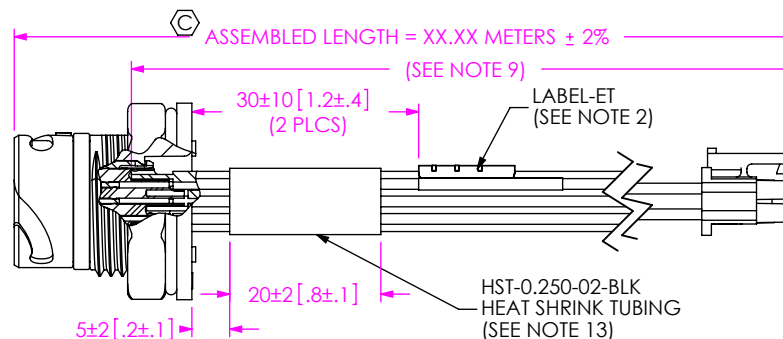
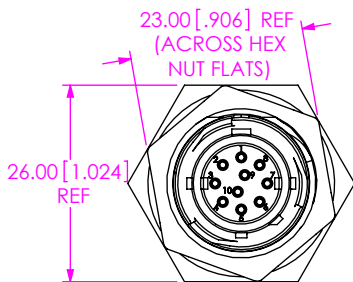
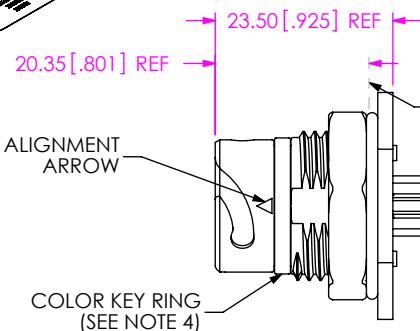
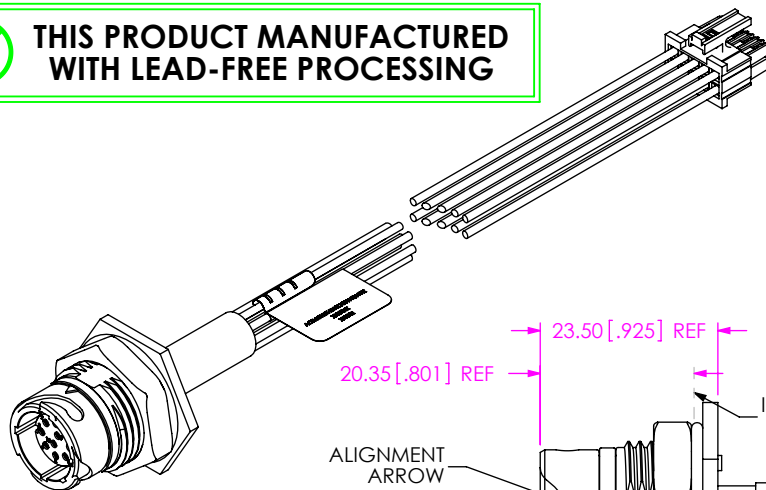


DO NOT  
SCALE FROM  
THIS PRINT



**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), COAX  
(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), COAX
- 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), COAX  
(6 X 1.0 TERM/SKT), 24 AWG

**PLATING**

- (SEE NOTE 10 & 14)
- G: 10u GOLD IN CONTACT AREA
- H: 30u GOLD IN CONTACT AREA

**SIZE**

**KEYING FEATURE**

- (SEE NOTE 4)
- 1: ORANGE
- 2: GREEN
- 3: BLUE
- 4: YELLOW

**STYLE**

- M: METAL

**END 2**

- BC: BLUNT CUT
- S1: 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% 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-ACR-16-M-X PRINT FOR DUST CAP.
7. PLACE HDRL-11 (LABEL) ON CABLE WHERE SHOWN. LABEL TO CONTAIN  
LINE 1 - PART NUMBER "ACR-16-XX-X-XX.XX-X-XX-M-X"  
LINE 2 - SHOP ORDER NUMBER "XXXXXX"  
LINE 3 - DATE CODE "XXXXX"
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: SFSO, MMSO & MPSS: 10u GOLD IN CONTACT AREA  
RF316: 30u GOLD CENTER CONTACT  
3u GOLD OUTER CONTACT
11. NOTE DELETED.
12. WHEN MOUNTING PRODUCT TO PANEL TORQUE ACPN-16-M TO 15 IN-LBS.
13. APPLY HEAT SHRINK TUBING TO -01, -02, -06, & -07 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].

F:\DWG\MISC\MKTG\ACR-16-XX-X-XX.XX-X-XX-M-X-MKT.SLDRW

**FIG 1**  
ACR-16-02-X-XX.XX-S-S1-M-1

UNLESS OTHERWISE SPECIFIED,  
DIMENSIONS ARE IN MILLIMETERS.  
TOLERANCES ARE:  
DECIMALS ANGLES  
X.X: ±0.3 [0.1]  
X.XX: ±0.13 [0.05]  
X.XXX: ±0.051 [0.020]

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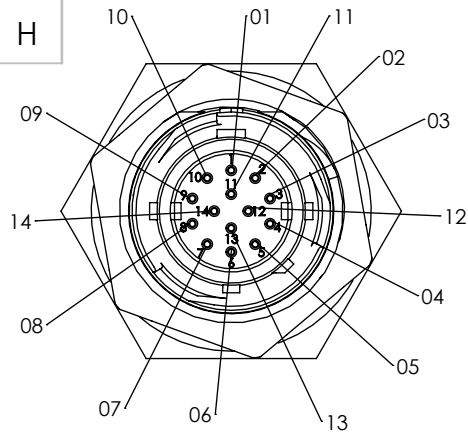
**MATERIAL:**  
SHELL: ZINK ALLOY  
INSULATOR: PBT  
TERMINALS: BRASS  
CONTACTS: BRASS/BeCu

