

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

LEAD STYLE  
 -01: 4 POS (1.0 TERM/SKT), 24 AWG  
 -02: 5 POS (1.0 TERM/SKT), 24 AWG  
 -03: 6 POS (0.5 TERM/SKT), 28 AWG  
 -04: 8 POS (0.5 TERM/SKT), 28 AWG  
 -05: 6 POS COMBO  
 (2x1.0 TERM/SKT), 24 AWG  
 (4x0.5 TERM/SKT), 28 AWG

PLATING  
 -G: 10µ" GOLD IN CONTACT AREA  
 -H: 30µ" GOLD IN CONTACT AREA

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

STYLE  
 -M: METAL

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)  
 (00.25 METER MIN TO 50.00 METER MAX)

DO NOT  
SCALE FROM  
THIS PRINT

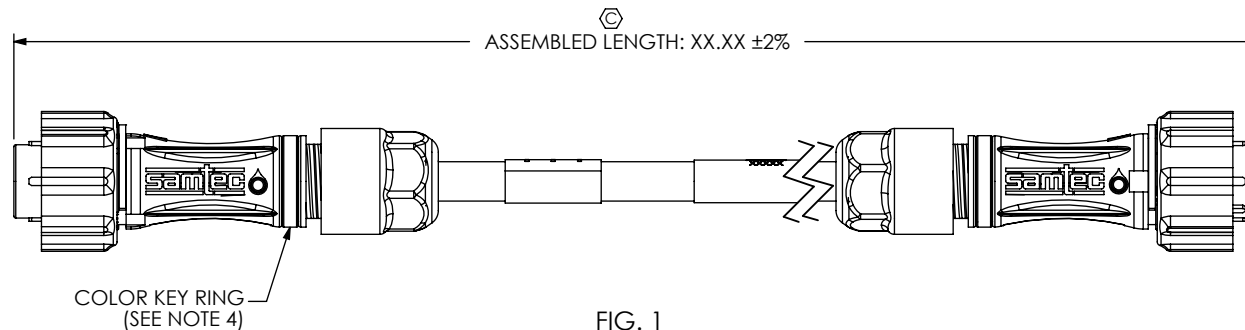
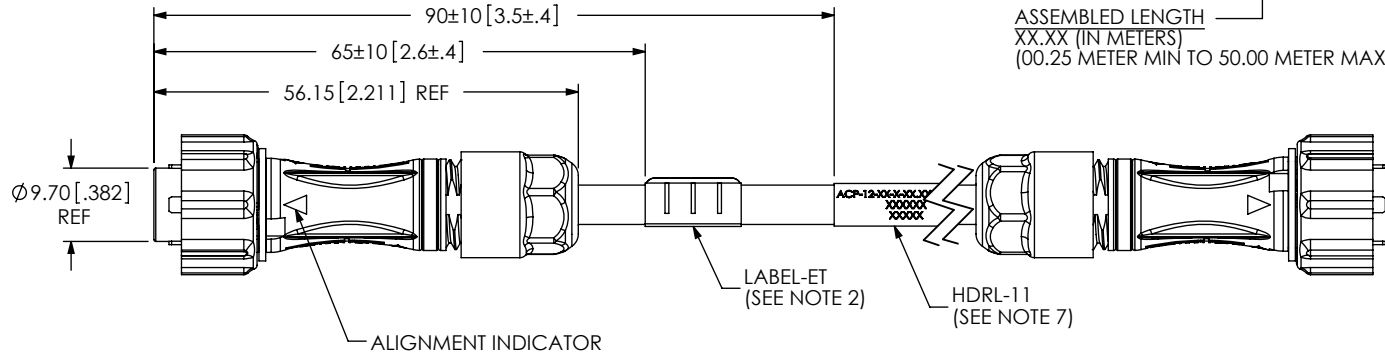


FIG. 1  
ACP-12-02-X-XX.XX-T-T-M-1 SHOWN

NOTES:

