

DESIGNED & DIMENSIONED
IN MILLIMETERS [INCHES]

DO NOT
SCALE FROM
THIS PRINT

MCR-8-02-X-XX.XX-X-XX

RECEPTACLE
SIZE

LEAD STYLE
-02: 12 POS, 28 AWG

PLATING SPECIFICATION
-L: 10µ" GOLD IN CONTACT AREA

END 2 (SEE TABLE 1)
-BC: BLUNT CUT
-01: 2 x 6 SFSD
(PIN 1 TO PIN 1)

END 1
-S: SOCKET

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

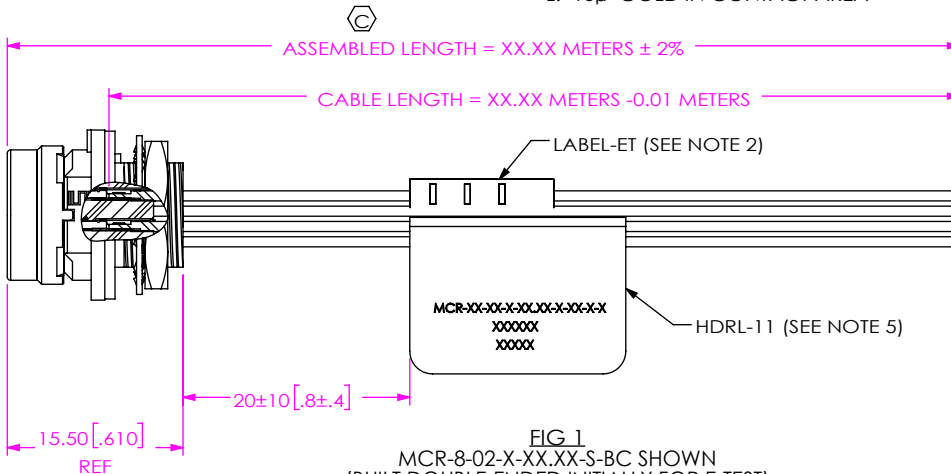
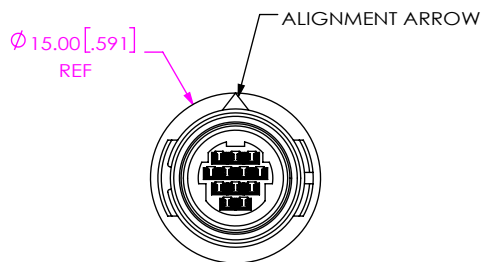


FIG 1
MCR-8-02-X-XX.XX-S-BC SHOWN
(BUILT DOUBLE-ENDED INITIALLY FOR E-TEST)

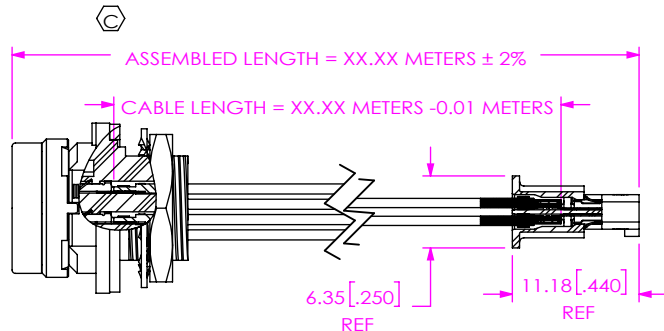
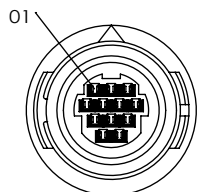
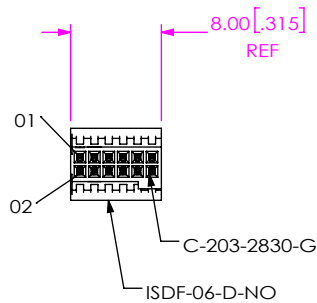
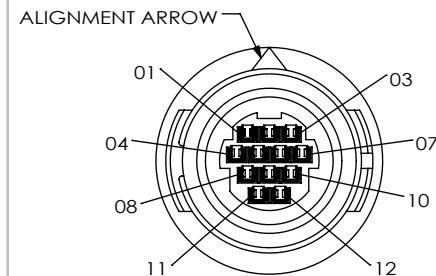


