) = (XX.XX METERS - 0.02 METERS) ± 2%
- BC CABLE LENGTH (WIRE ONLY) = ((XX.XX METERS X 2) + 0.02 METERS) ± 2%
- BC CABLE LENGTH (CONTAINING COAX) = ((XX.XX METERS X 2) + 0.03 METERS) ± 2%



SBWC-16-XX-O  
(SEE TABLE 1)

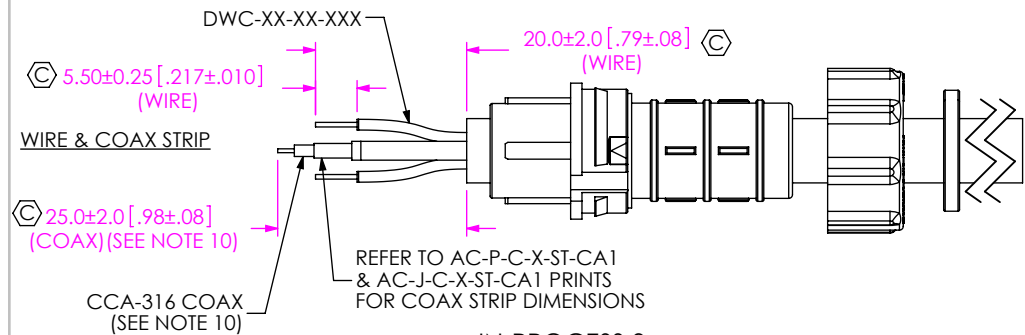
IN-PROCESS 1  
CUT SBWC CABLE TO LENGTH SHOWN

TABLE 1	
LEAD STYLES	SBWC PART #
-01	SBWC-16-01-O
-02	SBWC-16-02-O
-03	SBWC-16-03-O
-04	SBWC-16-04-O
-05	SBWC-16-05-O
-06	SBWC-16-06-O
-07	SBWC-16-07-O



IN-PROCESS 2  
FEED SBWC-16-XX-O BUNDLED CABLE THROUGH  
ACCR-16-X, ACCLS-16-P, & ACCOS-16-P-X

TABLE 2		
KEYING FEATURE	SHELL PART #	ACCR-16-X
-1	ACCOS-16-P-1	ACCR-16-1
-2	ACCOS-16-P-2	ACCR-16-2
-3	ACCOS-16-P-3	ACCR-16-3
-4	ACCOS-16-P-4	ACCR-16-4



IN-PROCESS 3  
STRIP OUTER JACKET & INNER WIRE/COAX  
TO DIMENSIONS SHOWN AND TIN INNER CONDUCTORS

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SHEET SCALE: 1:1

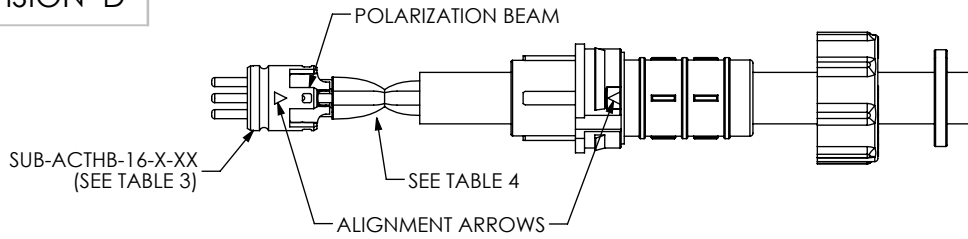


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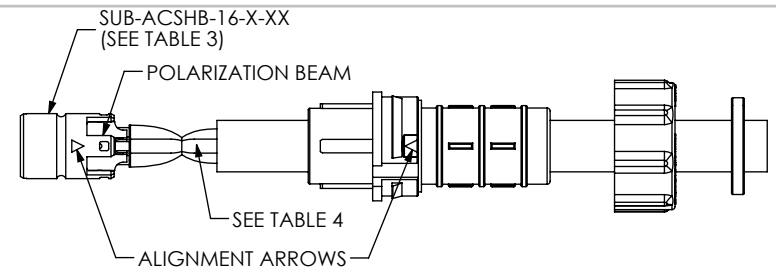
DESCRIPTION:  
ACCLIMATE CIRC. CABLE ASSEMBLY

