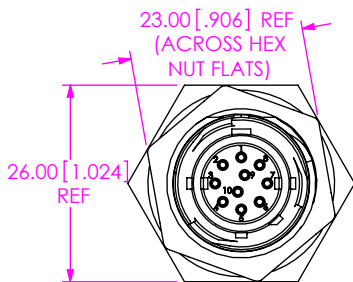
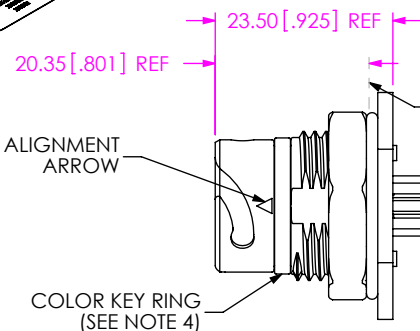
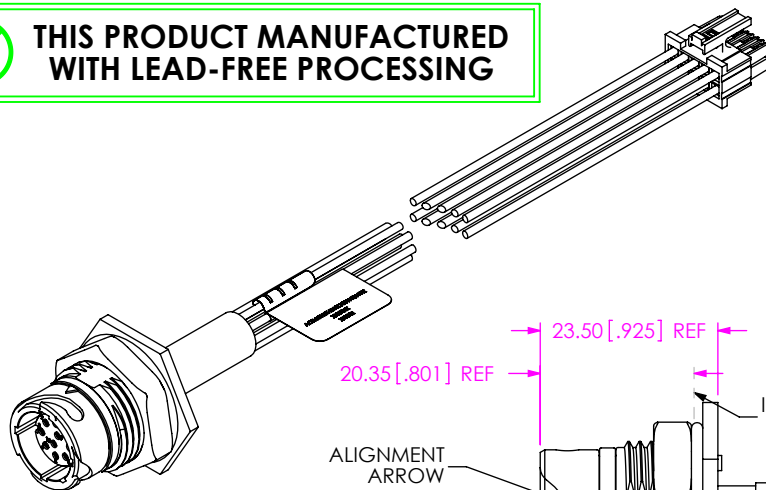


DO NOT  
SCALE FROM  
THIS PRINT



**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

**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)

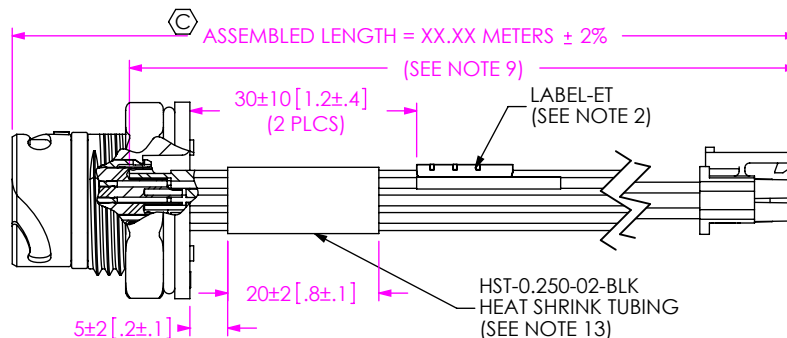
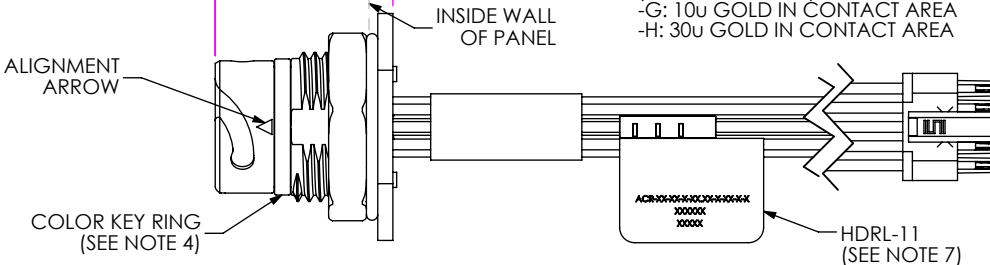
**END 1**

