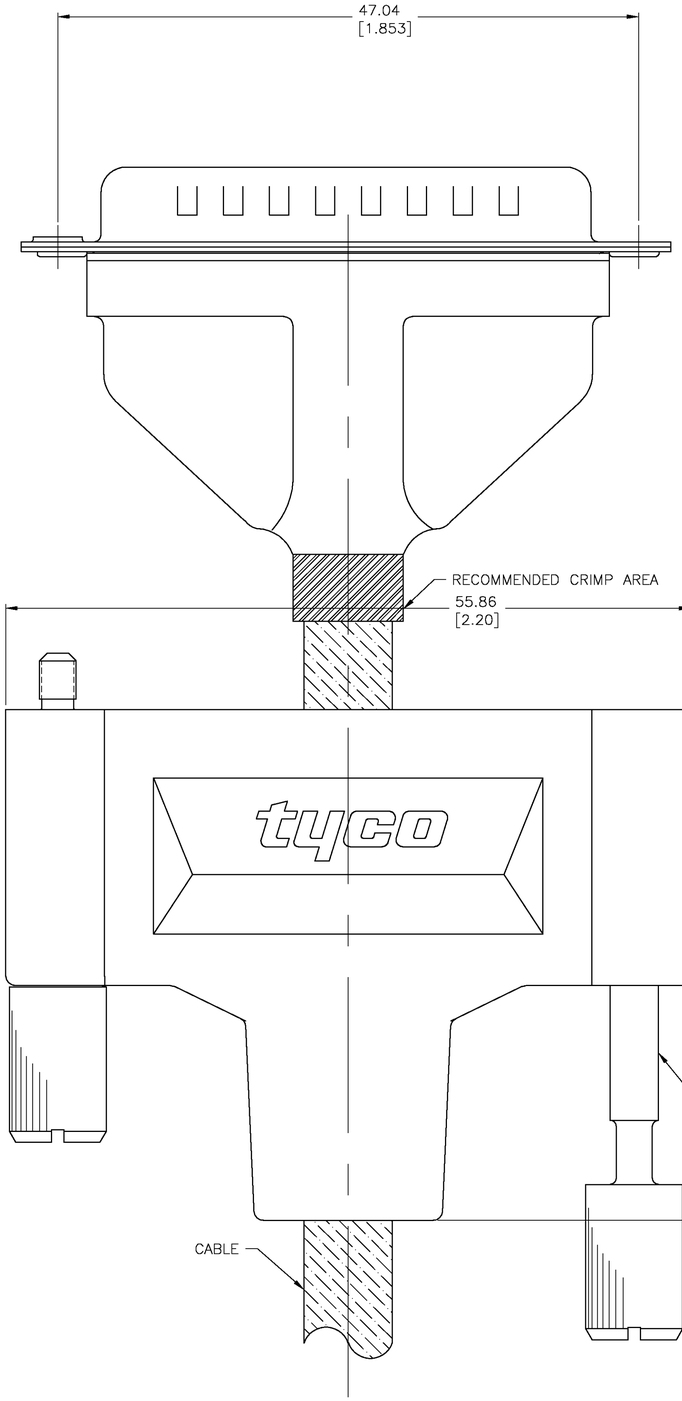
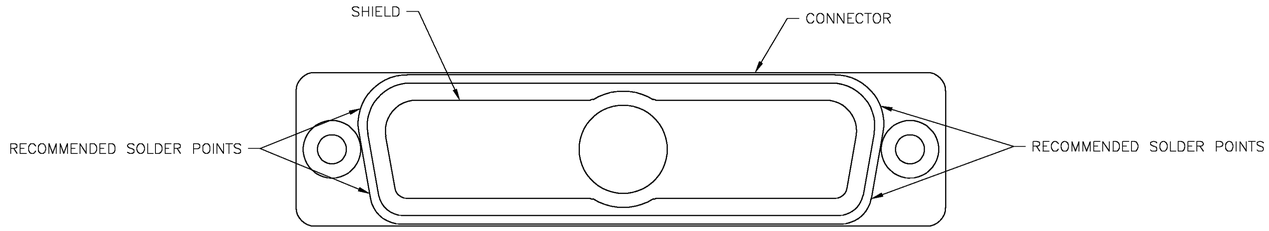
LOC	DIST
AD	00