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

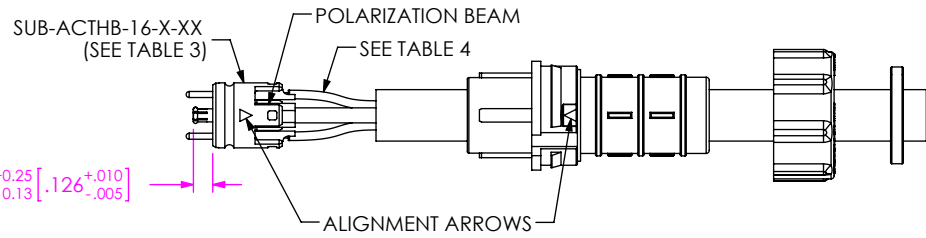
BY: D.SCHMELZ 04/30/2010 SHEET 4 OF 7



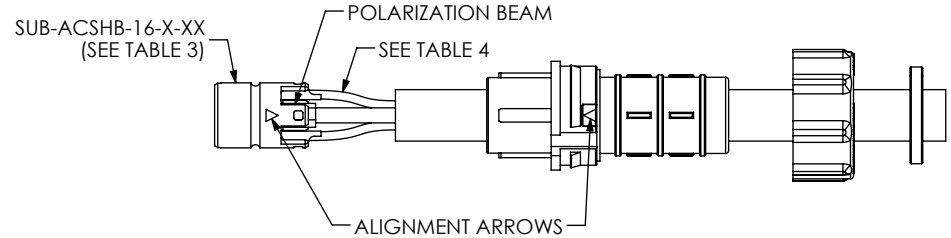
**SOLDER TERMINATION TO TERMINALS**



**SOLDER TERMINATION TO SOCKETS**

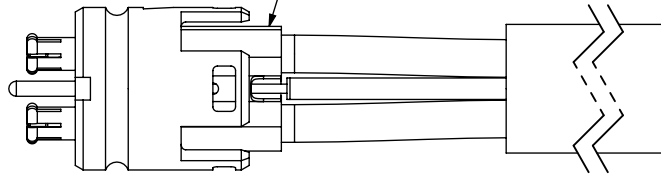


**COAX PLUG INSERTION**  
AFTER TERMINATION PUSH COAX PLUG INTO CORE UNTIL RETENTION BEAMS ENGAGE AND LOCK IT INTO PLACE

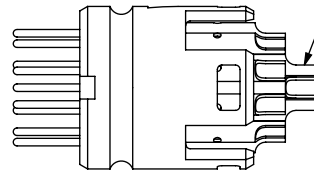


**COAX JACK INSERTION**  
AFTER TERMINATION PUSH COAX JACK INTO CORE UNTIL RETENTION BEAMS ENGAGE AND LOCK IT INTO PLACE

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)

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						

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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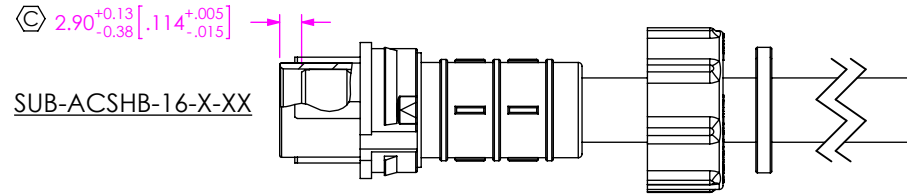
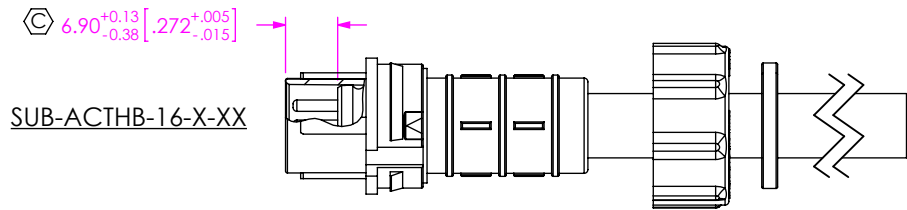
DO NOT SCALE DRAWING