DO NOT SCALE DRAWING SHEET SCALE: 1:1

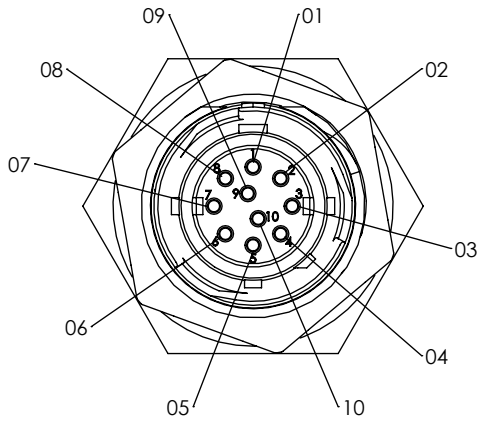


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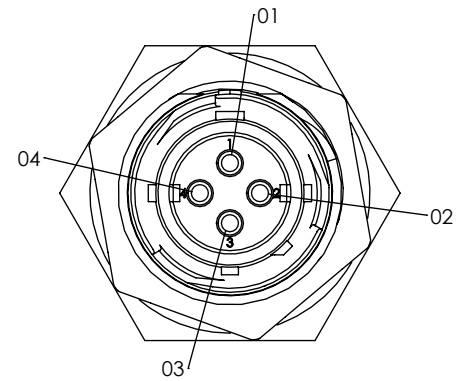
DESCRIPTION: M16 CABLE ASSEMBLY  
DWG. NO. ACR-16-XX-X-XX.XX-X-XX-M-X  
BY: D.SCHMELZ 04/27/2010 SHEET 1 OF 8



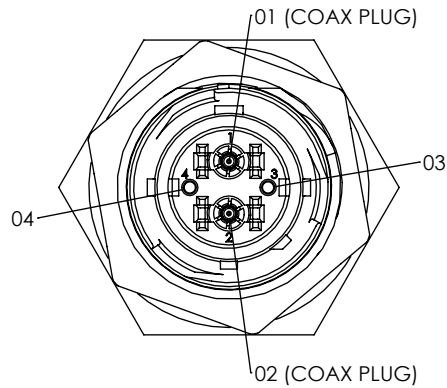
**-01: 14 POS**  
( $\varnothing$  0.5 TERMINALS)



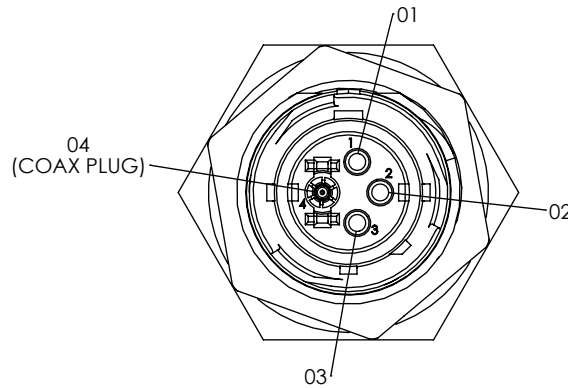
**-02: 10 POS**  
( $\varnothing$  1.0 TERMINALS)



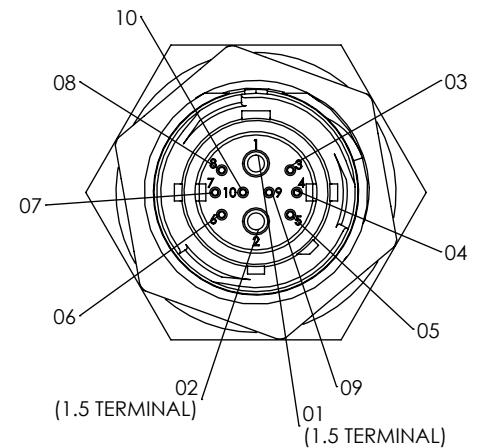
**-03: 4 POS**  
( $\varnothing$  1.5 TERMINALS)



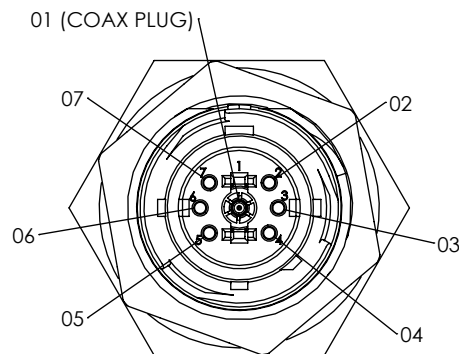
**-04: 4 POS COMBO**  
(2 X COAX PLUGS)  
(2 X  $\varnothing$  1.0 TERMINALS)



