

DO NOT SCALE FROM THIS PRINT

DESIGNED & DIMENSIONED IN MILLIMETERS [INCHES]

MCP-8-02-X-XX.XX-X-XX

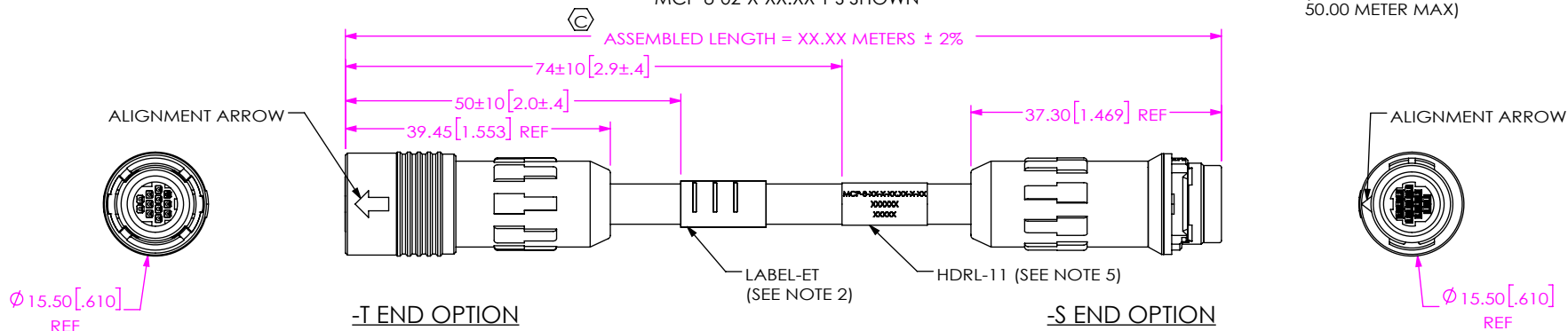
PLUG
SIZE
LEAD STYLE
-02: 12 POS, 28 AWG
PLATING SPECIFICATION
-L: 10µ" GOLD IN CONTACT AREA

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)

FIG 1
MCP-8-02-X-XX.XX-T-S SHOWN



END OPTIONS

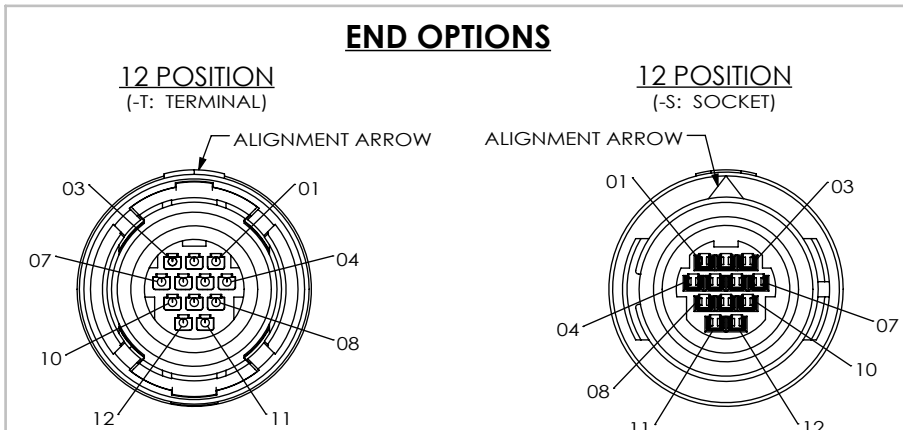
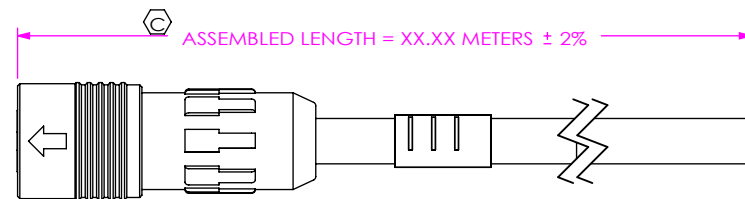