SHEET SCALE: 1:1

DESCRIPTION:  
ACCLIMATE CIRC. CABLE ASSEMBLY

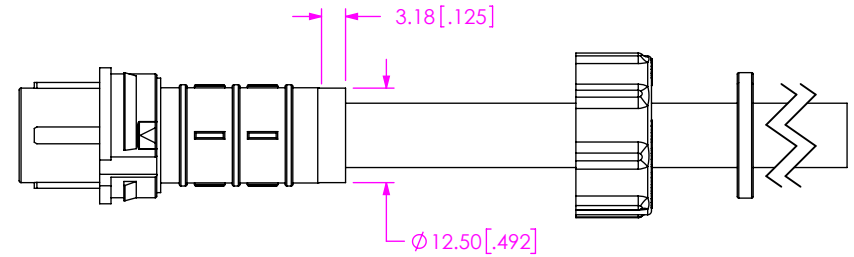
DWG. NO.  
ACP-16-XX-X-XX.XX-X-XX-O-X

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



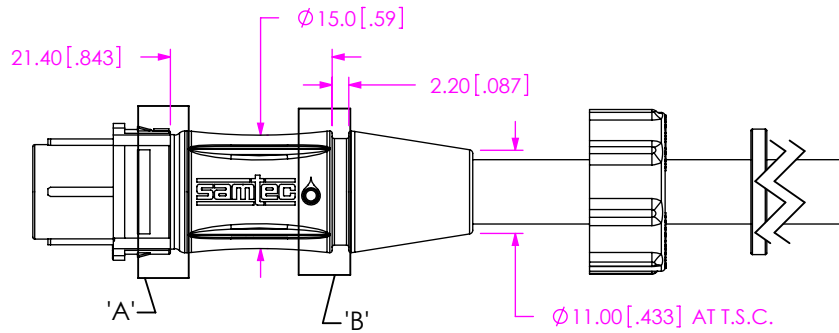
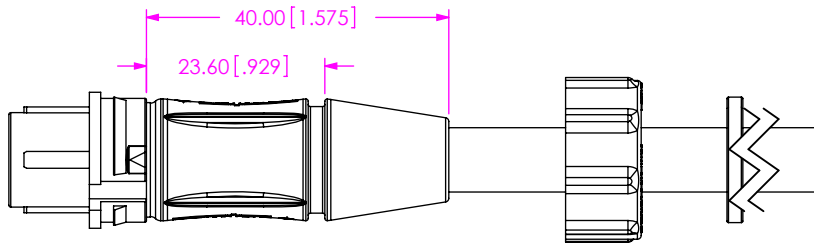
**IN-PROCESS 5**

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.