FIG 2
MCR-8-02-X-XX.XX-S-01 SHOWN
(PIN 1 TO PIN 1)
(DIFFERENT AS SHOWN, OTHERWISE SAME AS FIG 1)



END 1 OPTIONS

12 POSITION
(-S: SOCKET)



NOTES:

1. \odot 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. FOLLOW PACKAGING MANUAL INSTRUCTIONS.
4. SIGNAL MAPPING IS 1 TO 1, 2 TO 2, 3 TO 3, etc..
5. PLACE HDRL-11 (LABEL) ON CABLE WHERE SHOWN. LABEL TO CONTAIN
LINE 1 - PART NUMBER "MCR-8-XX-X-XX.XX-X-XX"
LINE 2 - SHOP ORDER NUMBER "XXXXXX"
LINE 3 - DATE CODE "XXXXXX"
6. PANEL THICKNESS RANGE: 0.70[0.027] - 3.00[0.118].
7. WHEN MOUNTING PRODUCT TO PANEL TORQUE PN-30-8 TO 0.8 Nm [7.08 IN-LBS].
8. CONTACTS MUST BE INSERTED UNTIL RETENTION FEATURE LOCKS INTO PLACE.
9. REFER TO CRIMP-SPECIFICATIONS PRINT FOR CRIMP AND STRIP DIMENSIONS, TOLERANCES, TOOLING, AND ITS REQUIREMENTS.
10. -S (SOCKET): REFERENCE DC-MCR-8 PRINT FOR SOCKET DUSTCAP

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: DO NOT SCALE DRAWING SHEET SCALE: 3:2
INSULATOR, C-RING: PPS
CONTACTS: PHOS BRONZE
GASKET: NEOPRENE RUBBER
LOCK WASHER: PHOS BRONZE, NI PLATED
HEX NUT: BRASS, NI PLATED

F:\DWG\MISC\MKTG\MCR-8-02-X-XX.XX-X-XX-MKT.SLDDRW

DESCRIPTION:
MINI CIRC. PANEL ASSEMBLY
DWG. NO.
MCR-8-02-X-XX.XX-X-XX
BY: J. BORGELT 4/11/2013 SHEET 1 OF 2



520 PARK EAST BLVD. NEW ALBANY, IN 47150
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REVISION G

IN-PROCESS 1

CUT CABLE TO LENGTH SHOWN
(CABLE LENGTH FORMULA HAS ADDER
FOR BUILDING CABLE DOUBLE ENDED)
(SEE NOTE 6)

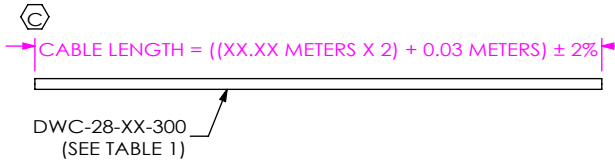
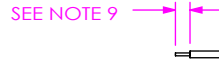


TABLE 1				
POSITION	-BC		-01	
	COLOR	DWC-XX-XX-XXX	COLOR	DWC-XX-XX-XXX
01	BROWN	DWC-28-01-300	BLACK	DWC-28-10-300
02	RED	DWC-28-02-300	BLACK	DWC-28-10-300
03	ORANGE	DWC-28-03-300	BLACK	DWC-28-10-300
04	YELLOW	DWC-28-04-300	BLACK	DWC-28-10-300
05	GREEN	DWC-28-05-300	BLACK	DWC-28-10-300
06	DARK BLUE	DWC-28-06-300	BLACK	DWC-28-10-300
07	VIOLET	DWC-28-07-300	BLACK	DWC-28-10-300
08	GRAY	DWC-28-08-300	BLACK	DWC-28-10-300
09	WHITE	DWC-28-09-300	BLACK	DWC-28-10-300
10	BLACK	DWC-28-10-300	BLACK	DWC-28-10-300
11	GREEN/BLACK	DWC-28-11-300	BLACK	DWC-28-10-300
12	TAN	DWC-28-12-300	BLACK	DWC-28-10-300