FIG 2
MCP-8-02-X-XX.XX-T-BC SHOWN
(BUILT DOUBLE ENDED INITIALLY FOR E-TEST)



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.
- FOLLOW PACKAGING MANUAL INSTRUCTIONS.
- SIGNAL MAPPING IS 1 TO 1, 2 TO 2, 3 TO 3, ETC..
- PLACE HDRL-11 (LABEL) ON CABLE WHERE SHOWN. LABEL TO CONTAIN
LINE 1 - PART NUMBER "MCP-8-XX-X-XX.XX-X-XX"
LINE 2 - SHOP ORDER NUMBER "XXXXXX"
LINE 3 - DATE CODE "XXXXX"
- CONTACTS/TERMINALS MUST BE INSERTED UNTIL RETENTION FEATURE LOCKS INTO PLACE.
- REFER TO CRIMP-SPECIFICATIONS PRINT FOR CRIMP AND STRIP DIMENSIONS, TOLERANCES, TOOLING, AND ITS REQUIREMENTS.
- T (TERMINAL): REFERENCE DC-MCP-8 PRINT FOR TERMINAL DUSTCAP
-S (SOCKET): REFERENCE DC-MCR-8 PRINT FOR SOCKET DUSTCAP
- APPLY EPOXY-40 (LOCTITE 7649) TO THE THREADS AND ALLOW TO DRY FOR 60 SECONDS.
- APPLY EPOXY-41 (LOCTITE 271) TO THE THREADS.
- O-RING MUST BE SEATED AGAINST CH-P-30-8-12.

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN MILLIMETERS.
TOLERANCES ARE:
DECIMALS ANGLES
X.X: ±0.3 [.01]
X.XX: ±0.13 [.005]
X.XXX: ±0.051 [.0020]

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MATERIAL: DO NOT SCALE DRAWING
INSULATORS, CABLE NUT, C-RING: PPS
TERMINALS & CONTACTS: PHOS BRONZE
GASKET, O-RING: SILICONE
SPRING: STAINLESS STEEL
COUPLING RING, SPACER: PBT
CABLE CLAMP: POM

SHEET SCALE: 1:1

samtec

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DESCRIPTION:
MINI CIRC. CABLE ASSEMBLY

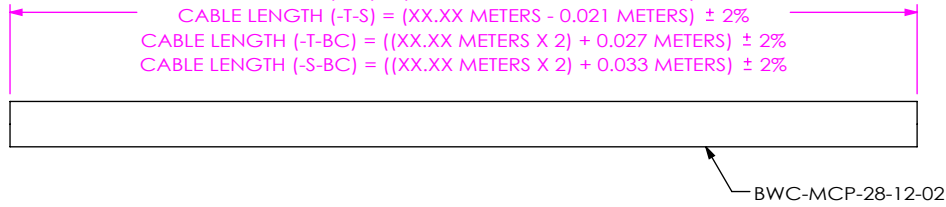
DWG. NO.
MCP-8-02-X-XX.XX-X-XX

BY: J. BORGELT 2/15/13 SHEET 1 OF 3

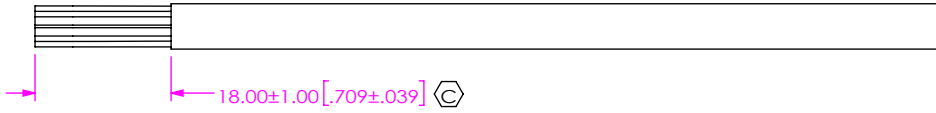
IN-PROCESS 1

CUT CABLE TO LENGTH SHOWN BASED ON END 1 & 2 GENDER
 (-BC FORMULA LENGTHS ADJUSTED TO INITIALLY BUILD CABLES DOUBLE ENDED)

