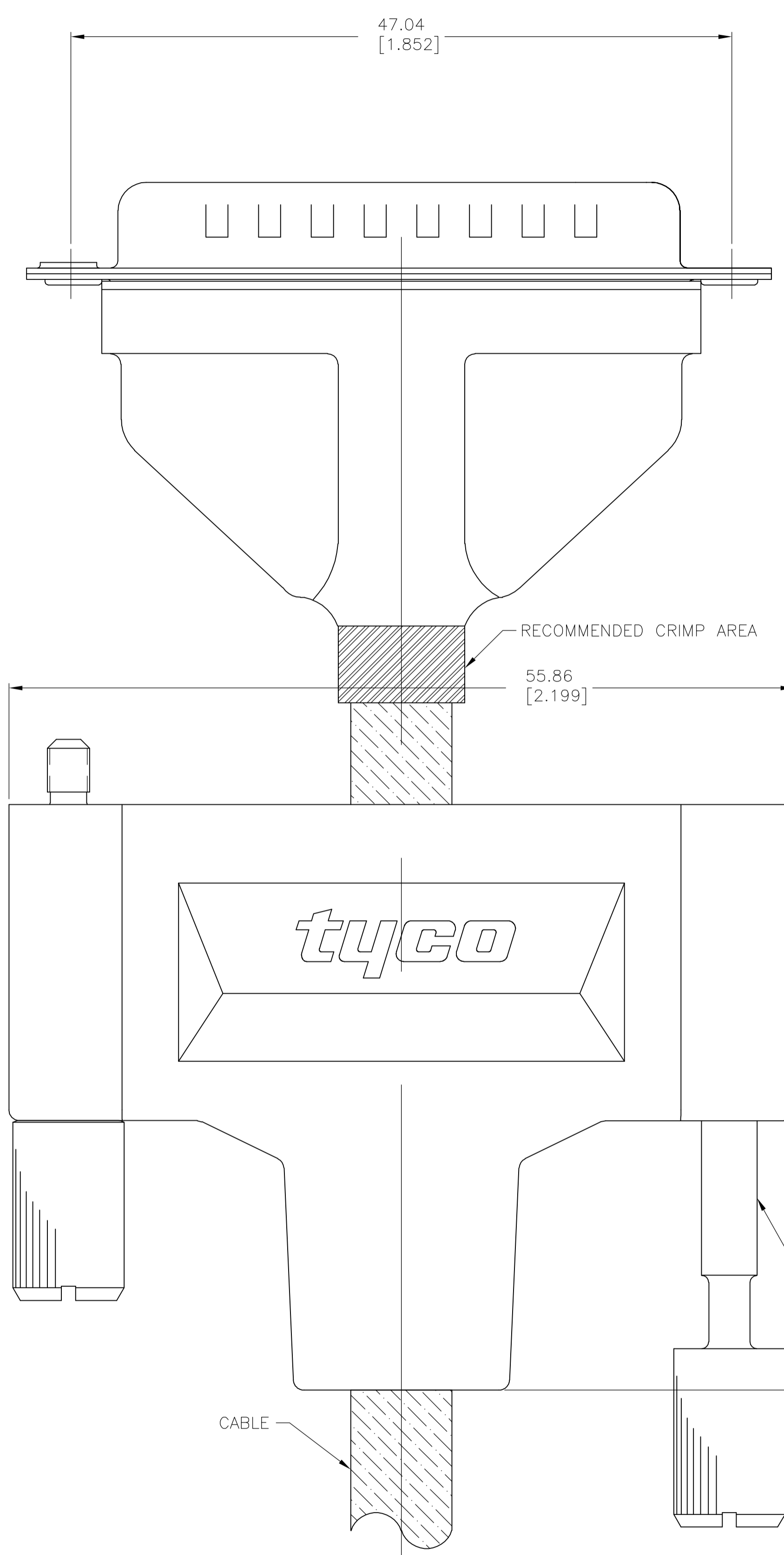
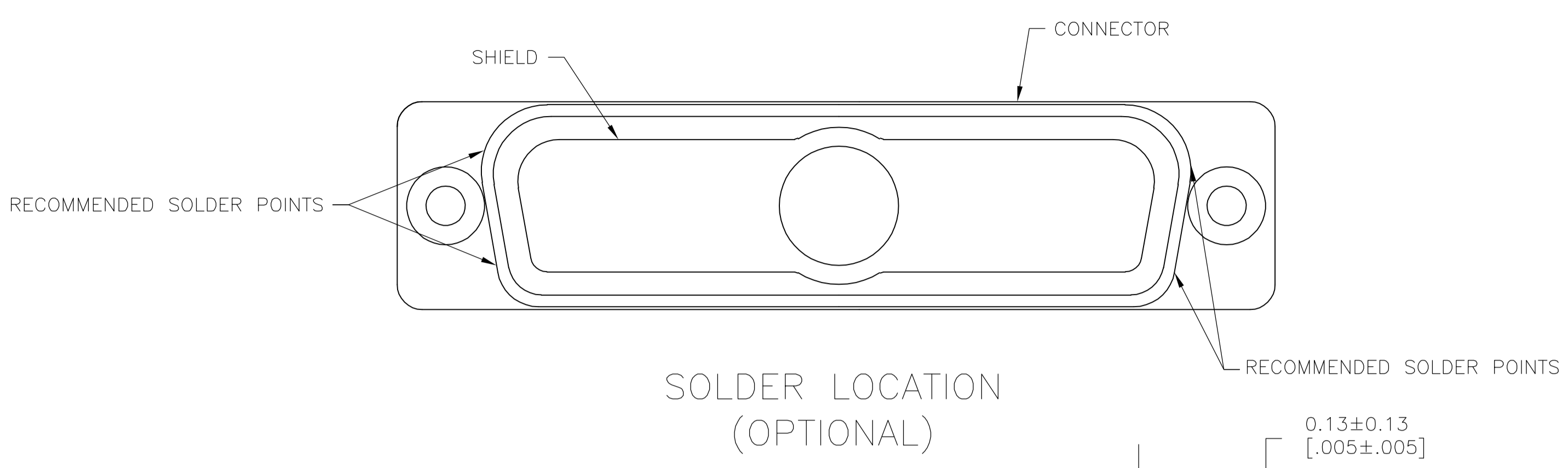