**-05: 4 POS COMBO**  
(3 X  $\varnothing$  1.5 TERMINALS)  
(1 X COAX PLUG)



**-06: 10 POS COMBO**  
(2 X  $\varnothing$  1.5 TERMINALS)  
(8 X  $\varnothing$  0.5 TERMINALS)



**-07: 7 POS COMBO**  
(1 X COAX PLUG)  
(6 X  $\varnothing$  1.0 TERMINALS)

**-T END OPTIONS**

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SHEET SCALE: 1.5:1

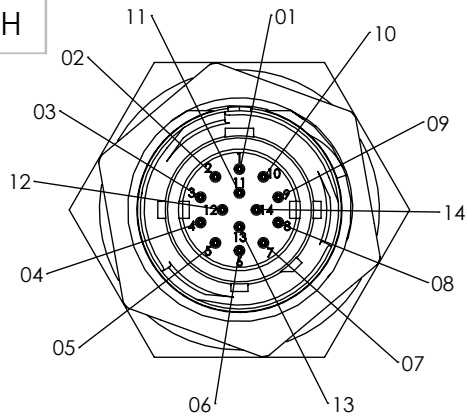


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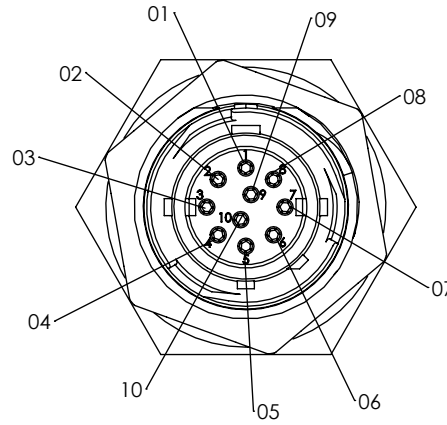
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DWG. NO. ACR-16-XX-X-XX.XX-X-XX-M-X

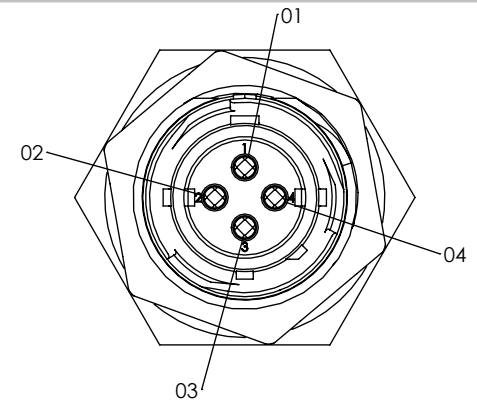
BY: D.SCHMELZ 04/27/2010 SHEET 2 OF 8



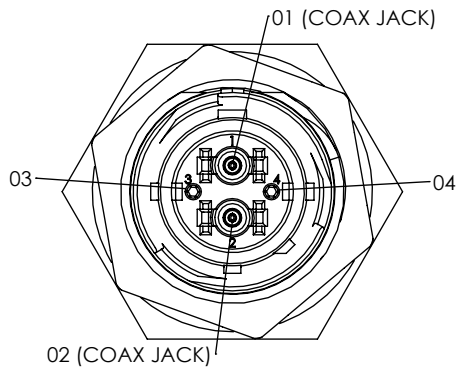
-01: 14 POS  
( $\varnothing$ 0.5 SOCKETS)



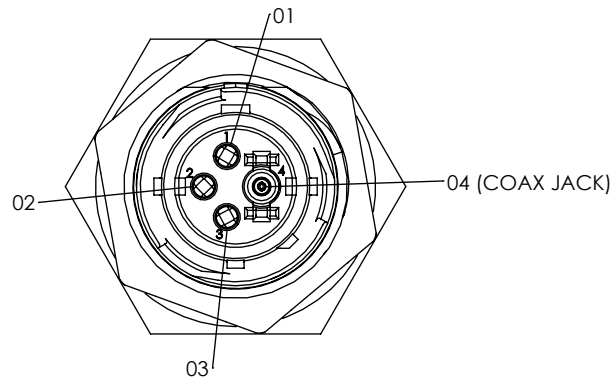
-02: 10 POS  
( $\varnothing$ 1.0 SOCKETS)



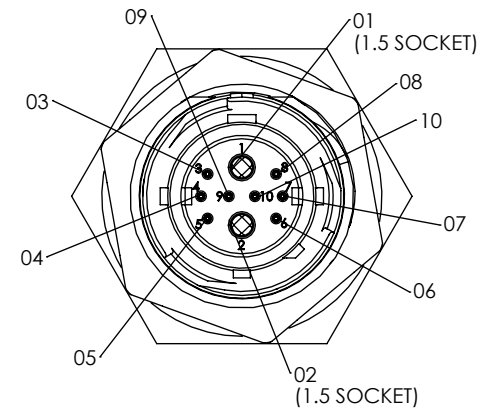
-03: 4 POS  
( $\varnothing$ 1.5 SOCKETS)



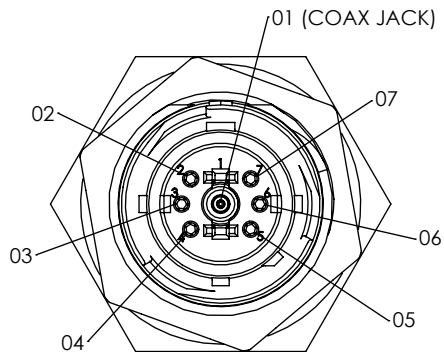
-04: 4 POS COMBO  
(2 X COAX JACKS)  
(2 X  $\varnothing$ 1.0 SOCKETS)