- T: TERMINAL
- S: SOCKET

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

**PLATING**

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

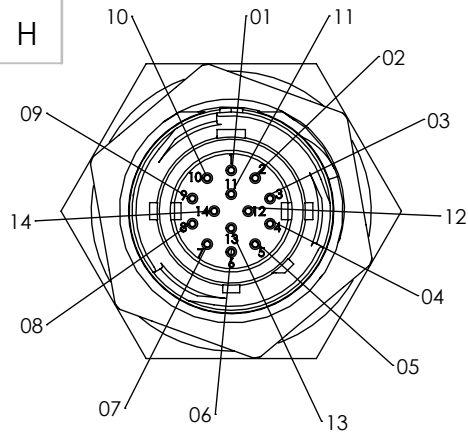


**NOTES:**

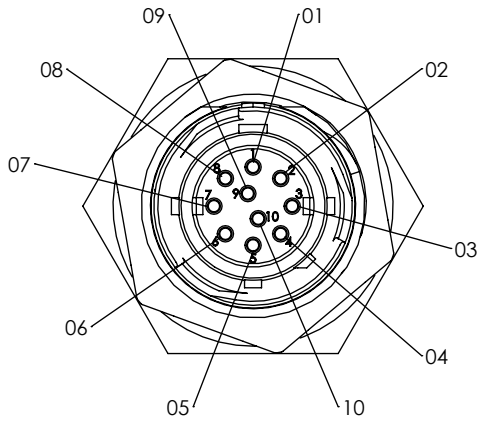
1. Ⓢ REPRESENTS A CRITICAL DIMENSION.
2. ASSEMBLY TO BE 100% TESTED FOR CONTINUITY, ISOLATION, & HI-POT AT 300V. (1) LABEL-ET TO BE APPLIED AFTER FINAL ELECTRICAL TEST.
3. ASSEMBLIES TO BE BULK PACKAGED.
4. KEYING FEATURE DETERMINES COLOR OF KEY RING AND DUSTCAP LANYARD IF APPLICABLE.
5. SIGNAL MAPPING 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: SFSD, MMSD & 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].

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

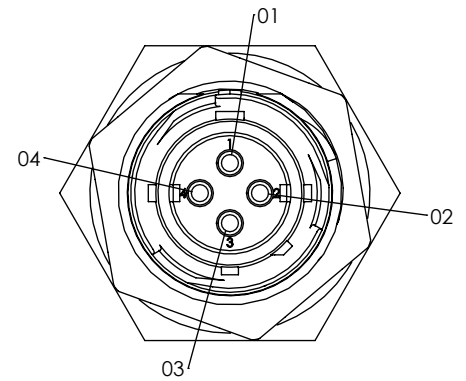
<p>UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN MILLIMETERS.</p> <p>TOLERANCES ARE:</p> <table border="0"> <tr> <td>DECIMALS</td> <td>ANGLES</td> </tr> <tr> <td>X.X: ±0.3 [01]</td> <td>2°</td> </tr> <tr> <td>X.XX: ±0.13 [005]</td> <td></td> </tr> <tr> <td>X.XXX: ±0.051 [0020]</td> <td></td> </tr> </table>	DECIMALS	ANGLES	X.X: ±0.3 [01]	2°	X.XX: ±0.13 [005]		X.XXX: ±0.051 [0020]		<p>PROPRIETARY NOTE</p> <p>THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION AND ALL DESIGN, MANUFACTURING, REPRODUCTION, USE, PATENT RIGHTS AND SALES RIGHTS ARE EXPRESSLY RESERVED BY SAMTEC, INC. THIS DOCUMENT SHALL NOT BE DISCLOSED, IN WHOLE OR PART, TO ANY UNAUTHORIZED PERSON OR ENTITY NOR REPRODUCED, TRANSFERRED OR INCORPORATED IN ANY OTHER PROJECT IN ANY MANNER WITHOUT THE EXPRESS WRITTEN CONSENT OF SAMTEC, INC.</p>	<p>520 PARK EAST BLVD, NEW ALBANY, IN 47150 PHONE: 812-944-6733 FAX: 812-948-5047 e-Mail info@SAMTEC.com code 55322</p>
	DECIMALS	ANGLES								
X.X: ±0.3 [01]	2°									
X.XX: ±0.13 [005]										
X.XXX: ±0.051 [0020]										
<p><b>MATERIAL:</b></p> <p>SHELL: ZINK ALLOY INSULATOR: PBT TERMINALS: BRASS CONTACTS: BRASS/BeCu</p>	<p>DESCRIPTION: <b>M16 CABLE ASSEMBLY</b></p> <p>DWG. NO. <b>ACR-16-XX-X-XX.XX-X-XX-M-X</b></p> <p>BY: D.SCHMELZ 04/27/2010 SHEET 1 OF 8</p>									



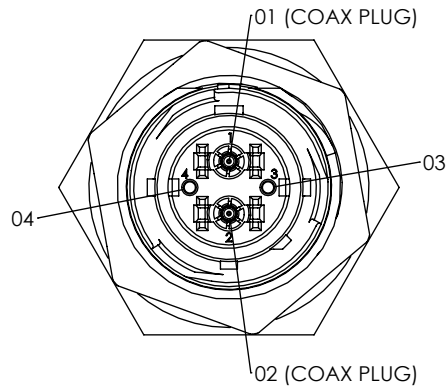
**-01: 14 POS**  
( $\varnothing$  0.5 TERMINALS)



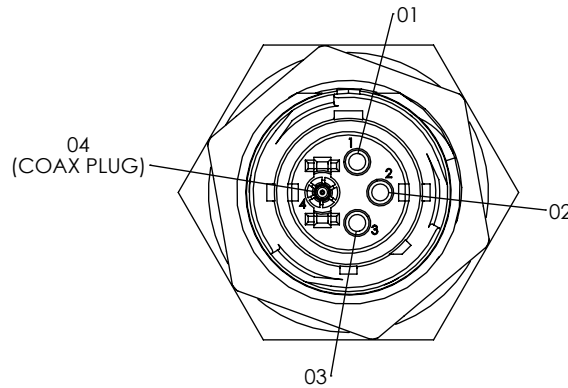
**-02: 10 POS**  
( $\varnothing$  1.0 TERMINALS)