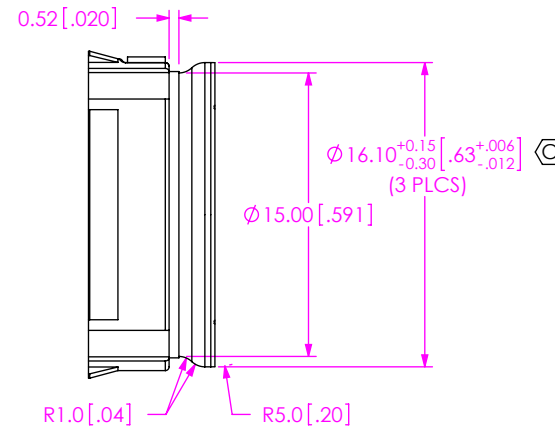


**IN-PROCESS 6**

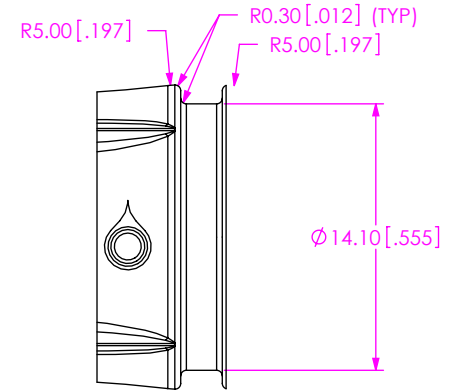
APPLY PRE-MOLD



**IN-PROCESS 7**  
APPLY OVERMOLD GRIP



**DETAIL 'A'**  
SCALE 2.5 : 1



**DETAIL 'B'**  
SCALE 2.5 : 1

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SHEET SCALE: 1:1

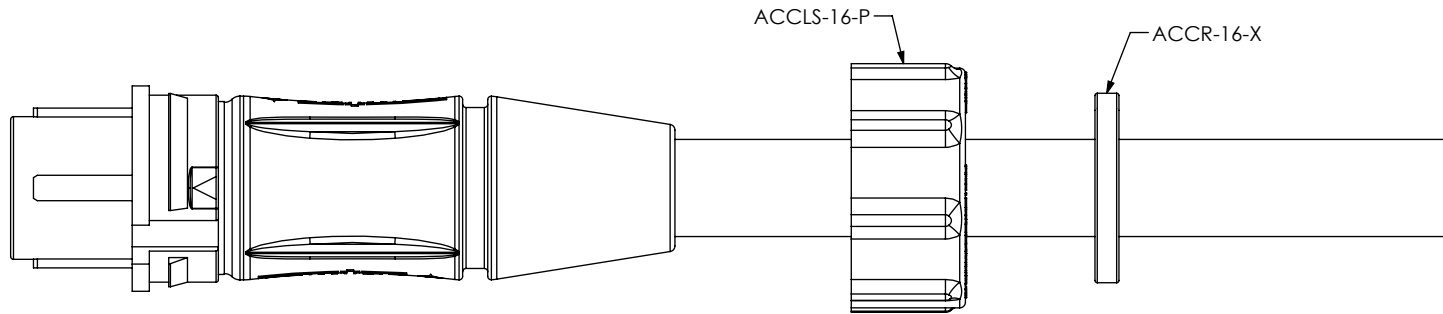


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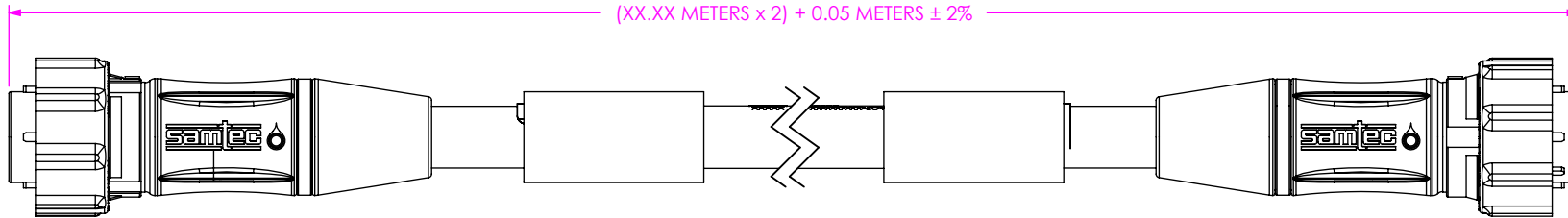
DESCRIPTION:  
ACCLIMATE CIRC. CABLE ASSEMBLY

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

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



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

**PROPRIETARY NOTE**

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DO NOT SCALE DRAWING

SHEET SCALE: 1:1



520 PARK EAST BLVD, NEW ALBANY, IN 47150  
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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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