NON ROHS COMPLIANT VERSION

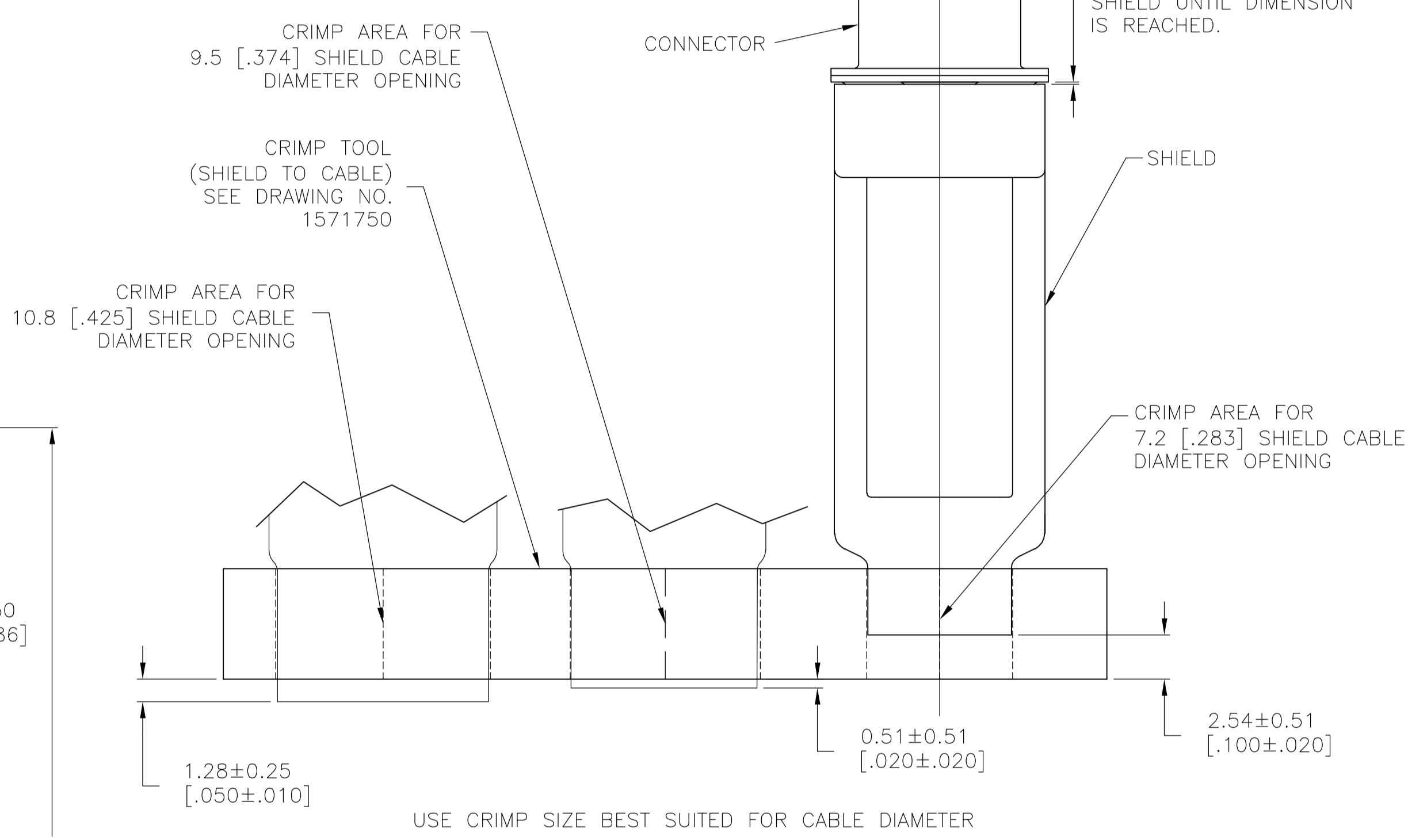
LOC		DIST		REVISIONS			
AD	00	REV	DATE	BY	APPV	DATE	BY
		D2	ECO-07-03605			15FEB07	MB JO



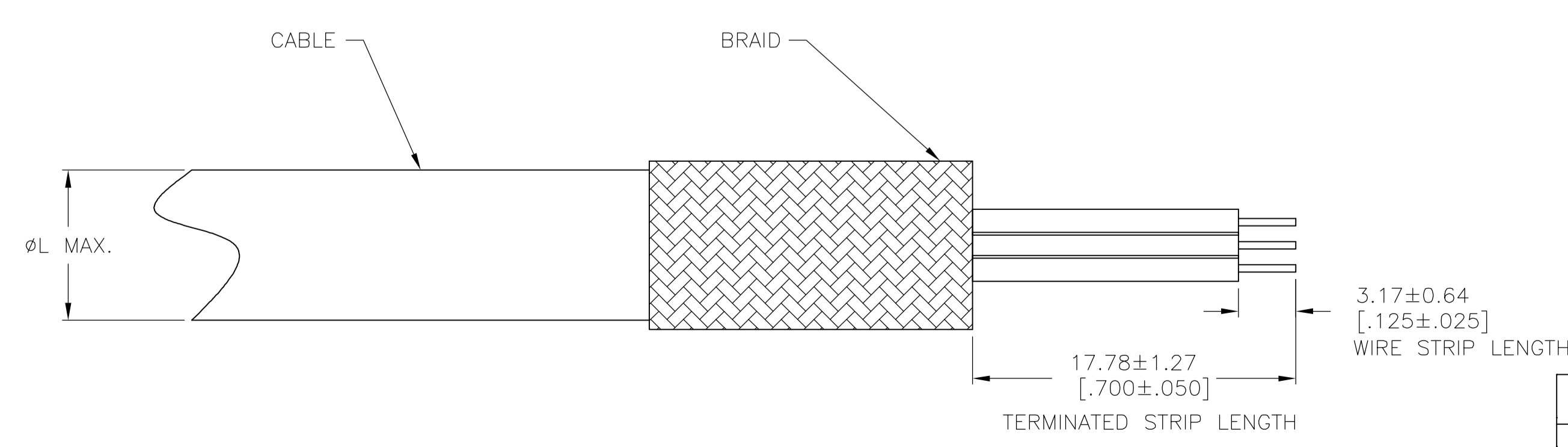
EXPLODED VIEW OF ASSEMBLED KIT



SOLDER LOCATION (OPTIONAL)