- ⊕ REPRESENTS A CRITICAL DIMENSION.
- ASSEMBLY TO BE 100% TESTED FOR CONTINUITY, ISOLATION, & HI-POT AT 300V.  
(1) LABEL-ET TO BE APPLIED AFTER FINAL ELECTRICAL TEST.
- ASSEMBLIES TO BE BULK PACKAGED.
- KEYING FEATURE DETERMINES COLOR OF KEY RING AND DUSTCAP LANYARD IF APPLICABLE.
- SIGNAL MAPPING IS 1 TO 1, 2 TO 2, 3 TO 3, etc..
- REFER TO DCA-ACP-12-M-X PRINT FOR DUST CAP.
- PLACE HDRL-11 (LABEL) ON CABLE WHERE SHOWN. LABEL TO CONTAIN  
LINE 1 - PART NUMBER "ACP-12-XX-X-XX.XX-X-XX-M-X"  
LINE 2 - SHOP ORDER NUMBER "XXXXXX"  
LINE 3 - DATE CODE "XXXXX"
- ACCN-12-M TORQUE SPEC: 15 IN-LBS
- PARTS TO BE BUILT & INSPECTED TO IPC-A-620 CLASS 2.

F:\DWG\MISC\MKTG\ACP-12-XX-X-XX.XX-X-XX-M-X-MKT.SLDDRW

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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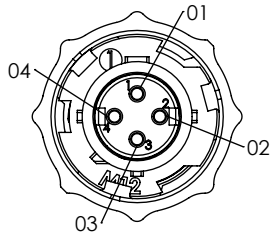
520 PARK EAST BLVD., NEW ALBANY, IN 47150  
PHONE: 812-944-6733 FAX: 812-948-5047  
e-Mail: info@SAMTEC.com code 53322

MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 1:1  
 SHELLS/LOCKING SLEEVE/NUT: ZINC ALLOY  
 INSULATOR: PBT, COLOR: BLACK  
 COLOR RING: SILICONE  
 GROMMET: NITRILE  
 GROMMET CAGE: NYLON, COLOR: BLACK  
 TERMINALS: BRASS  
 CONTACTS: BRASS/BeCu

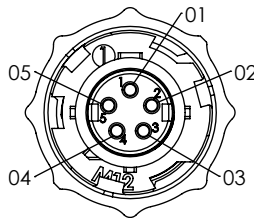
DESCRIPTION:  
ACCLIMATE CIRC. CABLE ASSEMBLY  
 DWG. NO.  
ACP-12-XX-X-XX.XX-X-XX-M-X  
 BY: D.SCHMELZ 09/16/2010 SHEET 1 OF 4

-T END OPTIONS

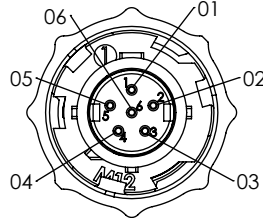
-01: 4 POS  
(Ø T.0 TERMINALS)



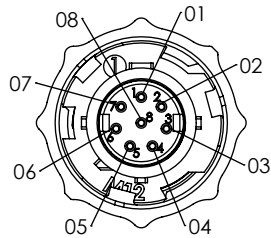
-02: 5 POS  
(Ø T.0 TERMINALS)



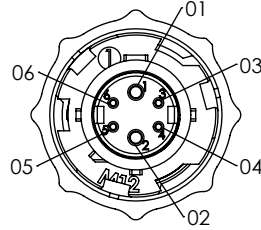
-03: 6 POS  
(Ø 0.5 TERMINALS)



-04: 8 POS  
(Ø 0.5 TERMINALS)

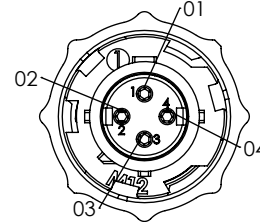


-05: 6 POS COMBO  
(2x Ø 1.0 TERMINALS)  
(4x Ø 0.5 TERMINALS)

