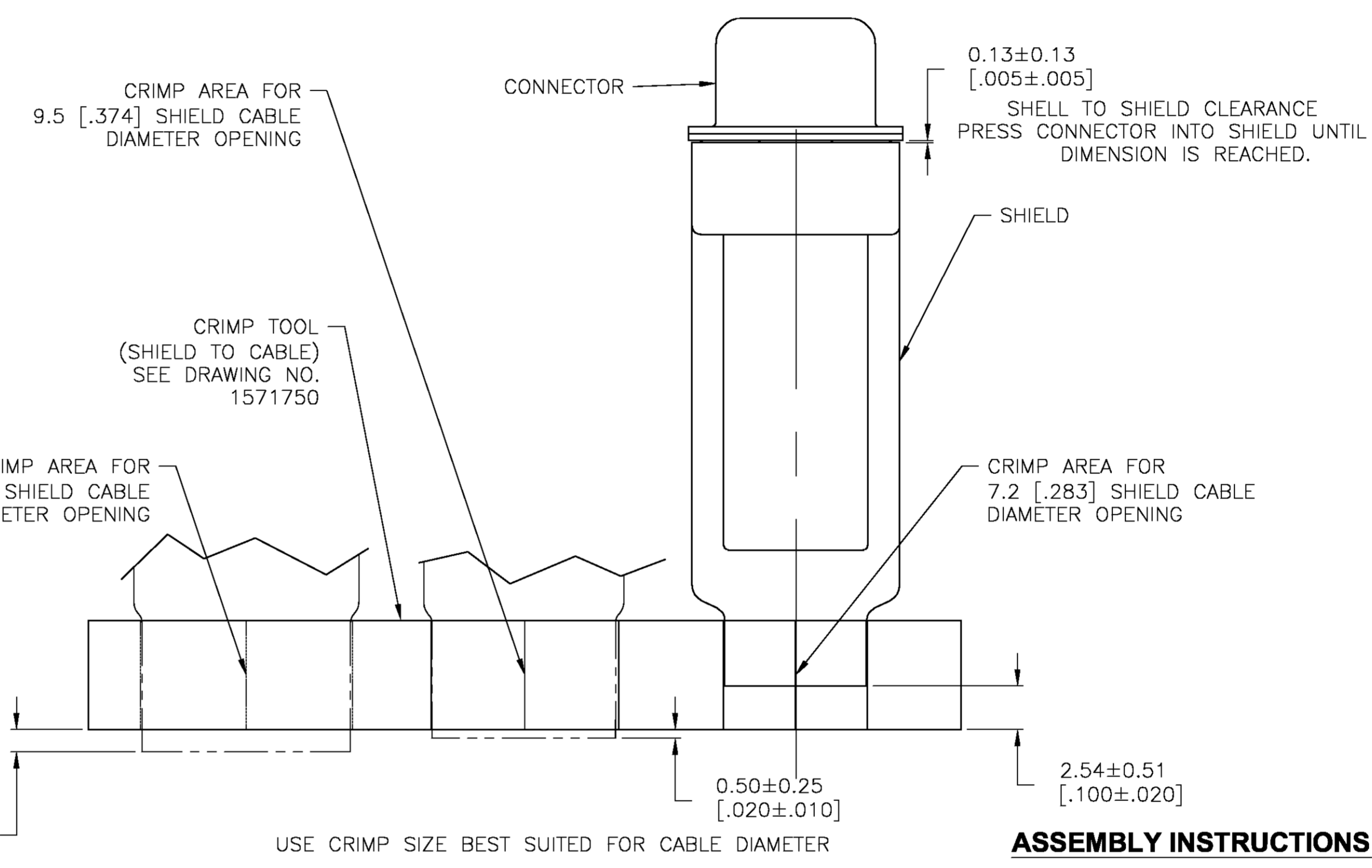
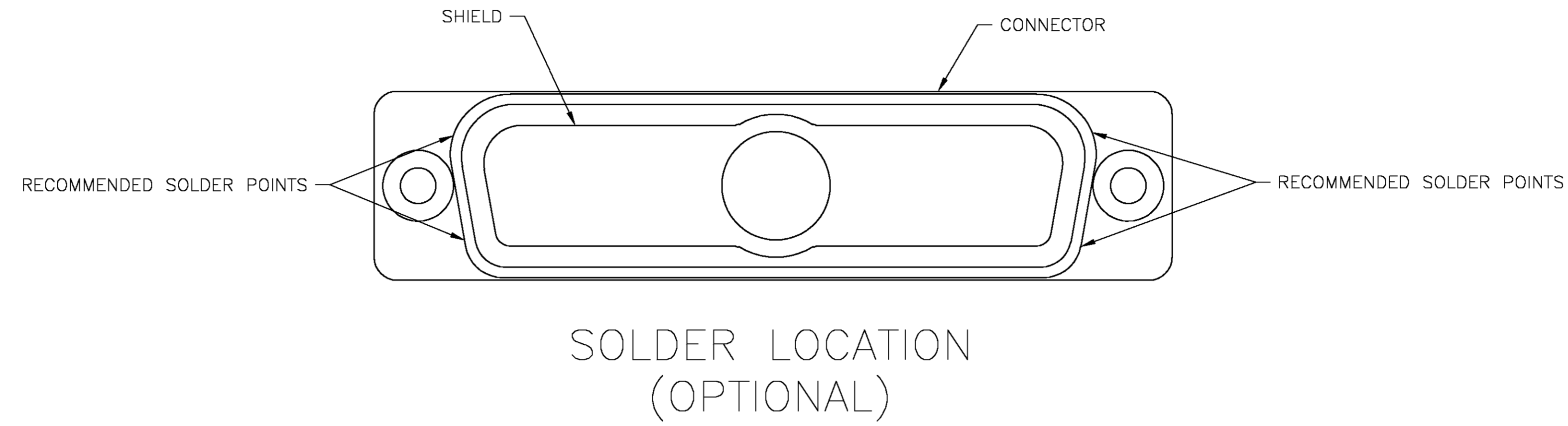
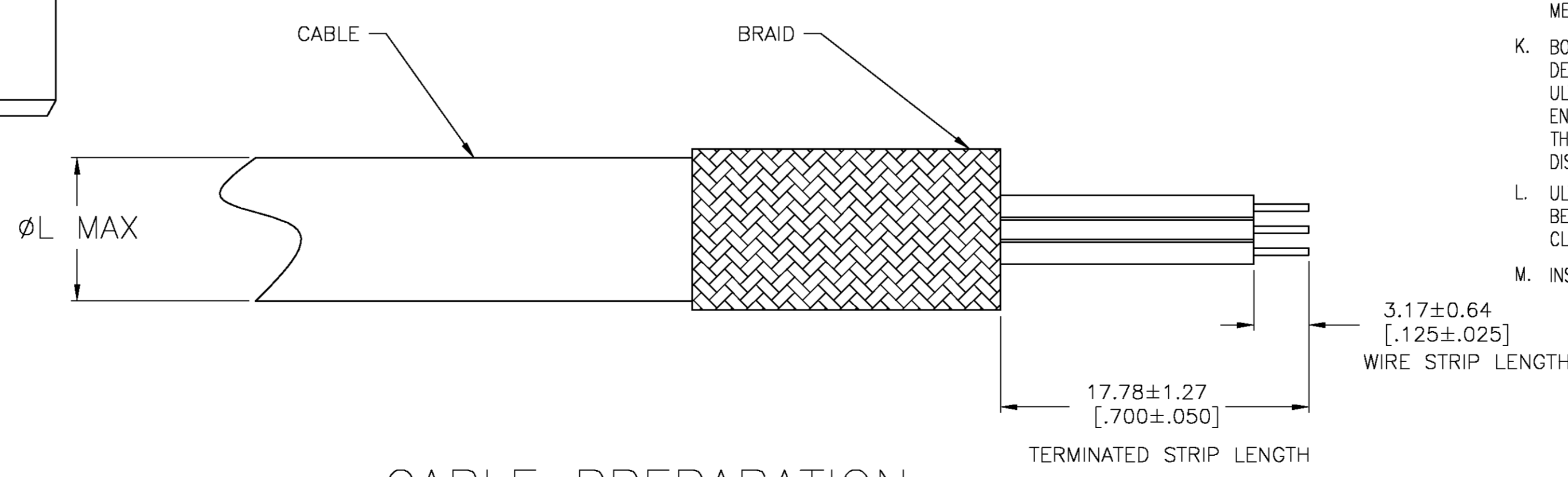