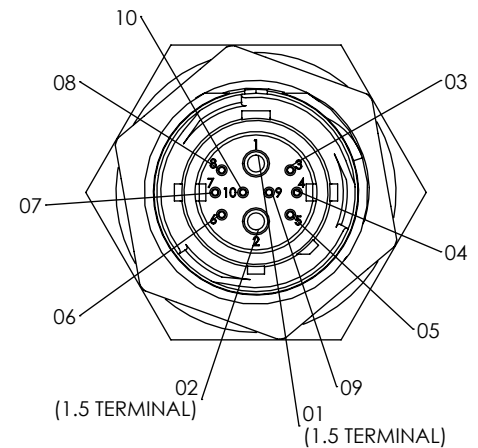
**-03: 4 POS**  
( $\varnothing$  1.5 TERMINALS)



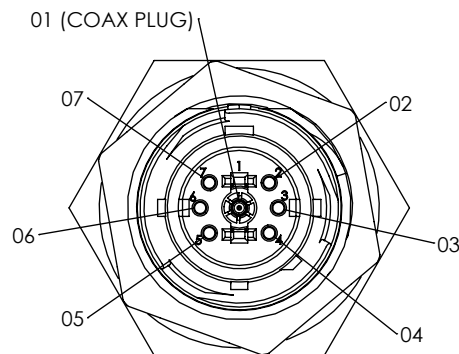
**-04: 4 POS COMBO**  
(2 X COAX PLUGS)  
(2 X  $\varnothing$  1.0 TERMINALS)



**-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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DO NOT SCALE DRAWING

SHEET SCALE: 1.5:1

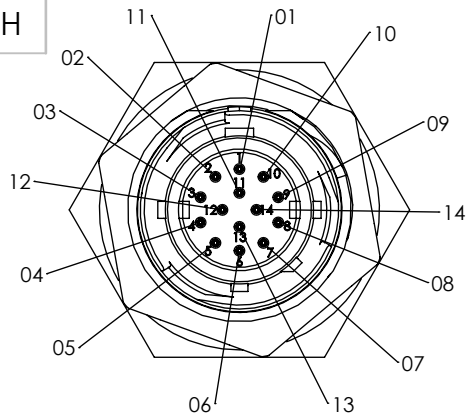


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e-Mail: info@SAMTEC.com code 55322

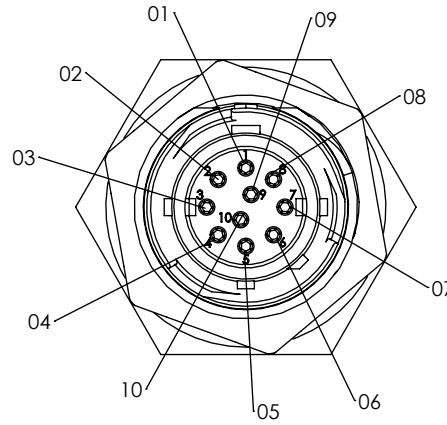
DESCRIPTION: M16 CABLE ASSEMBLY

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

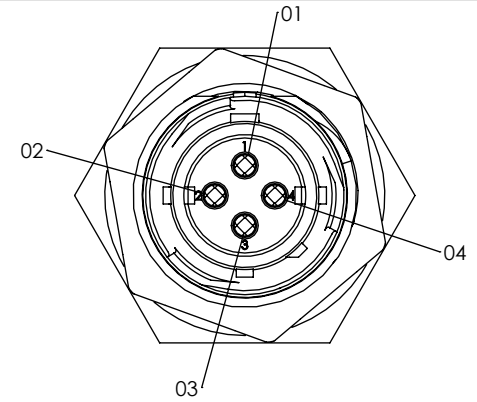
BY: D.SCHMELZ 04/27/2010 SHEET 2 OF 8



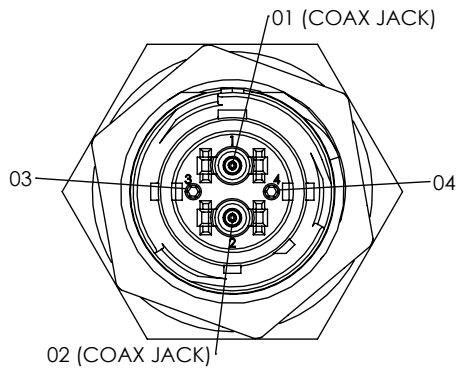
-01: 14 POS  
( $\varnothing$ 0.5 SOCKETS)



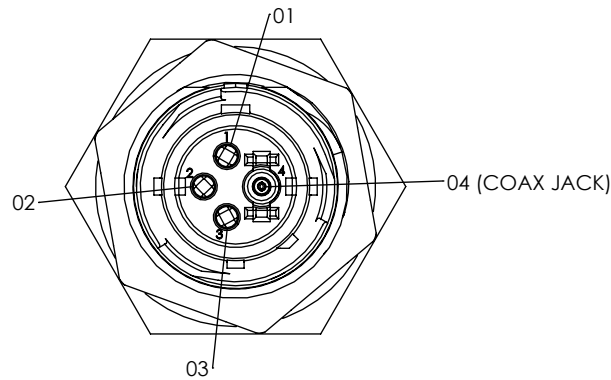
-02: 10 POS  
( $\varnothing$ 1.0 SOCKETS)