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



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



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

-S END OPTIONS

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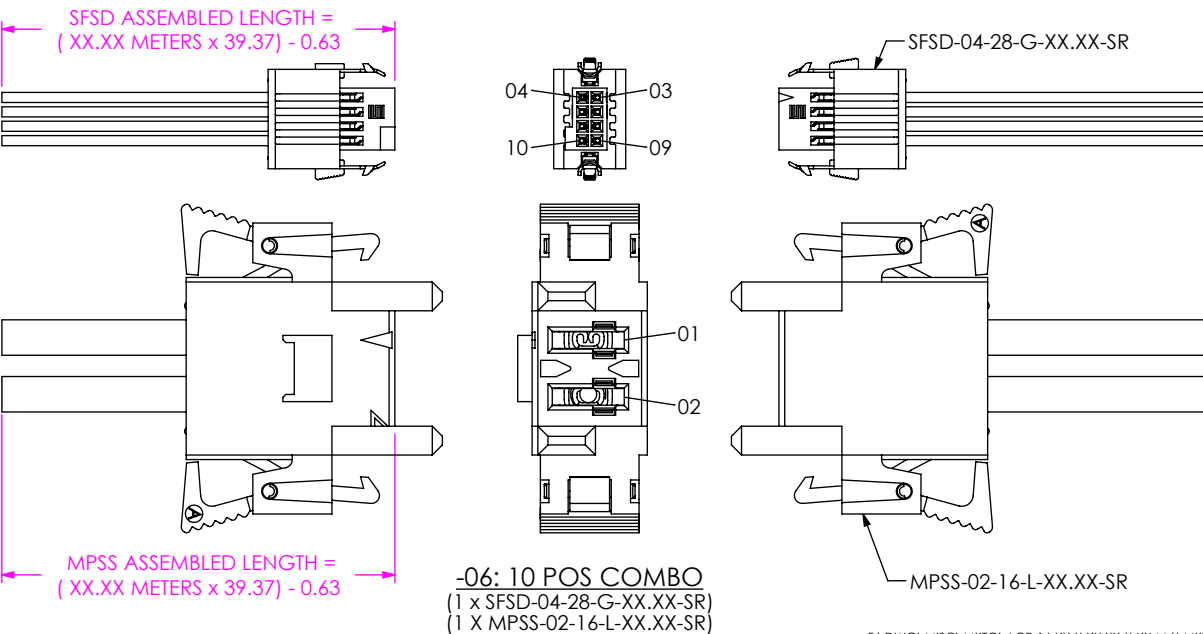
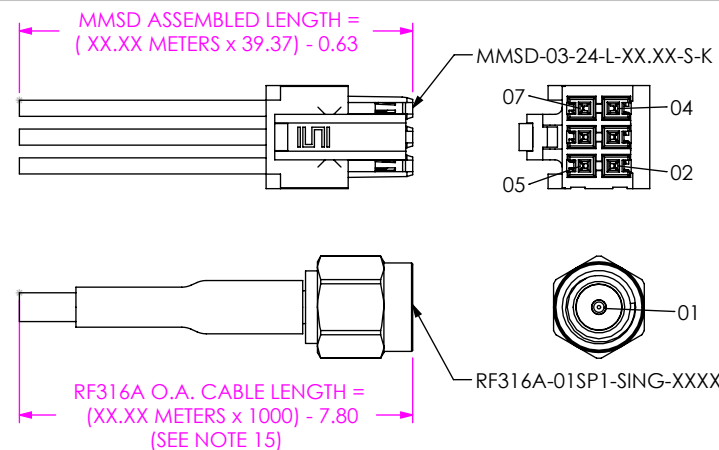
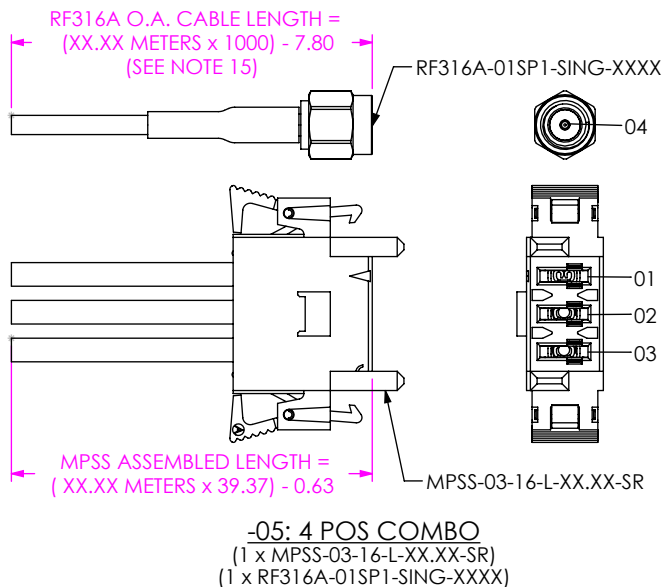
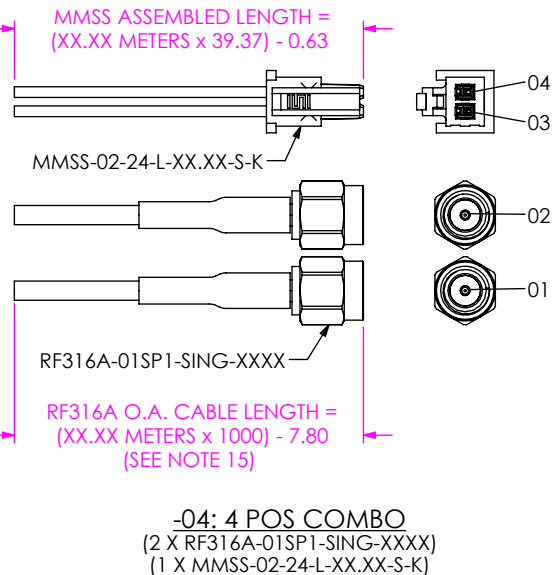
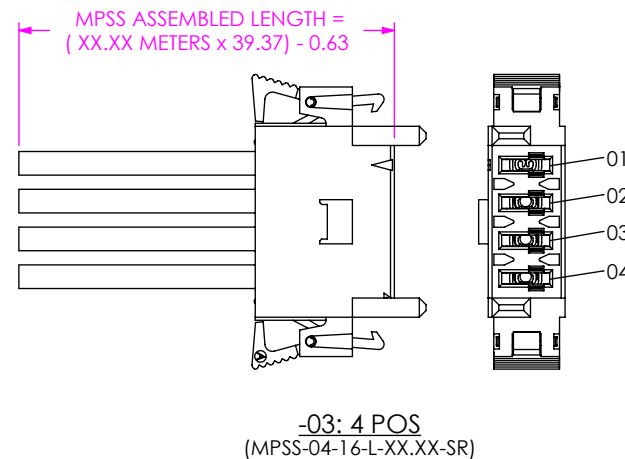
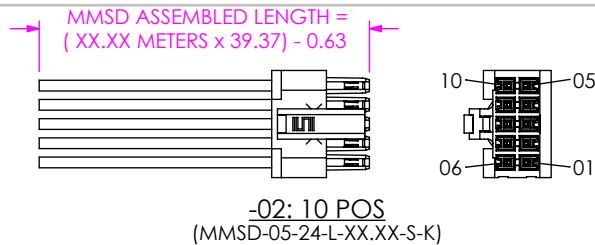
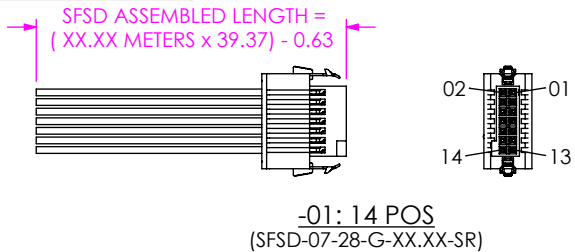
DESCRIPTION: M16 CABLE ASSEMBLY