EXPLODED VIEW OF ASSEMBLED KIT



CABLE PREPARATION



- NOTES:
- MATERIAL
 INSERT: PBT, BLACK, UL94V-0 RATED
 CONTACT & JACKSCREWS: BRASS
 SHELLS & SHIELD: STEEL
 ENCLOSURE: PVC, BLACK
 - 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
 - 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.
 - 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[.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
 - 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 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 ACCROSS 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]	7	1571656-6
8	6	9.5 [.374]	7	1571656-5
8	6	7.2 [.283]	7	1571656-4
	2	10.8 [.425]		1571656-3
	2	9.5 [.374]		1571656-2
	2	7.2 [.283]		1571656-1
		FINISH	CABLE DIA L	PART NUMBER

THIS DRAWING IS A CONTROLLED DOCUMENT.		DIN M. BINNER 21NOV03	Tyco Electronics Corporation Harrisburg, Pa 17105-3508	
DIMENSIONS: mm [INCHES]	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD	NAME	BULK KIT, RECEPTACLE, AMPLIMIT SOLDER CUP SHIELDING ENCLOSURE 25 POSITION, SIZE 3
0 PLC ± -	1 PLC ± 0.3(.012)	PRODUCT SPEC	SIZE	108-40031
2 PLC ± -	3 PLC ± -	APPLICATION SPEC	SCALE	108-40031
4 PLC ± -	ANGLES ± -	WEIGHT	CAGE CODE	1571656
MATERIAL	FINISH	CUSTOMER DRAWING	SCALE	4:1
			SHEET	1 OF 1
			REV	D