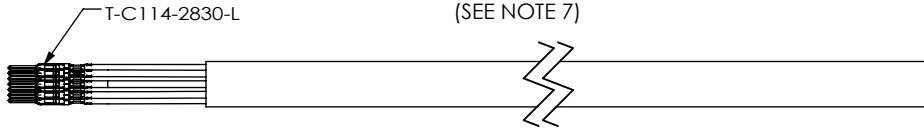
- ⊕ CABLE LENGTH (-T-T) = (XX.XX METERS - 0.02 METERS) ± 2%
- ⊕ CABLE LENGTH (-S-S) = (XX.XX METERS - 0.017 METERS) ± 2%
- ⊕ CABLE LENGTH (-T-S) = (XX.XX METERS - 0.021 METERS) ± 2%
- ⊕ CABLE LENGTH (-T-BC) = ((XX.XX METERS X 2) + 0.027 METERS) ± 2%
- ⊕ CABLE LENGTH (-S-BC) = ((XX.XX METERS X 2) + 0.033 METERS) ± 2%



IN-PROCESS 2
 STRIP OUTER JACKET

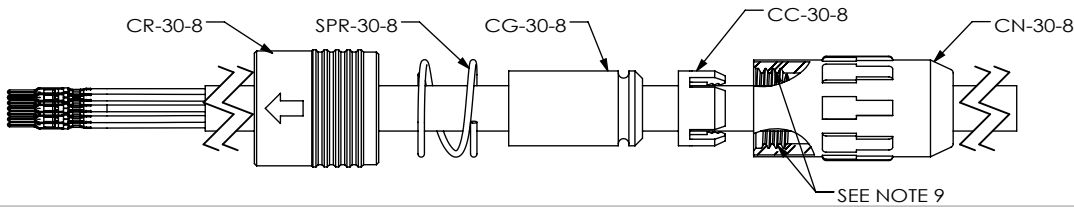


-T (TERMINAL): IN-PROCESS 3
 STRIP INDIVIDUAL WIRES & CRIMP TERMINALS
 (SEE NOTE 7)



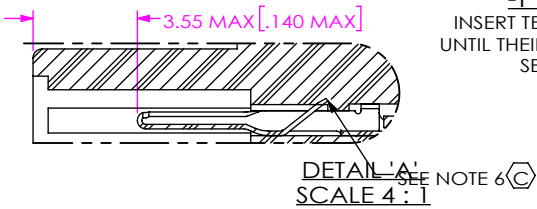
-T (TERMINAL): IN-PROCESS 4

APPLY EPOXY-40 (LOCTITE 7649) TO THE INTERNAL THREADS OF CN-30-8 (SEE NOTE 9).
 THEN SLIDE COMPONENTS ONTO CABLE IN ORDER SHOWN

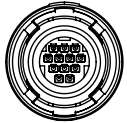
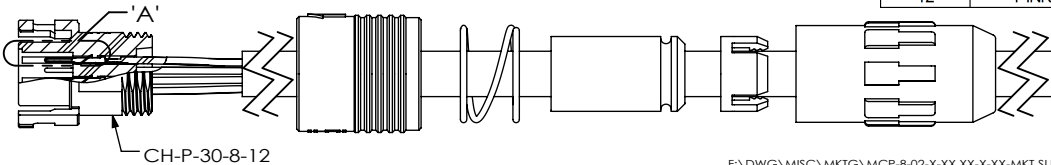


-T (TERMINAL): IN-PROCESS 5

INSERT TERMINALS INTO CH-P-30-8-12 INSULATOR
 UNTIL THEIR RETENTION FEATURES LOCK INTO PLACE.
 SEE TABLE 1 FOR COLOR MAPPING.