DWG. NO. **ACR-16-XX-X-XX.XX-X-XX-M-X**

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REVISION H

END 2 OPTIONS



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SHEET SCALE: 1:1

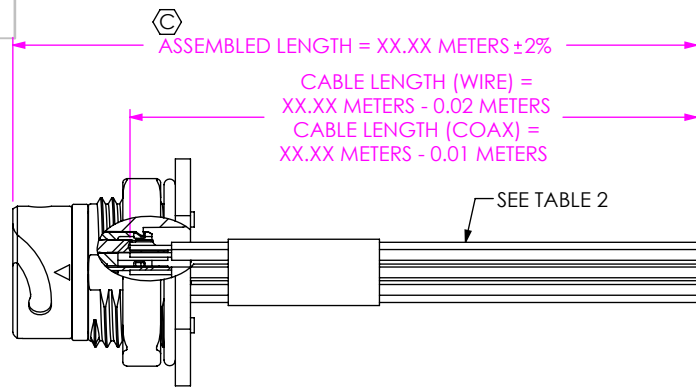
**samtec**

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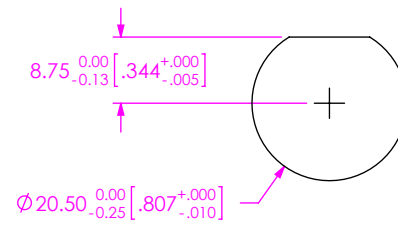
DESCRIPTION: M16 CABLE ASSEMBLY

DWG. NO. ACR-16-XX-X-XX.XX-X-XX-M-X

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-BC END OPTION  
 (BUILD DOUBLE-ENDED INITIALLY FOR E-TEST)  
 (SEE TABLE 2 FOR DWC CALLOUTS/SIGNAL MAPPING)  
 (SEE IN-PROCESS 7)



RECOMMENDED PANEL OPENING  
 (SEE NOTE 8 & 12)

TABLE 2  
 LEAD STYLE

POSITION	-01		-02		-03		-04		-05		-06		-07	
	COLOR	CABLE PART #	COLOR	CABLE PART #	COLOR	CABLE PART #	COLOR	CABLE PART #	COLOR	CABLE PART #	COLOR	CABLE PART #	COLOR	CABLE PART #
01	BROWN	DWC-28H-01-300	BROWN	DWC-24-01-300	BROWN	DWC-16-01-300	COAX	CCS-174525-01-CC	BROWN	DWC-16-01-300	BROWN	DWC-16-01-300	COAX	CCS-174525-01-CC
02	RED	DWC-28H-02-300	RED	DWC-24-02-300	RED	DWC-16-02-300	COAX	CCS-174525-01-CC	RED	DWC-16-02-300	RED	DWC-16-02-300	RED	DWC-24-02-300
03	ORANGE	DWC-28H-03-300	ORANGE	DWC-24-03-300	ORANGE	DWC-16-03-300	ORANGE	DWC-24-03-300	ORANGE	DWC-16-03-300	ORANGE	DWC-28H-03-300	ORANGE	DWC-24-03-300
04	YELLOW	DWC-28H-04-300	YELLOW	DWC-24-04-300	YELLOW	DWC-16-04-300	YELLOW	DWC-24-04-300	COAX	CCS-174525-01-CC	YELLOW	DWC-28H-04-300	YELLOW	DWC-24-04-300
05	GREEN	DWC-28H-05-300	GREEN	DWC-24-05-300							GREEN	DWC-28H-05-300	GREEN	DWC-24-05-300
06	DARK BLUE	DWC-28H-06-300	DARK BLUE	DWC-24-06-300							DARK BLUE	DWC-28H-06-300	DARK BLUE	DWC-24-06-300
07	VIOLET	DWC-28H-07-300	VIOLET	DWC-24-07-300							VIOLET	DWC-28H-07-300	VIOLET	DWC-24-07-300
08	GRAY	DWC-28H-08-300	GRAY	DWC-24-08-300							GRAY	DWC-28H-08-300		
09	WHITE	DWC-28H-09-300	WHITE	DWC-24-09-300							WHITE	DWC-28H-09-300		
10	BLACK	DWC-28H-10-300	BLACK	DWC-24-10-300							BLACK	DWC-28H-10-300		
11	GREEN/BLACK	DWC-28H-11-300												
12	TAN	DWC-28H-12-300												
13	DARK BLUE/YELLOW	DWC-28H-31-300												
14	PINK	DWC-28H-14-300												