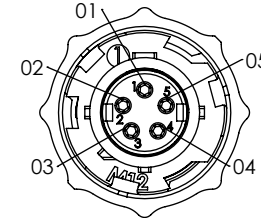


-S END OPTIONS

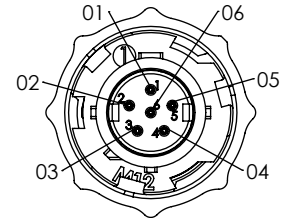
-01: 4 POS  
(Ø T.0 SOCKETS)



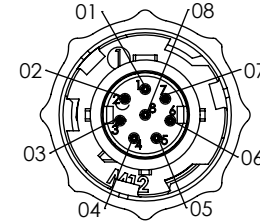
-02: 5 POS  
(Ø T.0 SOCKETS)



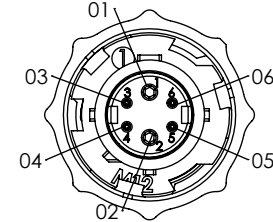
-03: 6 POS  
(Ø 0.5 SOCKETS)



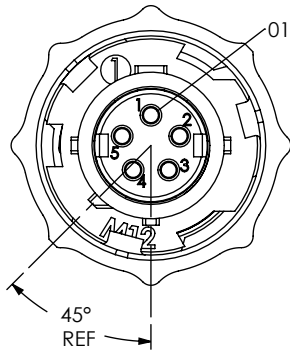
-04: 8 POS  
(Ø 0.5 SOCKETS)



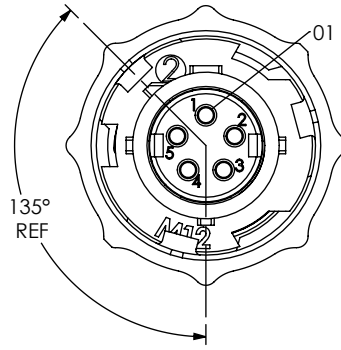
-05: 6 POS COMBO  
(2x Ø 1.0 SOCKETS)  
(4x Ø 0.5 SOCKETS)



-1  
(ORANGE KEY RING)

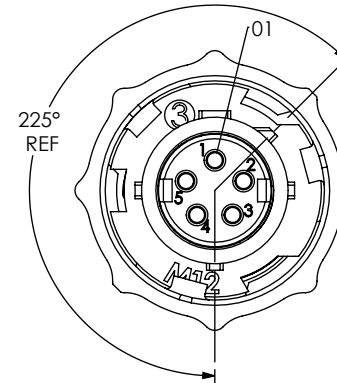


-2  
(GREEN KEY RING)

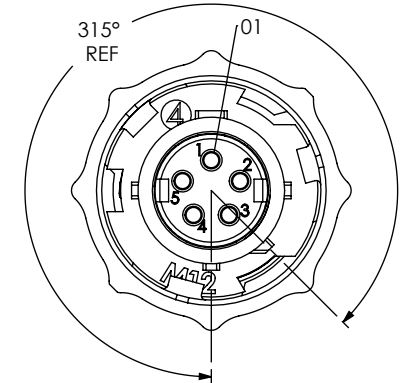


KEYING FEATURE  
(SEE NOTE 4)

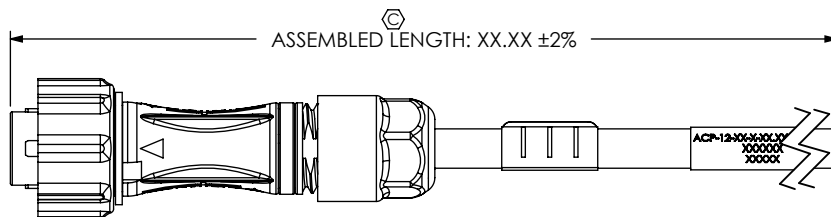
-3  
(BLUE KEY RING)



-4  
(YELLOW KEY RING)