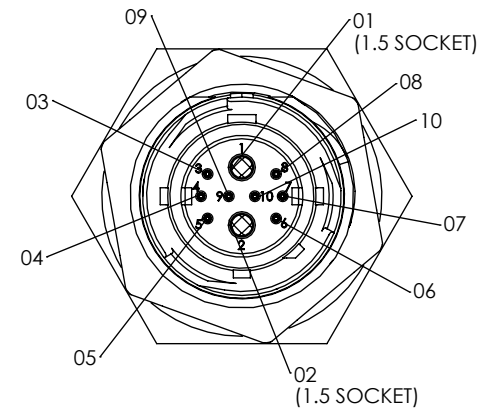
-03: 4 POS  
( $\varnothing$ 1.5 SOCKETS)



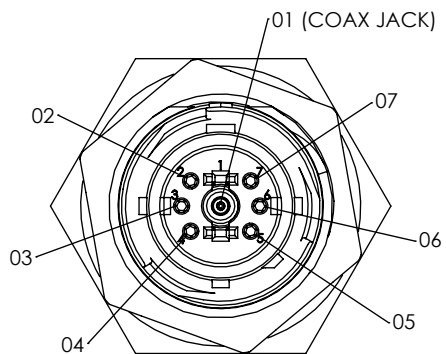
-04: 4 POS COMBO  
(2 X COAX JACKS)  
(2 X  $\varnothing$ 1.0 SOCKETS)