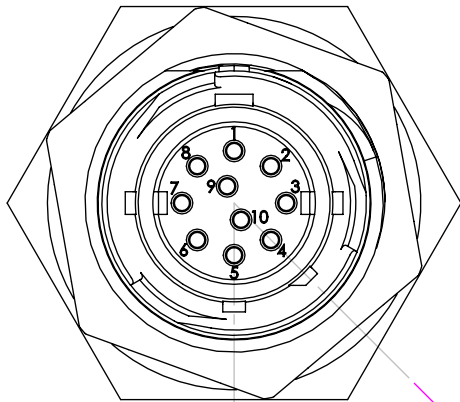
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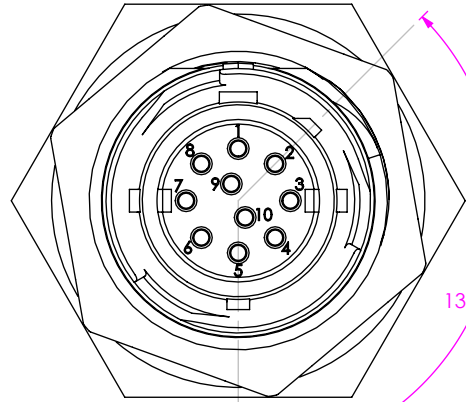


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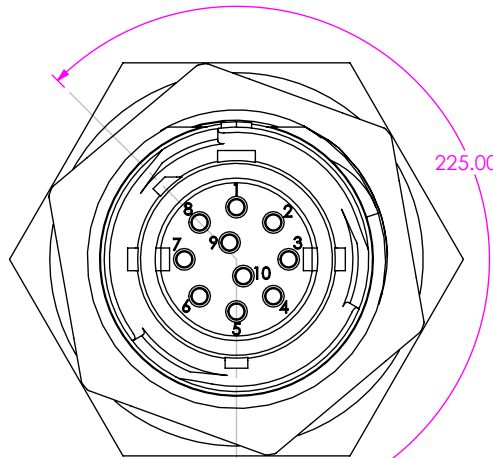
DESCRIPTION:  
 M16 CABLE ASSEMBLY  
 DWG. NO.  
**ACR-16-XX-X-XX.XX-X-XX-M-X**  
 BY: D.SCHMELZ 04/27/2010 SHEET 5 OF 8



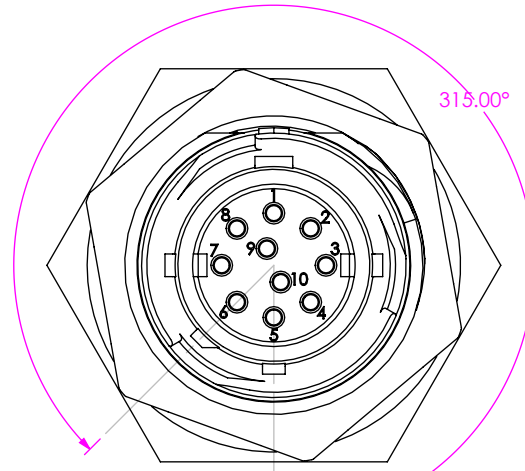
-1  
(ORANGE KEY RING)



-2  
(GREEN KEY RING)



-3  
(BLUE KEY RING)



-4  
(YELLOW KEY RING)

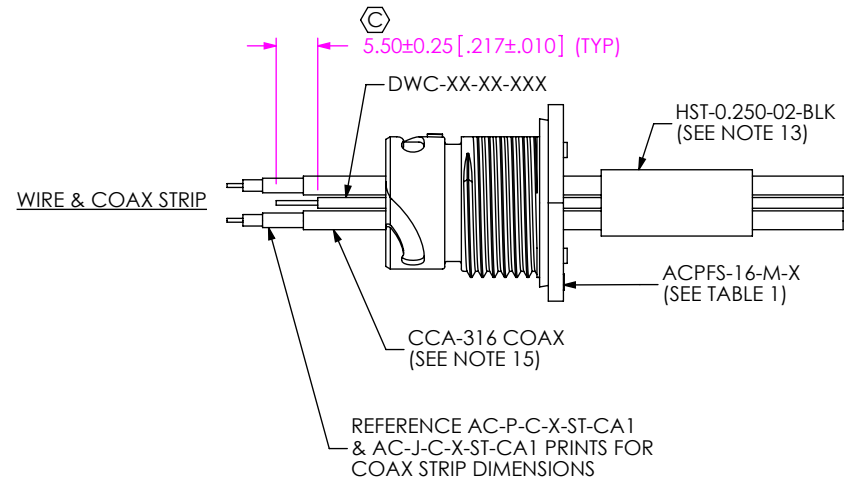
KEYING FEATURE  
(SEE NOTE 4)

