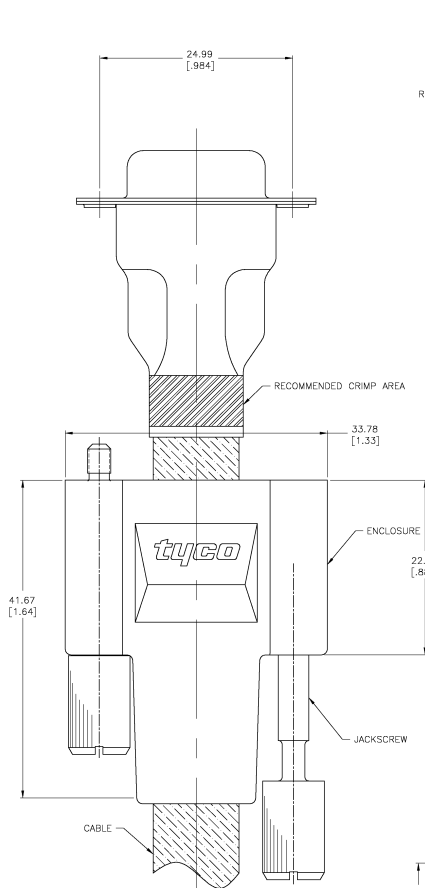
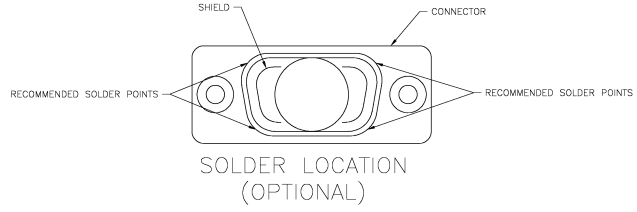


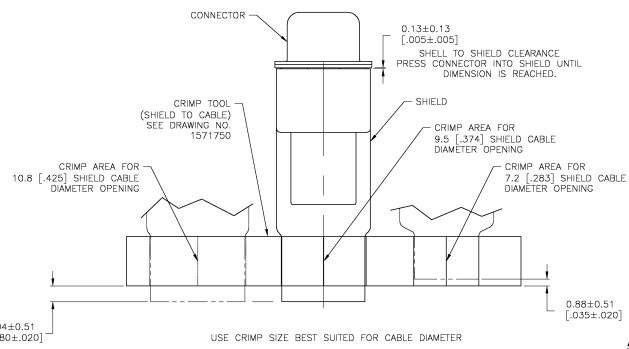
REV	DATE	DESCRIPTION	BY	CHK	APP
AD	00				
D		REV PER EC 023C-0008-04			



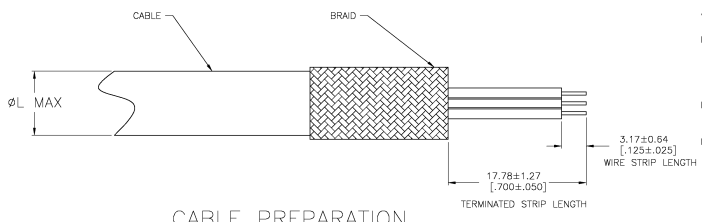
EXPLODED VIEW OF ASSEMBLED KIT



SOLDER LOCATION (OPTIONAL)