-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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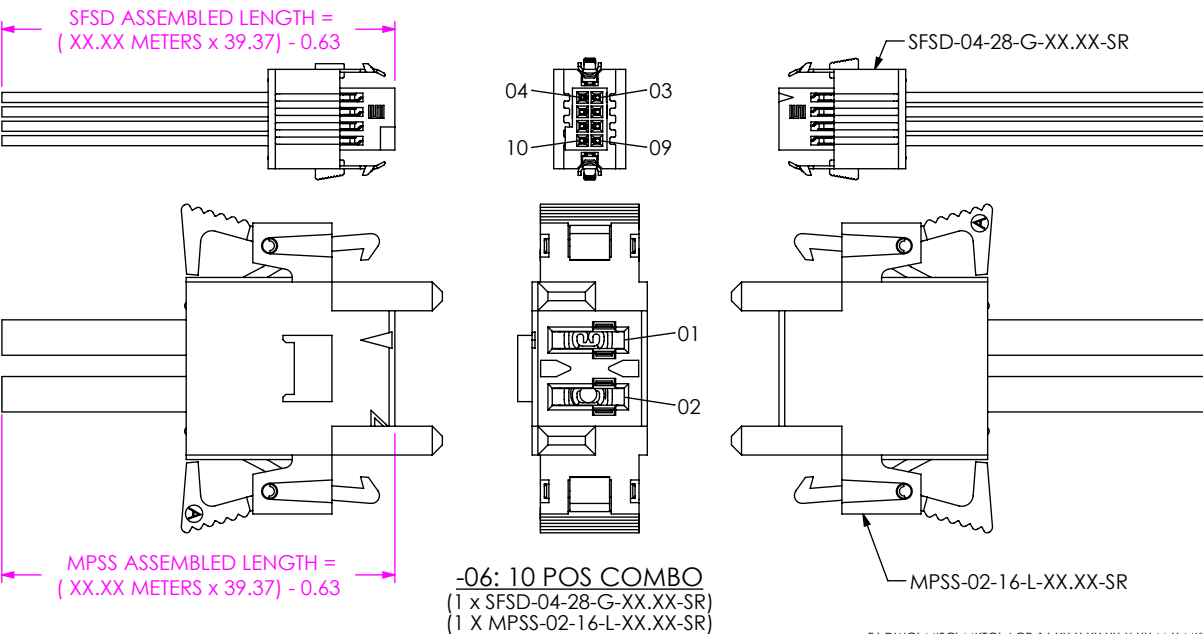
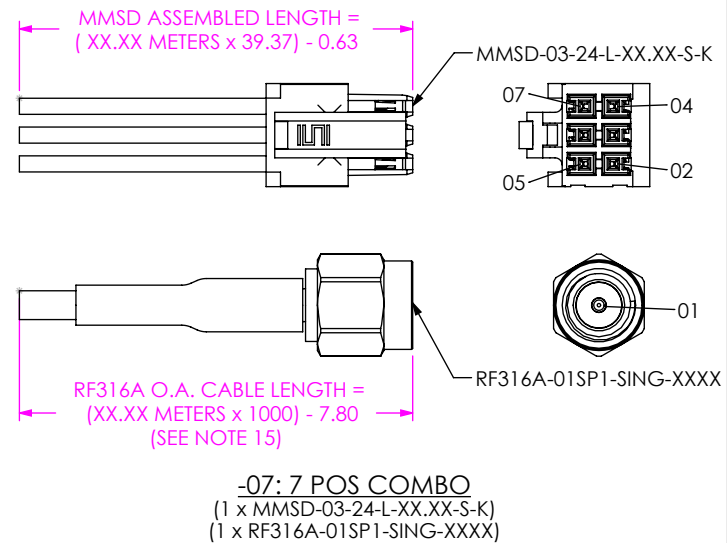
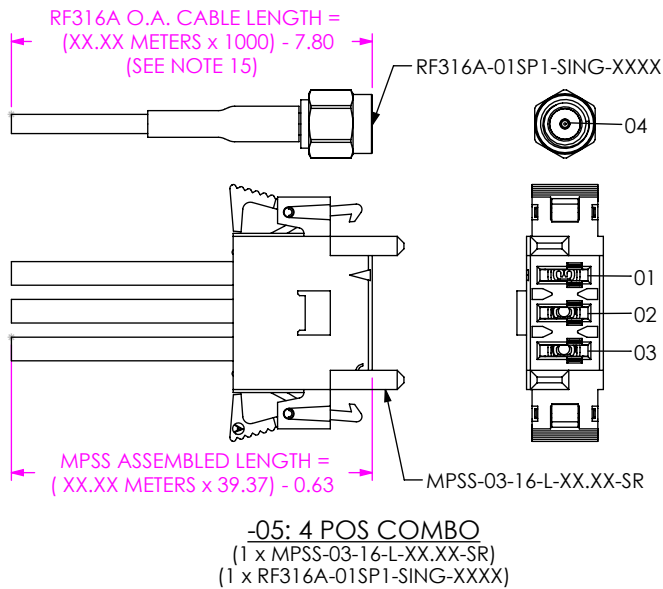
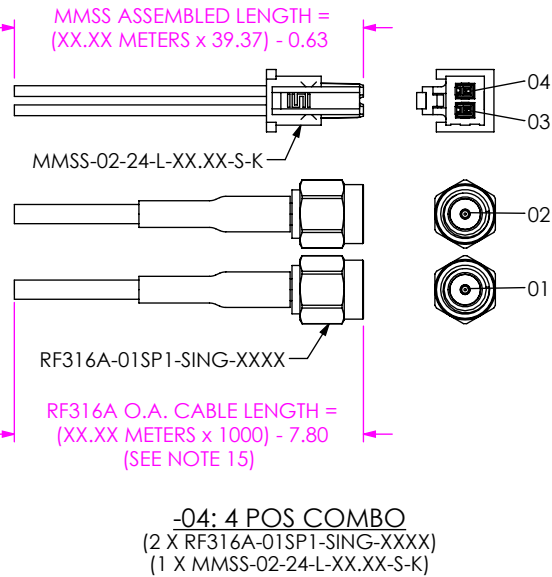
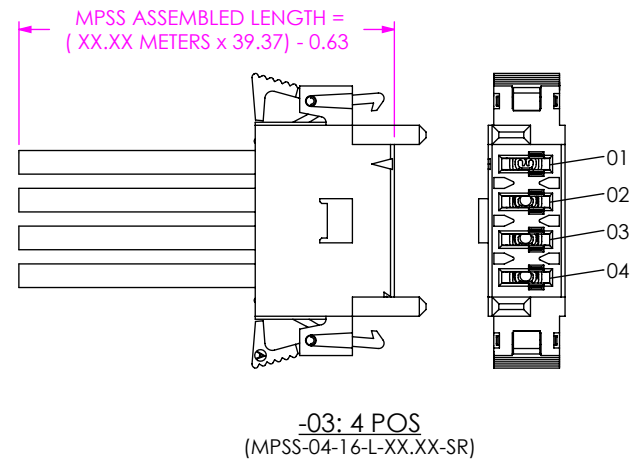
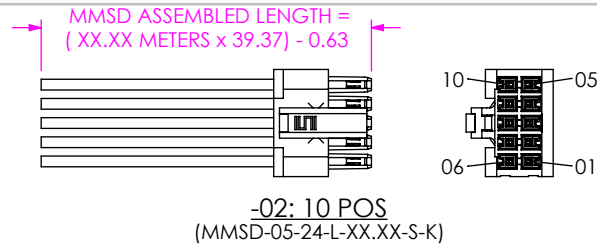
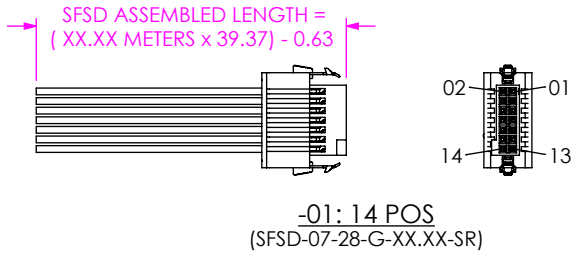
DESCRIPTION: M16 CABLE ASSEMBLY