SHIELD TO CABLE CRIMP



CABLE PREPARATION

1. NOTES:  
 MATERIAL  
 INSERT: PBT, BLACK, UL94V-0 RATED  
 CONTACT & JACKSCREWS: BRASS  
 SHELLS & SHIELD: STEEL  
 ENCLOSURE: PVC, BLACK
2. FINISH:  
 CONTACT: GOLD PLATING 0.02µm[.0000008] MIN. ON CONTACT AREA, 2.3µm[.000090] MIN. TIN-LEAD PLATING ON SOLDER AREA. ALL OVER 1.27µm[.000050] MIN. NICKEL.  
 SHELL: 2.4µm[.000095] MIN. TIN  
 SHIELD: 2.0-3.0µm[.000080-.000120] TIN.
3. SPECIFICATION:  
 ELECTRICAL CHARACTERISTICS:  
 CURRENT RATING: 3 AMPERES  
 DIELECTRIC WITHSTANDING VOLTAGE: AC 1000V r.m.s  
 INSULATION RESISTANCE: 5000 MEGAOHMS MINIMUM AT DC 500V  
 CONTACT RESISTANCE: 10 MILLIOHMS MAXIMUM.
4. PLUG CONNECTOR FULLY LOADED WITH CONTACTS. ALL OTHER PARTS ARE SHIPPED UNASSEMBLED, EACH PART INDIVIDUALLY BULK PACKED.
5. SOLDER CUP WILL ACCOMMODATE 20 MAX. AWG WIRE.
6. FINISH:  
 CONTACT: GOLD PLATING 0.02µm[.0000008] MIN. ON CONTACT AREA, 2.3µm[.000090] MIN. TIN PLATING ON SOLDER AREA. ALL OVER 1.27µm[.000050] MIN. NICKEL.  
 SHELL: 2.4µm[.000095] MIN. TIN  
 SHIELD: 2.0-3.0µm[.000080-.000120] TIN
8. ROHS 2002/95/EC COMPLIANT PART (SEE SHEET 2).