-BC END OPTION  
ACP-12-01-X-XX.XX-T-BC-M-T SHOWN



F:\DWG\MISC\WKTG\ACP-12-XX-X-XX.XX-X-XX-M-X-MKT.SLDDRW

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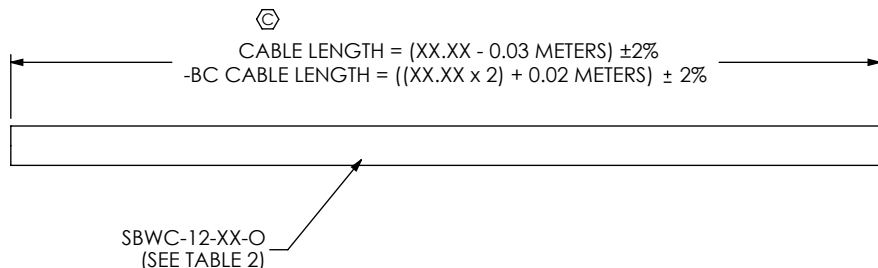
520 PARK EAST BLVD, NEW ALBANY, IN 47150  
PHONE: 812-944-6733 FAX: 812-948-5047  
e-Mail info@SAMTEC.com code 55322

DESCRIPTION: ACCLIMATE CIRC. CABLE ASSEMBLY

DWG. NO. ACP-12-XX-X-XX.XX-X-XX-M-X

BY: D.SHMELZ 09/16/2010 SHEET 2 OF 4

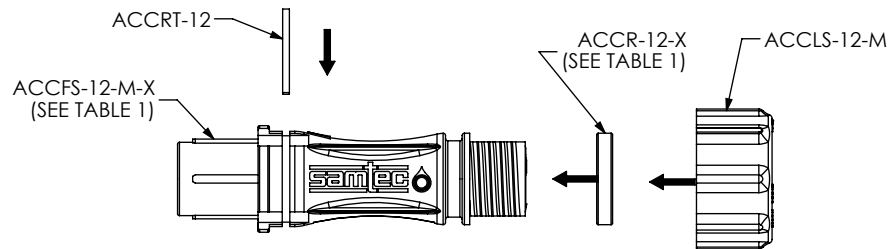
IN-PROCESS 1  
CUT SWBC-12-XX-O TO LENGTH



LEAD STYLES	SBWC PART #
-01	SBWC-12-01-O
-02	SBWC-12-02-O
-03	SBWC-12-03-O
-04	SBWC-12-04-O
-05	SBWC-12-05-O

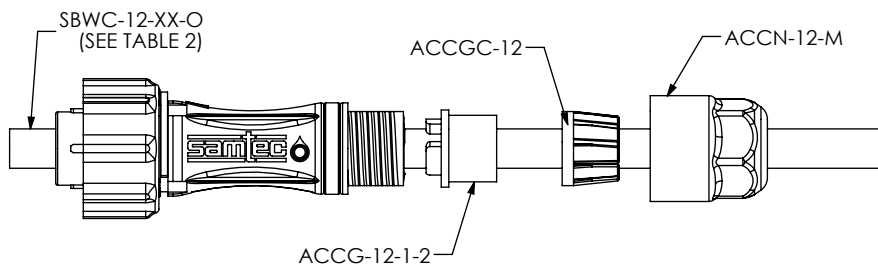
IN-PROCESS 2

STRETCH ACCR-12-X OVER ACCFS-12-M-X UNTIL IT SEATS IN GROOVE  
PUSH ACCLS-12-M ONTO ACCFS-12-M-X UNTIL IT BOTTOMS OUT AGAINST  
FLANGE. SNAP ACCRT-12 (RETAINING RING) INTO GROOVE IN  
ACCF-12-M-X TO HOLD ACCLS-12-M IN PLACE