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

BY: D.SCHMELZ 04/27/2010 SHEET 3 OF 8

REVISION H

END 2 OPTIONS



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DO NOT SCALE DRAWING

SHEET SCALE: 1:1

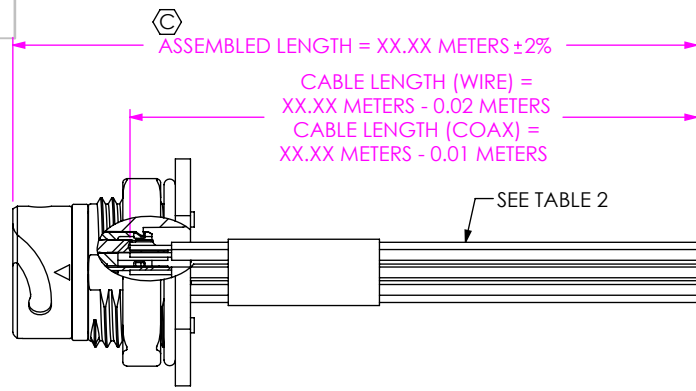
**samtec**

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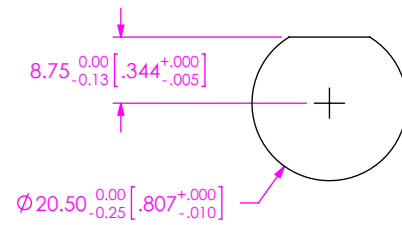
DESCRIPTION: M16 CABLE ASSEMBLY

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

BY: D.SCHMELZ 04/27/2010 SHEET 4 OF 8



**-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												

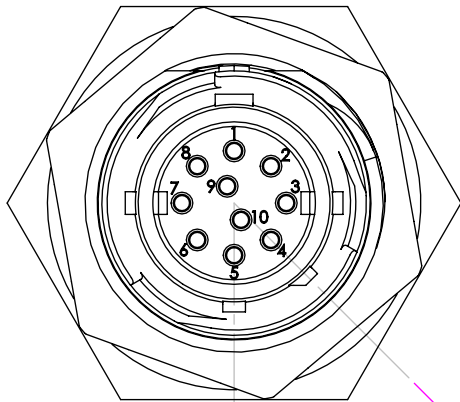
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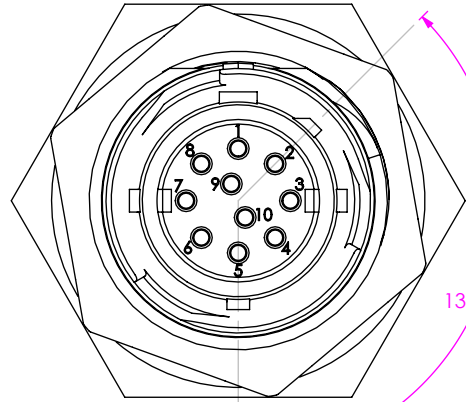


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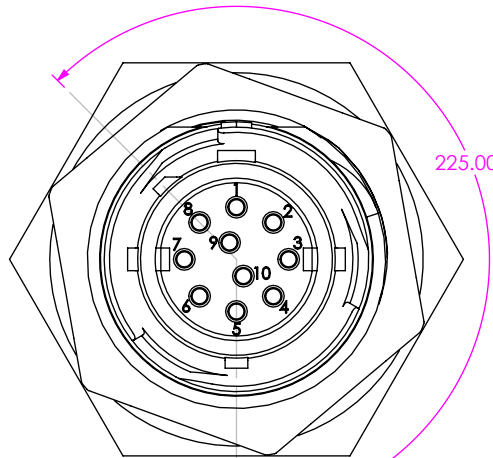
DESCRIPTION: M16 CABLE ASSEMBLY  
 DWG. NO. ACR-16-XX-X-XX.XX-X-XX-M-X  
 BY: D.SCHMELZ 04/27/2010 SHEET 5 OF 8



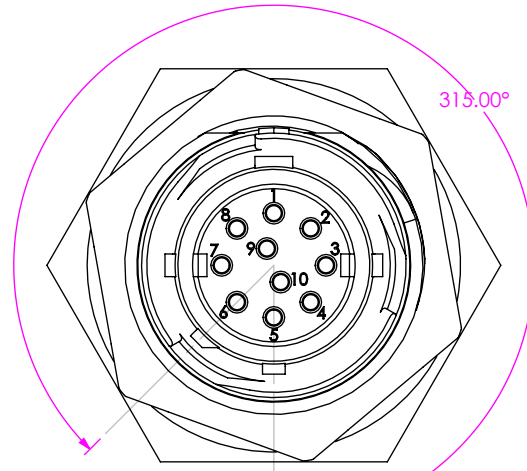
-1  
(ORANGE KEY RING)



-2  
(GREEN KEY RING)