ASSEMBLY INSTRUCTIONS

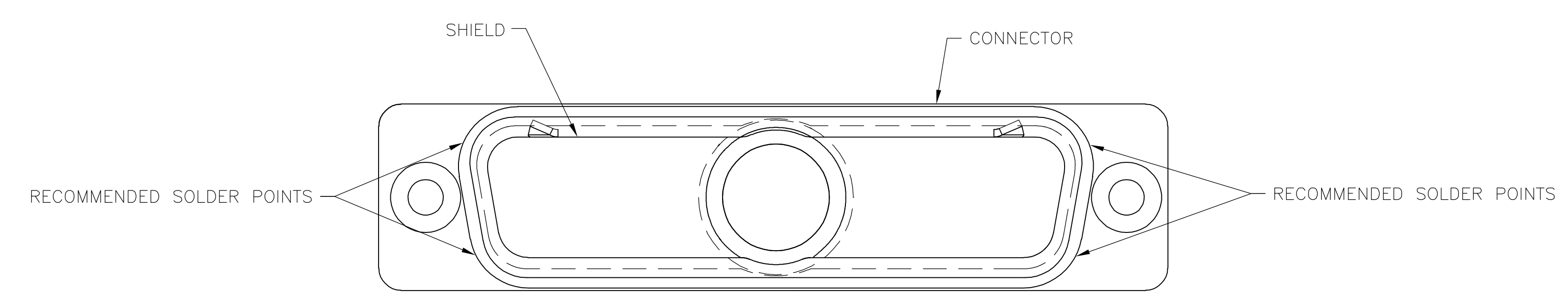
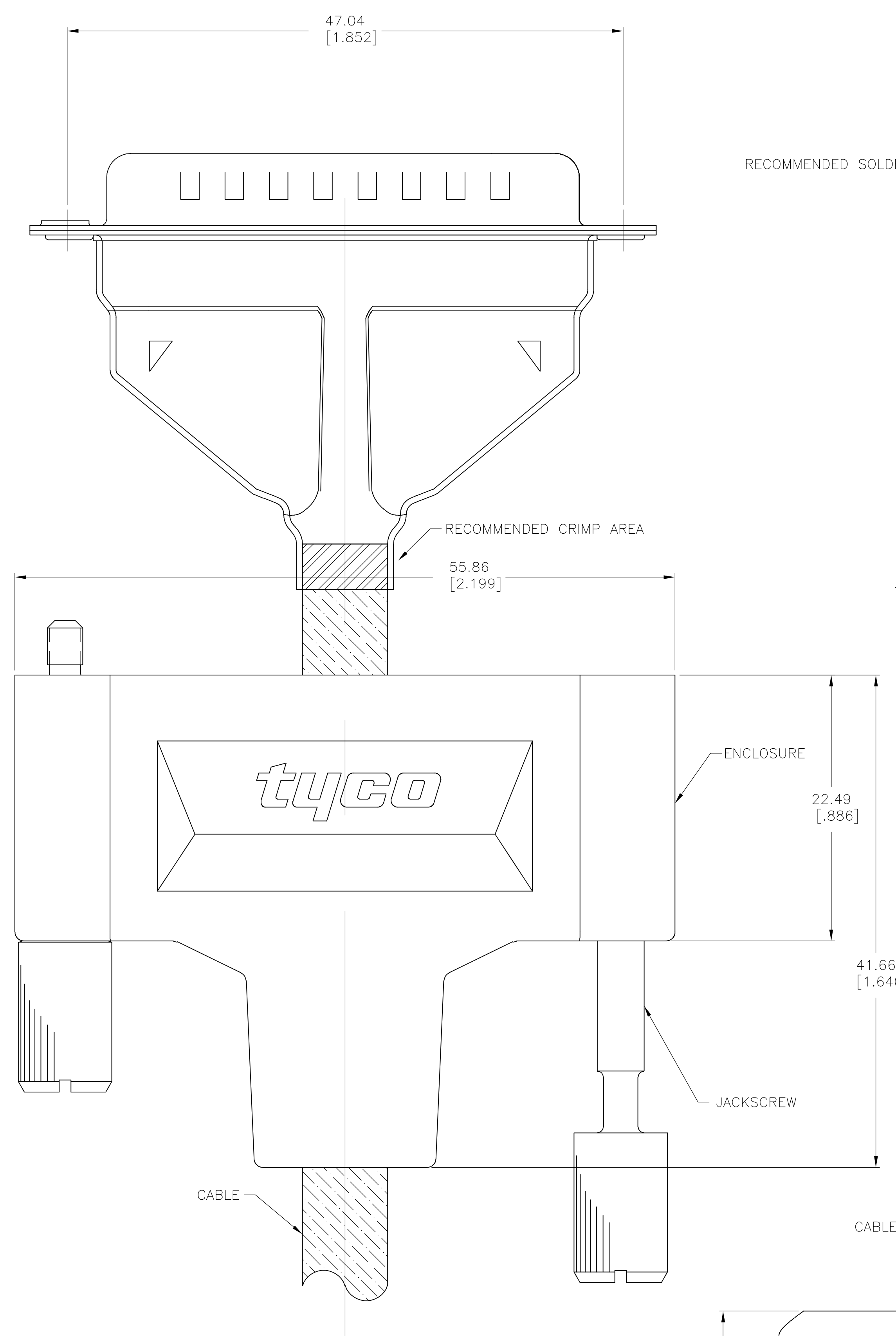
- USE SHIELD ENCLOSURE EXPANSION TOOL, 58241-1 TO GET ENCLOSURE ON CABLE.
- PREPARE CABLE AS SHOWN.
- PLACE CABLE THROUGH SHIELD.
- SOLDER CONDUCTORS TO CONTACTS.
- PRESS SHIELD ONTO CONNECTOR AS SHOWN.
- SOLDER SHIELD TO CONNECTOR AS SHOWN (OPTIONAL).
- METALLIC SHIELD SURFACES AND INTERIOR ENCLOSURE 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 31 TO 35mm 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 MAR 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.