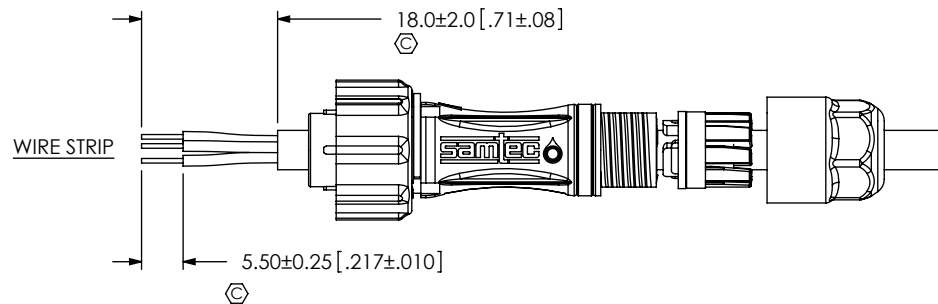
KEYING FEATURE	ACCF-12-M-X	ACCR-12-X
-1	ACCF-12-M-1	ACCR-12-1
-2	ACCF-12-M-2	ACCR-12-2
-3	ACCF-12-M-3	ACCR-12-3
-4	ACCF-12-M-4	ACCR-12-4

IN-PROCESS 3  
FEED SBWC-12-XX-O BUNDLED CABLE THROUGH ACCN-12-M,  
ACCGC-12, ACCG-12-1-2, & ACCFS-12-M-X



IN-PROCESS 4

STRIP OUTER JACKET & INNER WIRES TO DIMENSIONS  
SHOWN, & PUSH ACCG-12-1-2 INTO ACCGC-12



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PHONE: 812-944-6733 FAX: 812-948-5047  
e-Mail: info@SAMTEC.com code 55322

DESCRIPTION:  
ACCLIMATE CIRC. CABLE ASSEMBLY

DWG. NO.  
ACP-12-XX-X-XX.XX-X-XX-M-X

BY: D.SCHMELZ 09/16/2010 SHEET 3 OF 4

IN-PROCESS 5  
TERMINATE WIRES TO TERMINAL/SOCKETS  
(SEE NOTE 5)

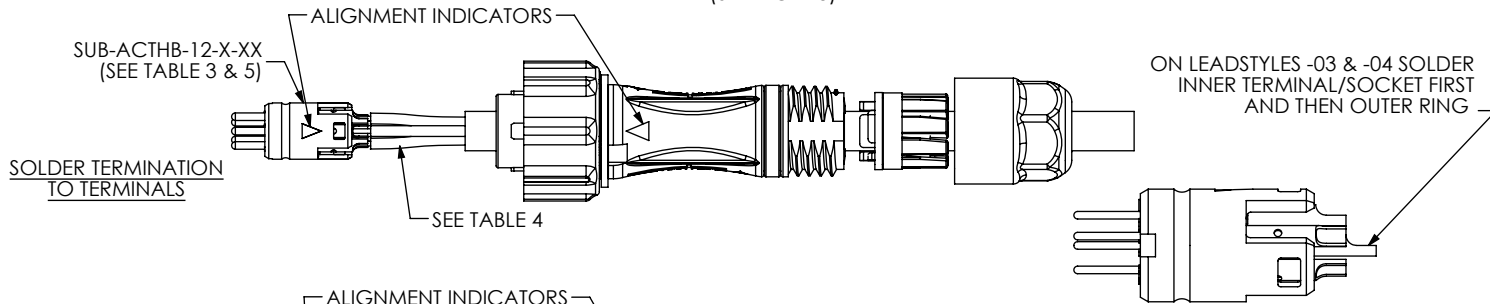


TABLE 3		
LEAD STYLE	END1/END 2	SUB-ACXHB-12-X-XX
-01	-T	SUB-ACTHB-12-X-01
-02	-T	SUB-ACTHB-12-X-02
-03	-T	SUB-ACTHB-12-X-03
-04	-T	SUB-ACTHB-12-X-04
-05	-T	SUB-ACTHB-12-X-05
-01	-S	SUB-ACSHB-12-X-01
-02	-S	SUB-ACSHB-12-X-02
-03	-S	SUB-ACSHB-12-X-03
-04	-S	SUB-ACSHB-12-X-04
-05	-S	SUB-ACSHB-12-X-05