SHIELD TO CABLE CRIMP



CABLE PREPARATION

- NOTES**
- MATERIAL**
 INSERT: PBT, BLACK, UL94V-0 RATED
 CONTACT & JACKSCREWS: BRASS
 SHIELD & SHIELD: STEEL
 ENCLOSURE: PVC, BLACK
 - FINISH**
 CONTACT: GOLD PLATING 0.02μm [0.000002] MIN ON CONTACT AREA/2.3μm [0.00009] MIN
 TIN-LEAD PLATING ON SOLDER AREA ALL OVER 1.27μm [0.00050] MIN NICKEL
 SELL: 2.4μm [0.00095] MIN IN
 SHIELD: 2.0-3.0μm [0.00080-0.00120] TIN
 - SPECIFICATION**
 ELECTRICAL CHARACTERISTICS
 CURRENT RATING: 3 AMPRES
 DIELECTRIC WITHSTANDING VOLTAGE: AC 1000V (10/3)
 INSULATION RESISTANCE: 500Ω MEGOHMS MINIMUM AT DC 500V
 CONTACT RESISTANCE: 10 MEGOHMS MAXIMUM
 - RECEPTACLE CONNECTOR FULLY LOADED WITH CONTACTS. ALL OTHER PARTS ARE SHIPPED UNASSEMBLED, EACH PART INDIVIDUALLY BULK PACKED.
 - SOLDER CUP WILL ACCOMMODATE 20 MAX AWG WIRE.
 - FINISH**
 CONTACT: GOLD PLATING 0.02μm [0.000002] MIN ON CONTACT AREA/2.3μm [0.00009] MIN
 TIN-LEAD PLATING ON SOLDER AREA ALL OVER 1.27μm [0.00050] MIN NICKEL
 SELL: 2.4μm [0.00095] MIN IN
 SHIELD: 2.0-3.0μm [0.00080-0.00120] TIN
 - LEAD FREE PART
 - PRELIMINARY PART.

ASSEMBLY INSTRUCTIONS

- USE SHIELD ENCLOSURE EXPANSION TOOL, 58241-1 TO GET ENCLOSURE ON CABLE.
- PREPARE CABLE AS SHOWN.
- PLACE CABLE THROUGH SHIELD.
- SOLDER CONDUCTORS TO CONTACTS.
- PRESS SHIELD ONTO CONNECTOR AS SHOWN.
- SOLDER SHIELD TO CONNECTOR AS SHOWN (OPTIONAL).
- METALLIC SHIELD SURFACES AND INTERIOR ENCLOSURE SURFACE MUST BE CLEAN AND DRY PER 3M REQUIREMENTS.
- CUT TWO PIECES OF 3M/SCOTCH VHB 4926, DOUBLE COATED ADHESIVE TAPE 6 TO 8mm WIDE BY 12 TO 18mm LONG.
- APPLY TAPE TO METALLIC SHIELD SURFACE LENGTHWISE, ADJACENT TO CONNECTOR FLANGE.
- REMOVE ADHESIVE BACKING FROM TAPE AND PUSH ENCLOSURE OVER METALLIC SHIELD.
- BOND STRENGTH IS DEPENDANT ON THE AMOUNT OF SURFACE CONTACT DEVELOPED. A FIRM APPLICATION DEVELOPS A BETTER BOND. ULTIMATE SURFACE CONTACT CAN BE ACCOMPLISHED BY CLAMPING ENCLOSURE TO THE SHIELD. CARE SHOULD BE TAKEN NOT TO MARK THE POLYMER SURFACE. SHIMS MAY BE REQUIRED TO EVENLY DISTRIBUTE THE CLAMPING FORCE ACROSS THE POLYMER.
- ULTIMATE BOND STRENGTH IS DEVELOPED AFTER 72 HOURS, BUT MAY BE ACCELERATED BY EXPOSURE TO 66°C FOR 1 HOUR, IF THE CLAMPS ARE COMPATIBLE WITH THIS TEMPERATURE.
- INSERT JACK SCREWS.

FINISH	CABLE DIA	PART NUMBER
△	10.8 [0.425]	1571654-6
△	9.5 [0.374]	1571654-5
△	7.2 [0.283]	1571654-4
△	10.8 [0.425]	1571654-3
△	9.5 [0.374]	1571654-2
△	7.2 [0.283]	1571654-1

THIS DRAWING IS A CONTROLLED DOCUMENT.		BY: [blank]	DATE: [blank]	tyco	Two Electronics Corporation
REV	DESCRIPTION	DATE	BY	CHK	APP
1	BULK KIT, RECEPTACLE, AMPLIMATE SOLDER CUP SHIELDING ENCLOSURE 9 POSITION, SIZE 1	10B-40031			
DATE	ISSUE	ISSUE NO	REV	BY	APP
		A1	00779		
CUSTOMER DRAWING		SCALE	4:1	REV	D