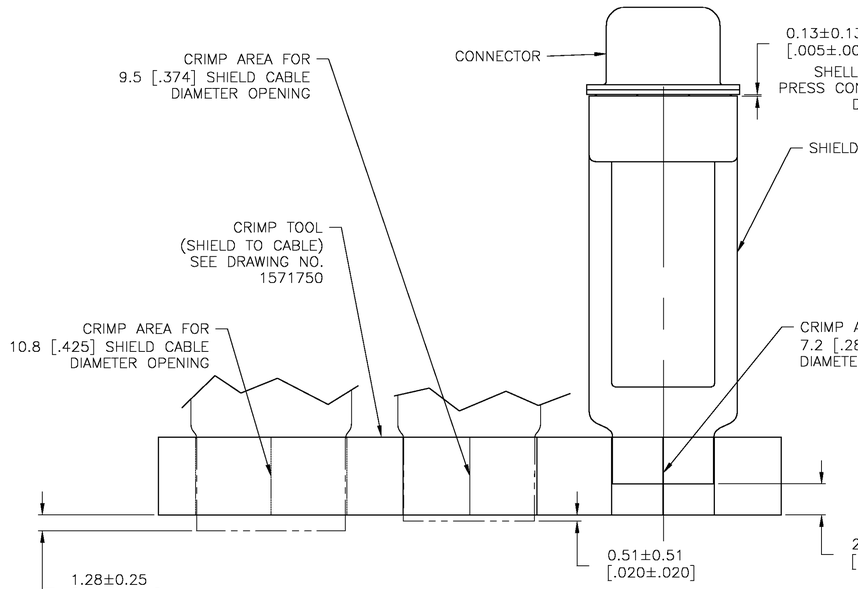
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	D	REV PER EC 0G3C-0606-04	19OCT04	MB	JO



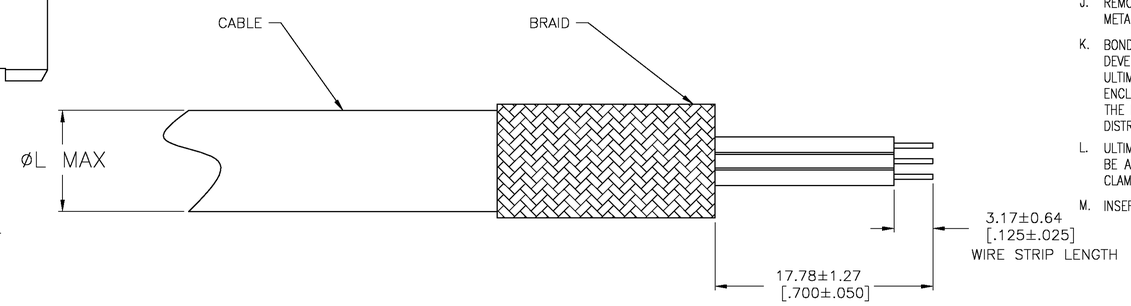


SOLDER LOCATION
(OPTIONAL)



USE CRIMP SIZE BEST SUITED FOR CABLE DIAMETER

SHIELD TO CABLE CRIMP



CABLE PREPARATION

EXPLODED VIEW OF
ASSEMBLED KIT

NOTES :
1. 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 MEGOHMS 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 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

7. LEAD FREE PART.

8. PRELIMINARY PART.

ASSEMBLY INSTRUCTIONS

A. USE SHIELD ENCLOSURE EXPANSION TOOL, 58241-1 TO GET ENCLOSURE ON CABLE.
B. PREPARE CABLE AS SHOWN.
C. PLACE CABLE THROUGH SHIELD.
D. SOLDER CONDUCTORS TO CONTACTS.
E. PRESS SHIELD ONTO CONNECTOR AS SHOWN.
F. SOLDER SHIELD TO CONNECTOR AS SHOWN (OPTIONAL).
G. METALLIC SHIELD SURFACES AND INTERIOR ENCLOSURE SURFACE MUST BE CLEAN AND DRY PER 3M REQUIREMENTS.
H. CUT TWO PIECES OF 3M/SCOTCH VHB 4926, DOUBLE COATED ADHESIVE TAPE 6 TO 8mm WIDE BY 31 TO 35mm LONG.
I. APPLY TAPE TO METALLIC SHIELD SURFACE. LENGTHWISE. ADJACENT TO CONNECTOR FLANGE.
J. REMOVE ADHESIVE BACKING FROM TAPE AND PUSH ENCLOSURE OVER METALLIC SHIELD.
K. BOND SRENGTH 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 ACCROOS THE POLYMER.
L. 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.
M. INSERT JACK SCREWS.

8 6	10.8 [.425]	7	1571652-6
8 6	9.5 [.374]	7	1571652-5
8 6	7.2 [.283]	7	1571652-4
2	10.8 [.425]		1571652-3
2	9.5 [.374]		1571652-2
2	7.2 [.283]		1571652-1
FINISH	CABLE DIA L		PART NUMBER

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: mm [INCHES]

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ± -
1 PLC ± 0.3[.012]
2 PLC ± -
3 PLC ± -
4 PLC ± -
ANGLES ± -

MATERIAL 1 FINISH 2

DWN	M.BINNER 21NOV03
CHK	-
APVD	-
PRODUCT SPEC	108-40031
APPLICATION SPEC	-
WEIGHT	-

Tyco Electronics Corporation
Harrisburg, Pa 17105-3608

NAME: BULK KIT, PLUG, AMPLIMITE SOLDER CUP SHIELDING ENCLOSURE 25 POSITION, SIZE 3

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-1571652	-

CUSTOMER DRAWING | SCALE 4:1 | SHEET 1 OF 1 | REV D