IN-PROCESS 2

STRIP CONDUCTORS



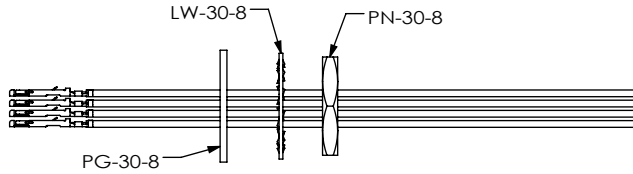
IN-PROCESS 3

CRIMP CONTACTS
(SEE NOTE 9)



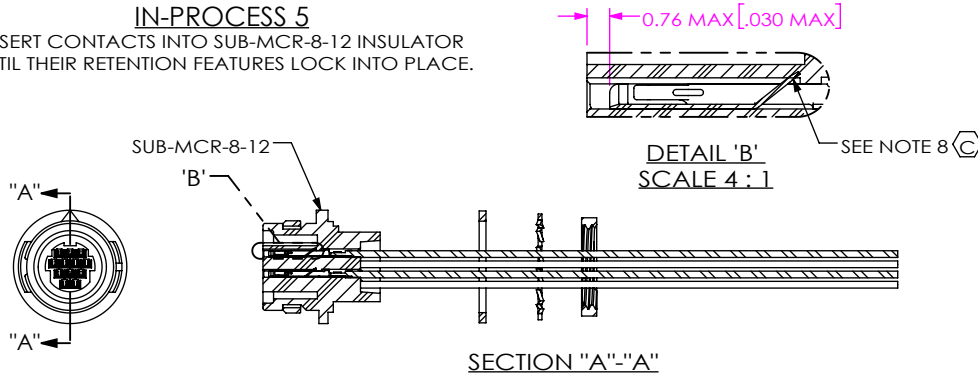
IN-PROCESS 4

SLIDE PG-30-8, LW-30-8, & PN-30-8 COMPONENTS ONTO WIRES



IN-PROCESS 5

INSERT CONTACTS INTO SUB-MCR-8-12 INSULATOR
UNTIL THEIR RETENTION FEATURES LOCK INTO PLACE.



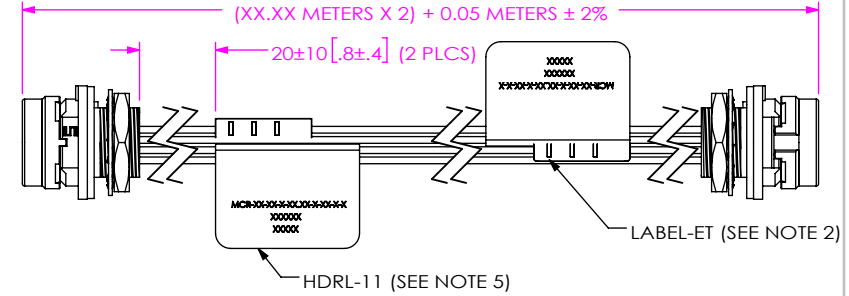
IN-PROCESS 6

SLIDE PG-30-8 FORWARD AND SEAT AGAINST FLANGE ON
SUB-MCR-8-12. SLIDE LW-30-8 FORWARD & LOOSELY THREAD
PN-30-8 ONTO SUB-MCR-8-12 TO HOLD ITEMS IN PLACE



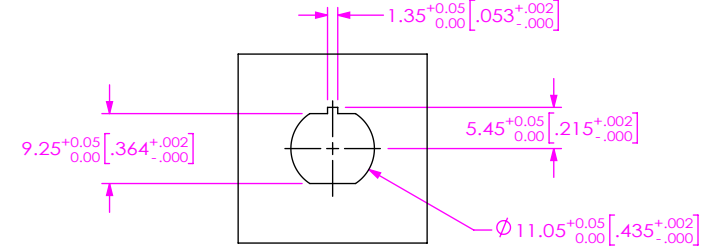
IN-PROCESS 7

REPEAT STEPS 2-6 FOR END 2. E-TEST CABLE, APPLY
LABEL-ET & HDRL-11 TO BOTH ENDS. CUT CABLE IN
HALF & TRIM BOTH ENDS TO FINISHED LENGTH.



RECOMMENDED PANEL OPENING

(SEE NOTES 6 & 7)



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DO NOT SCALE DRAWING

SHEET SCALE: 1:1

samtec

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DWG. NO.

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SHEET 2 OF 2