8	6	10.8 [.425]	1571652-6
8	6	9.5 [.374]	1571652-5
8	6	7.2 [.283]	1571652-4
SUPERSEDED BY 1571652-6	2	10.8 [.425]	1571652-3
SUPERSEDED BY 1571652-5	2	9.5 [.374]	1571652-2
SUPERSEDED BY 1571652-4	2	7.2 [.283]	1571652-1
	FINISH	CABLE DIA L	PART NUMBER

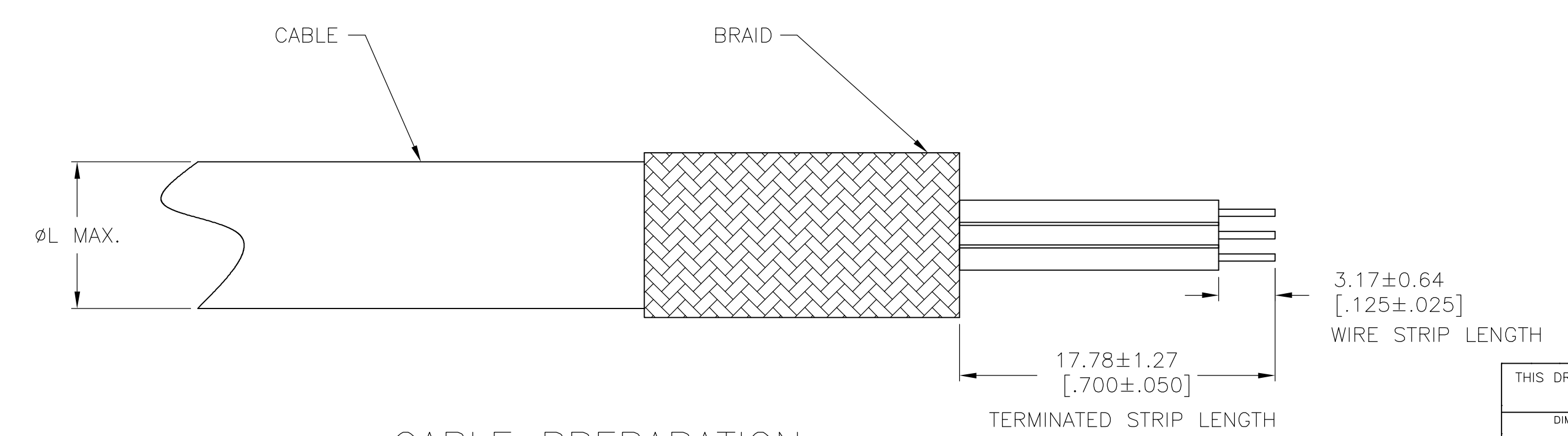