135.00°

225.00°

315.00°

45.00°



**IN-PROCESS 1**  
 FEED CABLES FROM END 2 DISCRETE CABLE ASSEMBLY THROUGH HST-0.250-02-BLK (IF APPLICABLE) & ACPFS-16-M-X. STRIP CABLES TO DIMENSIONS SHOWN & TIN INNER CONNECTORS. FOR -BC OPTION, FEED DWC/COAX & STRIP TO DIMENSION SHOWN. (SEE NOTE 15)

KEYING FEATURE	SHELL PART #
-1	ACPFS-16-M-1
-2	ACPFS-16-M-2
-3	ACPFS-16-M-3
-4	ACPFS-16-M-4

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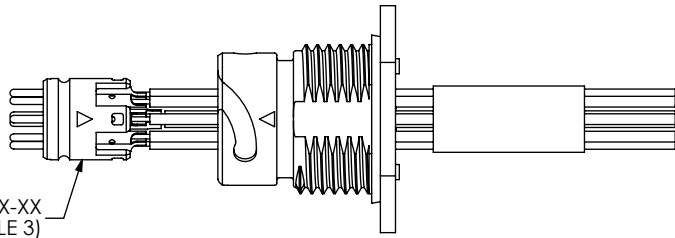
DESCRIPTION:  
 M16 CABLE ASSEMBLY

DWG. NO.  
 ACR-16-XX-X-XX.XX-X-XX-M-X

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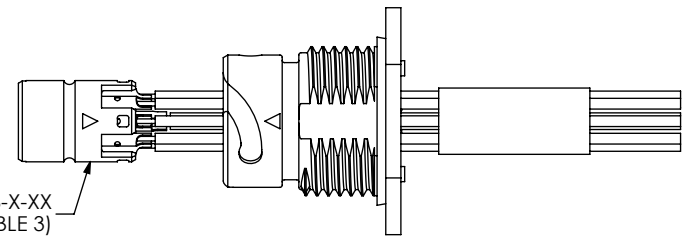


SUB-ACTHB-16-X-XX  
(SEE TABLE 3)



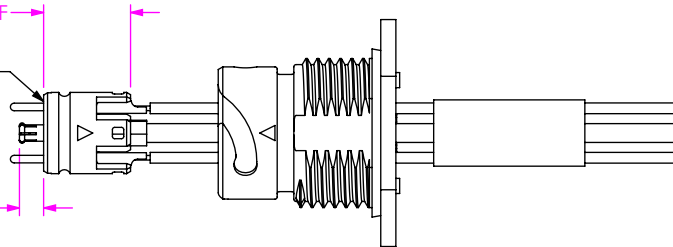
SOLDER TERMINATION  
TO TERMINALS

SUB-ACSHB-16-X-XX  
(SEE TABLE 3)



SOLDER TERMINATION  
TO SOCKETS

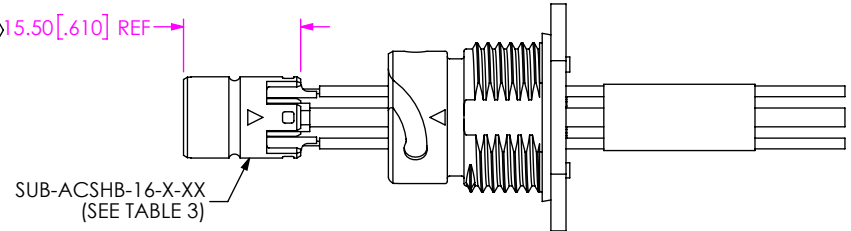
11.50 [.453] REF  
SUB-ACTHB-16-X-XX  
(SEE TABLE 3)



COAX PLUG INSERTION

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

15.50 [.610] REF  
SUB-ACSHB-16-X-XX  
(SEE TABLE 3)



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  
(SEE NOTE 5)

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

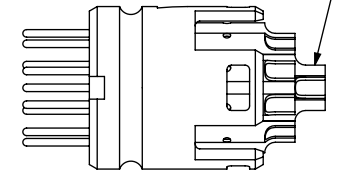
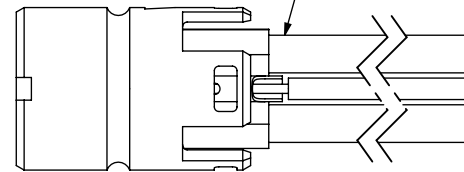


TABLE 3

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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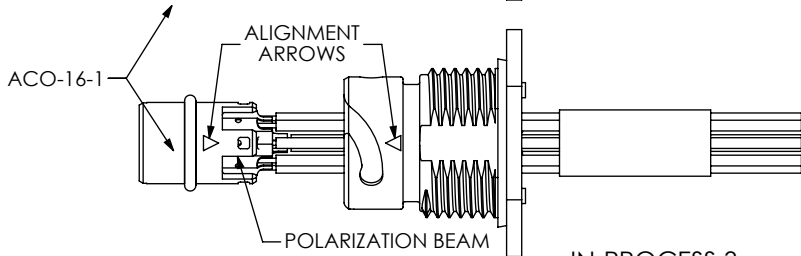
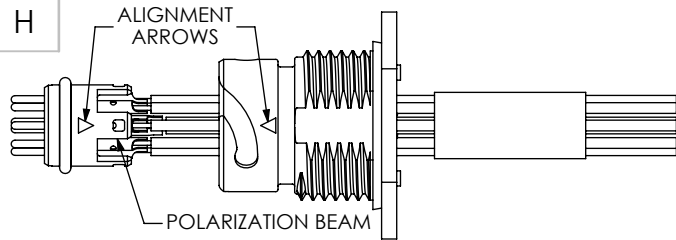
DESCRIPTION:

M16 CABLE ASSEMBLY

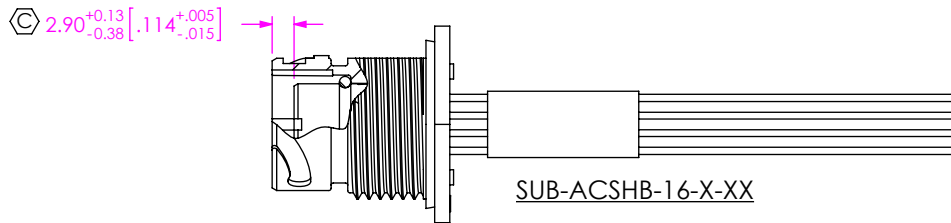
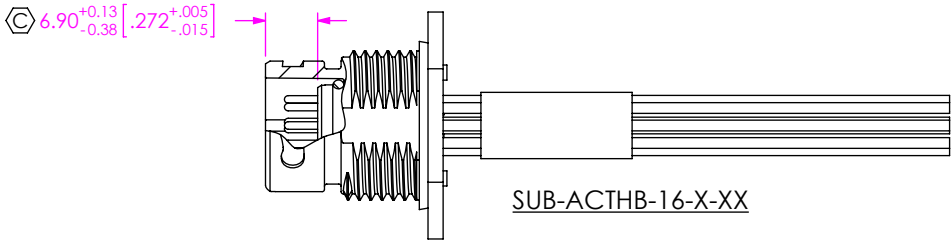
DWG. NO.

ACR-16-XX-X-XX.XX-X-XX-M-X

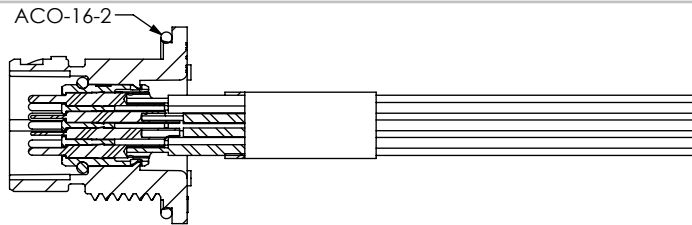
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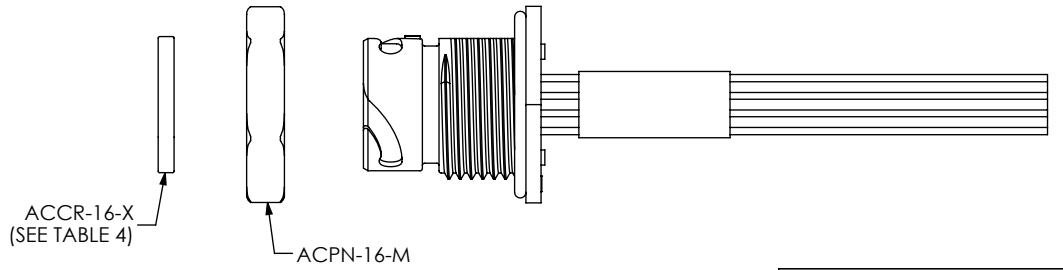
**IN-PROCESS 3**  
 PUSH ACO-16-1 O-RING ONTO SUB-ACHTB-16-X-XX,  
 OR SUB-ACSHB-16-X-XX SUB-ASSEMBLIES



**IN-PROCESS 4**  
 WHILE MAKING SURE ALIGNMENT ARROWS LINE UP TO AID POLARIZATION BEAM  
 ENGAGEMENT, INSERT SUB-ACXHB-16-X-XX SUB-ASSEMBLY INTO ACPFS-16-M-X  
 UNTIL SNAP LOCKS ENGAGE.

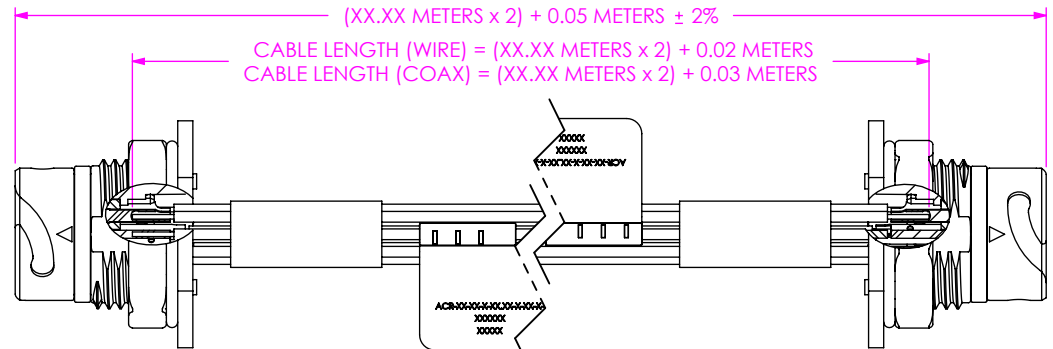


**IN-PROCESS 5**  
 INSERT ACO-16-2 AROUND FLANGE



**IN-PROCESS 6**  
 THREAD ACPN-16-M ONTO ACPFS-16-M-X  
 STRETCH ACCR-16-X OVER ACPFS-16-M-X  
 UNTIL IT SEATS IN GROOVE. ACTIVATE HEAT SHRINK TUBING

TABLE 4	
KEYING FEATURE	ACCR-16-X
-1 (ORANGE)	ACCR-16-1
-2 (GREEN)	ACCR-16-2
-3 (BLUE)	ACCR-16-3
-4 (YELLOW)	ACCR-16-4



**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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 DWG. NO. ACR-16-XX-X-XX.XX-X-XX-M-X  
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