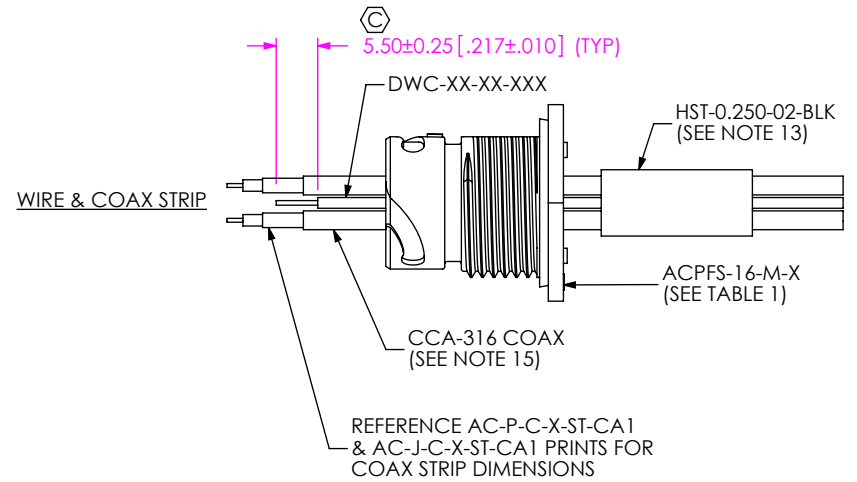


-3  
(BLUE KEY RING)



-4  
(YELLOW KEY RING)

KEYING FEATURE  
(SEE NOTE 4)



**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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SHEET SCALE: 1:1



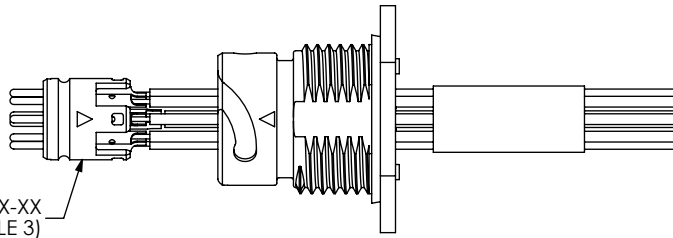
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 e-Mail: info@SAMTEC.com code 55322

DESCRIPTION:  
 M16 CABLE ASSEMBLY

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

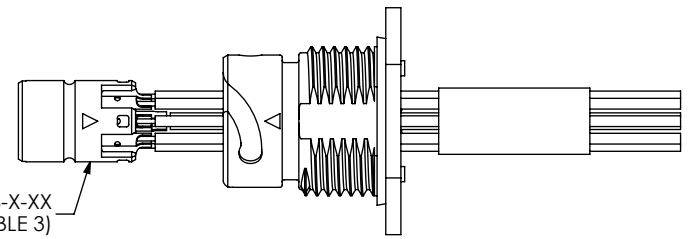
BY: D.SCHMELZ 04/27/2010 SHEET 6 OF 8

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



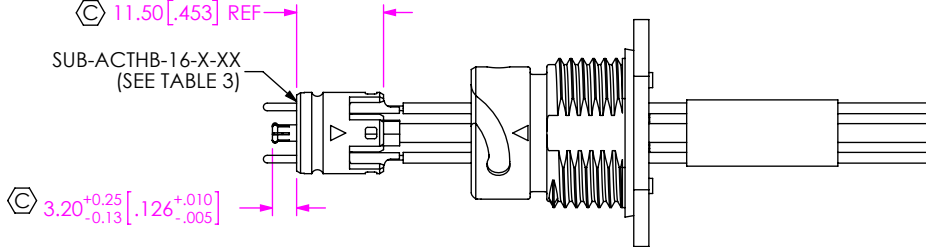
SOLDER TERMINATION  
TO TERMINALS

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



SOLDER TERMINATION  
TO SOCKETS

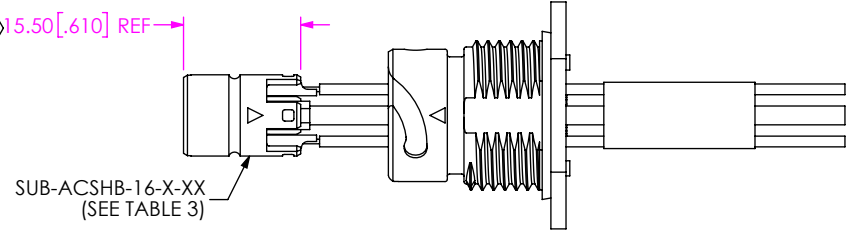
11.50 [.453] REF  
SUB-ACTHB-16-X-XX  
(SEE TABLE 3)



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

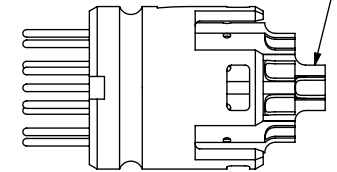
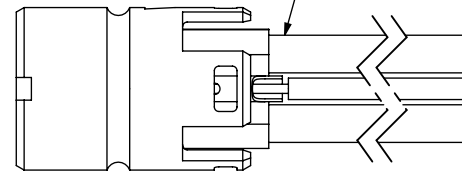


TABLE 3

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:

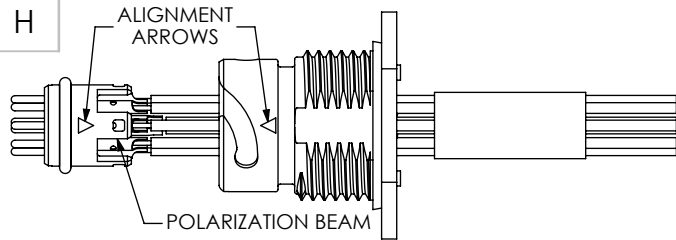
M16 CABLE ASSEMBLY

DWG. NO.