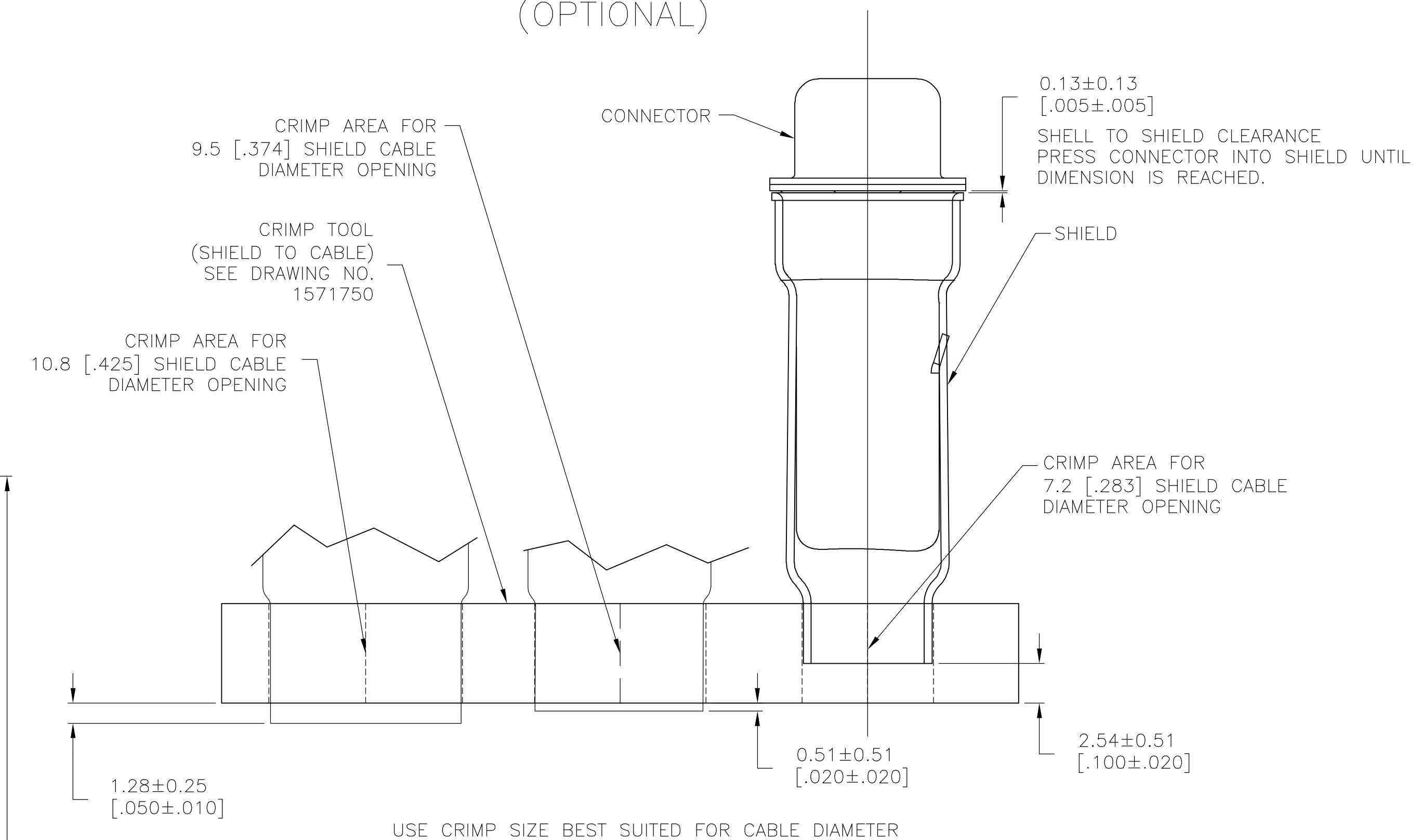
DIMENSIONS:		TOLERANCES UNLESS OTHERWISE SPECIFIED:		MATERIAL		FINISH		WEIGHT		CUSTOMER DRAWING	
0 PLC	±	±	±	1	2	6	1	1	1	1	1
1 PLC	±	±	±	1	2	6	1	1	1	1	1
2 PLC	±	±	±	1	2	6	1	1	1	1	1
3 PLC	±	±	±	1	2	6	1	1	1	1	1
4 PLC	±	±	±	1	2	6	1	1	1	1	1
ANGLES	±	±	±	1	2	6	1	1	1	1	1