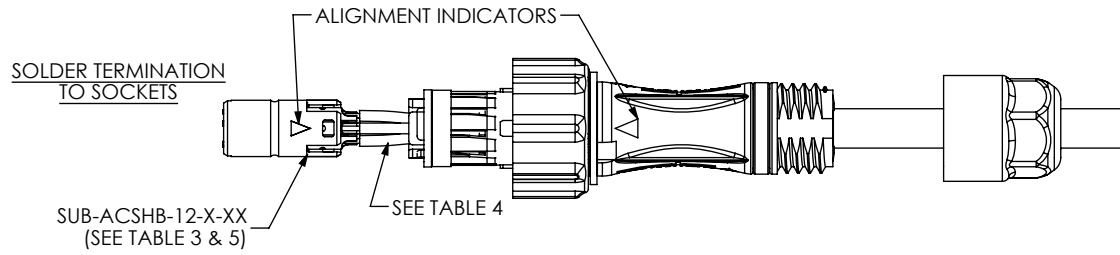
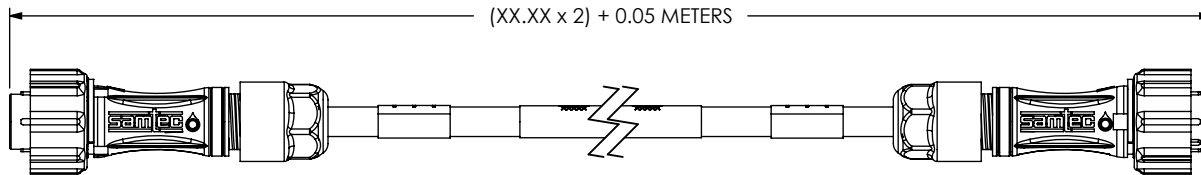
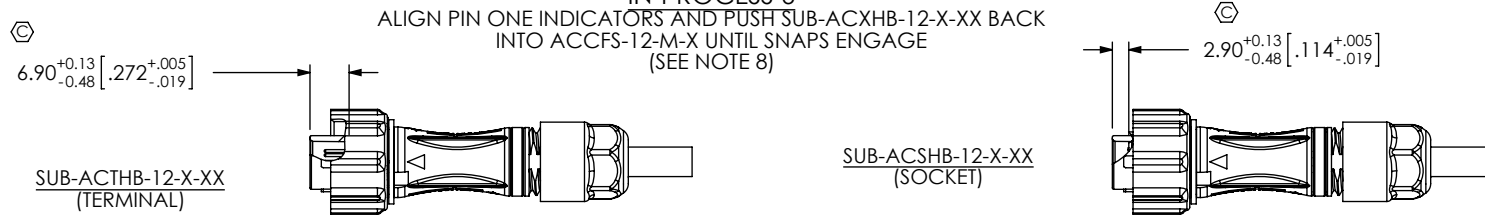


TABLE 4					
WIRE COLOR					
POSITION	LEAD STYLE				
	-01	-02	-03	-04	-05
01	BROWN	BROWN	BROWN	BROWN	BROWN
02	RED	RED	RED	RED	RED
03	ORANGE	ORANGE	ORANGE	ORANGE	ORANGE
04	YELLOW	YELLOW	YELLOW	YELLOW	YELLOW
05	NA	GREEN	GREEN	GREEN	GREEN
06		NA	BLUE	BLUE	BLUE
07			NA	VIOLET	NA
08				GRAY	

TABLE 5	
PLATING	SUB-ACXHB-12-X-XX
-G	SUB-ACXHB-12-G-XX
-H	SUB-ACXHB-12-H-XX

IN-PROCESS 6  
ALIGN PIN ONE INDICATORS AND PUSH SUB-ACXHB-12-X-XX BACK INTO ACCFS-12-M-X UNTIL SNAPS ENGAGE  
(SEE NOTE 8)



IN-PROCESS 7  
(-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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