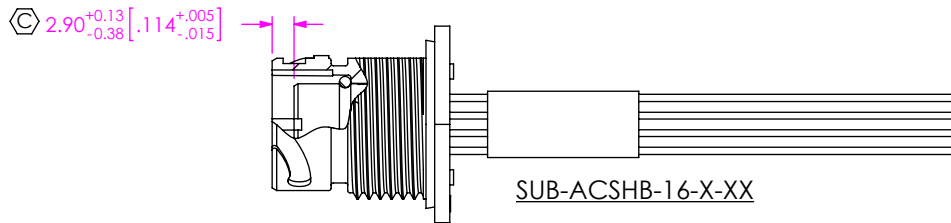
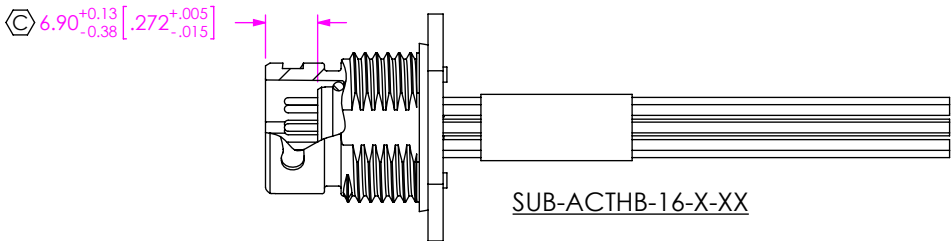
ACR-16-XX-X-XX.XX-X-XX-M-X

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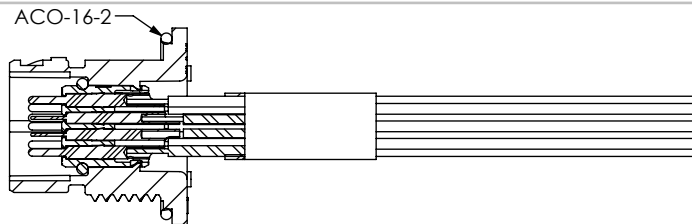
REVISION H



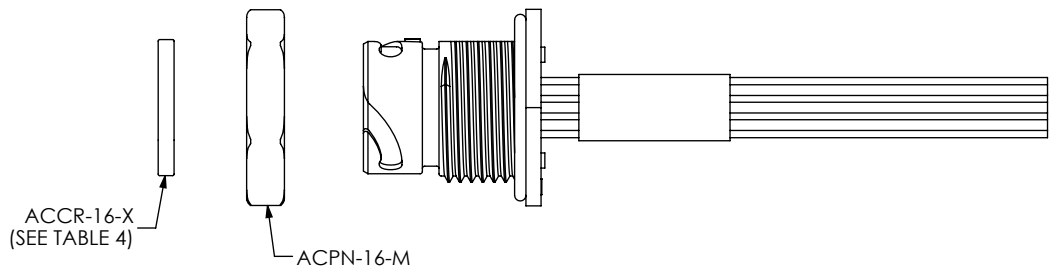
**IN-PROCESS 3**  
 PUSH ACO-16-1 O-RING ONTO SUB-ACHTB-16-X-XX,  
 OR SUB-ACSHB-16-X-XX SUB-ASSEMBLIES



**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.

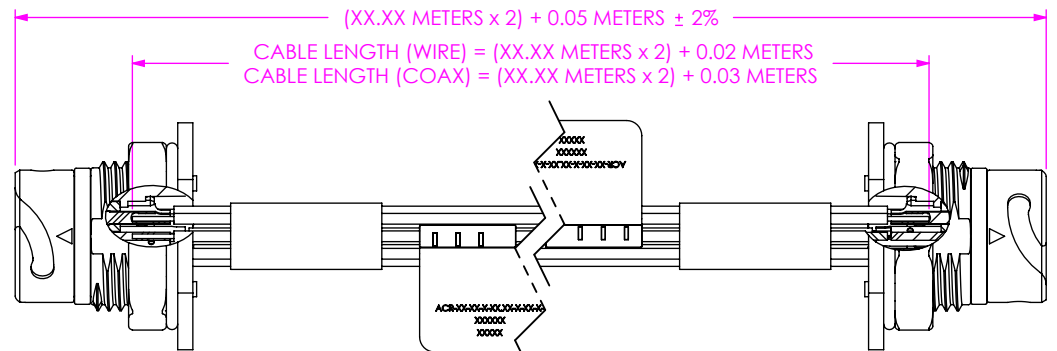


**IN-PROCESS 5**  
 INSERT ACO-16-2 AROUND FLANGE



**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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DESCRIPTION:  
 M16 CABLE ASSEMBLY

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

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