ROHS 2002/95/EC COMPLIANT VERSION

LOC		DIST		REVISIONS			
F	LTR	DESCRIPTION	DATE	DRN	APVD		
AD	00	SEE SHEET 1					



SOLDER LOCATION (OPTIONAL)



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).
- CRIMP SHIELD TO CABLE AS SHOWN IN CRIMP DETAIL
- PRESS ENCLOSURE OVER SHIELD UNTIL CONNECTOR FLANGE IS FLUSH WITH ENCLOSURE EDGE.
- INSERT JACKSCREWS.

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	M. BINNER	21NOV03	<b>tyco</b> Electronics	Tyco Electronics Corporation Harrisburg, Pa 17105-3608
DIMENSIONS: mm [INCHES]		CHK		APVD		NAME
TOLERANCES UNLESS OTHERWISE SPECIFIED:		0 PLC ± -		PRODUCT SPEC		BULK KIT, PLUG, AMPLIMITE
1 PLC ± 0.3[.012]		2 PLC ± -		APPLICATION SPEC		108-40031
3 PLC ± -		4 PLC ± -		SIZE		25 POSITION, SIZE 3
ANGLES FINISH		± -		CAGE CODE		DRAWING NO
MATERIAL		1		WEIGHT		A1 00779
		2		SCALE		4:1
		6		SHEET		2 OF 2
				REV		D2