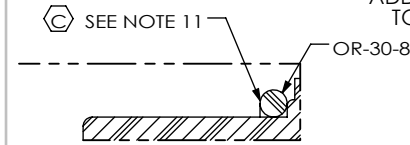


DETAIL 'A'
 SCALE 4:1

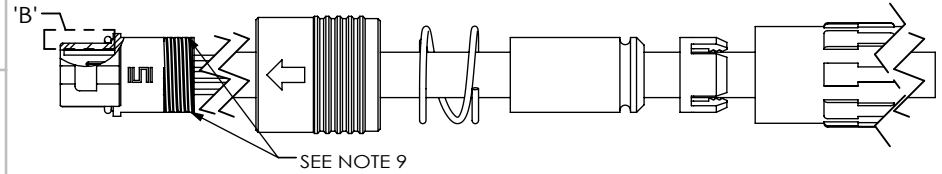


-T (TERMINAL): IN-PROCESS 6

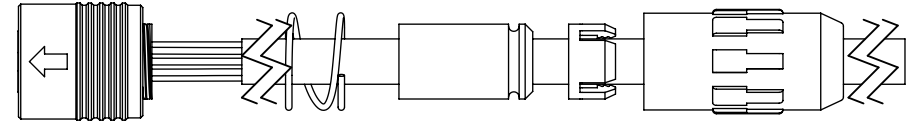
ADD OR-30-8 AND APPLY EPOXY-40 (LOCTITE 7649)
 TO THE THREADS OF CH-P-30-8-12 (SEE NOTE 9)



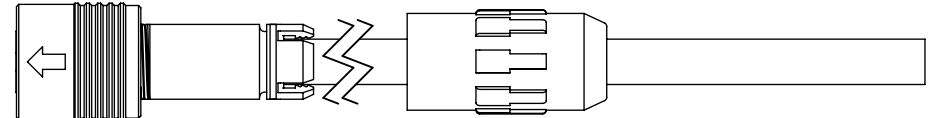
DETAIL 'B'
 SCALE 4:1



-T (TERMINAL): IN-PROCESS 7
 WHILE ALIGNING ORIENTATION FEATURES
 SLIDE CR-30-8 ONTO CH-P-30-8-12



-T (TERMINAL): IN-PROCESS 8
 SLIDE SPR-30-8 INTO CR-30-8.
 THEN SLIDE CG-30-8 UNTIL IT SEATS AGAINST THE BACK OF CH-P-30-8-12.
 THEN SLIDE CC-30-8 IN UNTIL IT SEATS AGAINST THE BACK OF CG-30-8.



-T (TERMINAL): IN-PROCESS 9

APPLY EPOXY-41 (LOCTITE 271) TO THREADS OF CN-30-8 (SEE NOTE 10). THEN
 THREAD CN-30-8 ON TO THE CH-P-30-8-12 & TORQUE TO 0.5 Nm [4.4 IN-LBS].

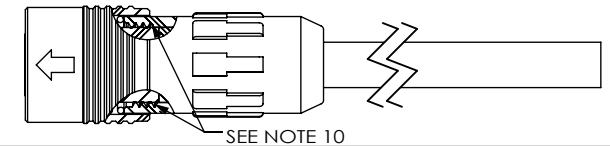


TABLE 1	
POSITION	COLOR
01	BROWN
02	RED
03	ORANGE
04	YELLOW
05	GREEN
06	BLUE
07	VIOLET
08	GRAY
09	WHITE
10	BLACK
11	LIGHT BLUE
12	PINK

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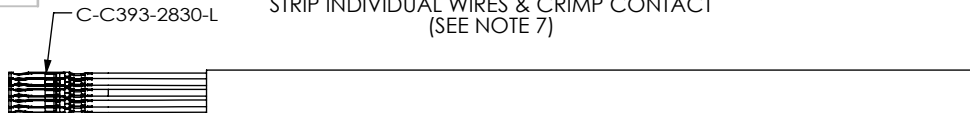
SHEET SCALE: 1:1



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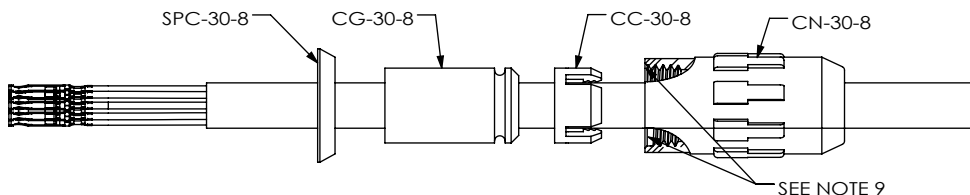
DESCRIPTION:	MINI CIRC. CABLE ASSEMBLY
DWG. NO.	MCP-8-02-X-XX.XX-X-XX
BY:	J. BORGELT 2/15/13 SHEET 2 OF 3

-S (SOCKET): IN-PROCESS 3
 STRIP INDIVIDUAL WIRES & CRIMP CONTACT
 (SEE NOTE 7)



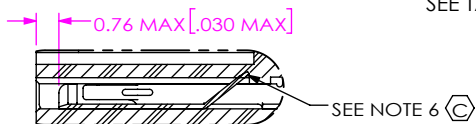
-S (SOCKET): IN-PROCESS 4

APPLY EPOXY-40 (LOCTITE 7649) TO THE THREADS OF CN-30-8 (SEE NOTE 9)
 SLIDE COMPONENTS ONTO CABLE IN ORDER SHOWN



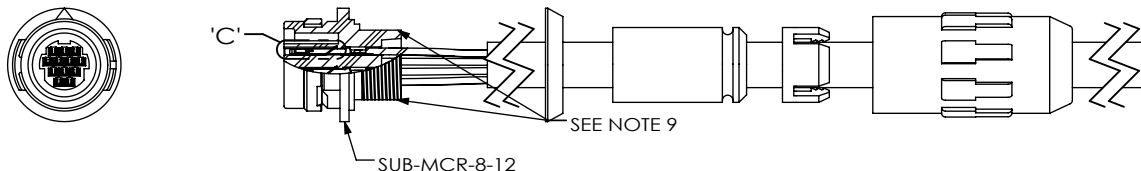
-S (SOCKET): IN-PROCESS 5

APPLY EPOXY-40 (LOCTITE 7649) TO THE THREADS OF SUB-MCR-8-12.
 INSERT CONTACTS INTO SUB-MCR-8-12 INSULATOR
 UNTIL THEIR RETENTION BEAMS ENGAGE.
 SEE TABLE 2 FOR COLOR MAPPING.
 (SEE NOTE 9)



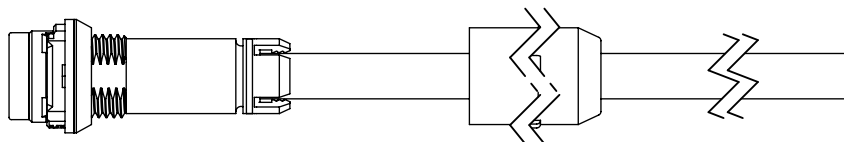
DETAIL 'C'
 SCALE 4 : 1

TABLE 2	
POSITION	COLOR
01	BROWN
02	RED
03	ORANGE
04	YELLOW
05	GREEN
06	BLUE
07	VIOLET
08	GRAY
09	WHITE
10	BLACK
11	LIGHT BLUE
12	PINK



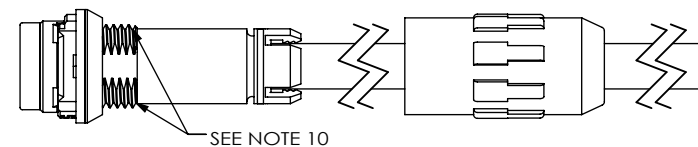
-S (SOCKET): IN-PROCESS 6

SLIDE SPC-30-8 ONTO SUB-MCR-8-12.
 THEN SLIDE CG-30-8 UNTIL IT SEATS AGAINST THE BACK OF SUB-MCR-8-12.
 THEN SLIDE CC-30-8 UNTIL IT SEATS AGAINST THE BACK OF CG-30-8.



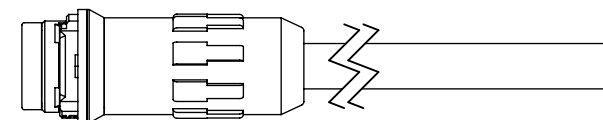
-S (SOCKET): IN-PROCESS 7

APPLY EPOXY-41 (LOCTITE 271)
 TO THE THREADS OF SUB-MCR-8-12. (SEE NOTE 10)



-S (SOCKET): IN-PROCESS 8

THREAD CN-30-8 ON TO SUB-MCR-8-12 & TORQUE TO 0.5 Nm [4.4 IN-LBS].



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SHEET SCALE: 1:1



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DESCRIPTION: MINI CIRC. CABLE ASSEMBLY

DWG. NO. MCP-8-02-X-XX.XX-X-XX

BY: J. BORGELT 2/15/13 SHEET 3 OF 3