

DO NOT SCALE FROM THIS PRINT

DESIGNED & DIMENSIONED IN MILLIMETERS [INCHES]

MCP-8-02-X-XX.XX-X-XX

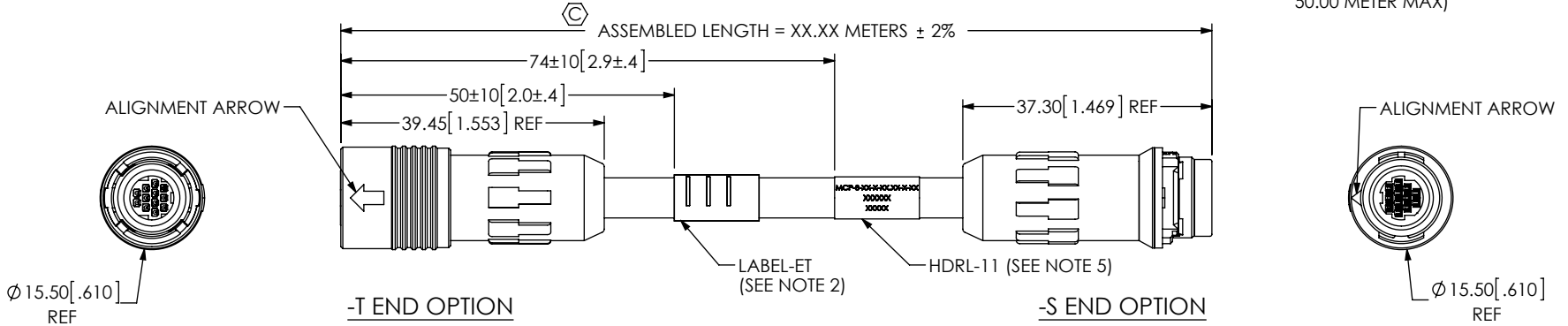
PLUG
SIZE
LEAD STYLE
-02: 12 POS, 28 AWG
PLATING SPECIFICATION
-L: 10µ" GOLD IN CONTACT AREA

END 2
-T: TERMINAL
-S: SOCKET
-BC: BLUNT CUT

END 1
-T: TERMINAL
-S: SOCKET (NOT AVAILABLE WITH END 2 -T)

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

FIG 1
MCP-8-02-X-XX.XX-T-S SHOWN



END OPTIONS

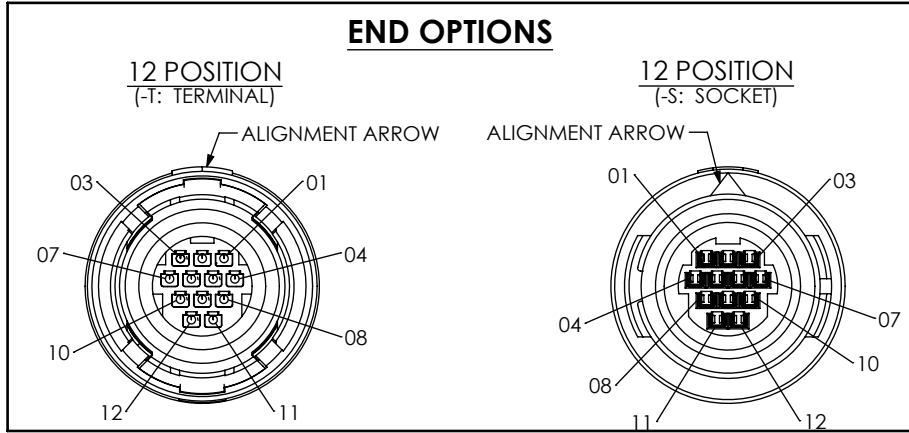
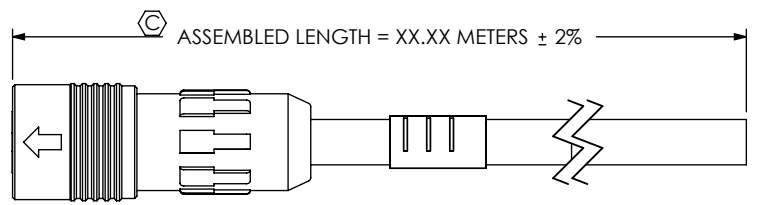


FIG 2
MCP-8-02-X-XX.XX-T-BC SHOWN
(BUILT DOUBLE ENDED INITIALLY FOR E-TEST)



NOTES:

1. Ⓢ 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. ASSEMBLIES TO BE BULK PACKAGED PER PACKAGING STANDARD CO-RF-WI-3001-M.
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 "MCP-8-XX-X-XX.XX-X-XX"
LINE 2 - SHOP ORDER NUMBER "XXXXXX"
LINE 3 - DATE CODE "XXXXX"
6. CONTACTS/TERMINALS MUST BE INSERTED UNTIL RETENTION FEATURE LOCKS INTO PLACE.
7. REFER TO CRIMP-SPECIFICATIONS PRINT FOR CRIMP AND STRIP DIMENSIONS, TOLERANCES, TOOLING, AND ITS REQUIREMENTS.
8. -T (TERMINAL): REFERENCE DC-MCP-8 PRINT FOR TERMINAL DUSTCAP
-S (SOCKET): REFERENCE DC-MCR-8 PRINT FOR SOCKET DUSTCAP
9. APPLY EPOXY-40 (LOCTITE 7649) TO THE THREADS AND ALLOW TO DRY FOR 60 SECONDS.
10. APPLY EPOXY-41 (LOCTITE 271) TO THE THREADS.
11. O-RING MUST BE SEATED AGAINST CH-P-30-8-12.

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN MILLIMETERS. TOLERANCES ARE:
DECIMALS ANGLES
X.X: ±0.3 [.01] 2°
X.XX: ±0.13 [.005]
X.XXX: ±0.051 [.0020]

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MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 1:1
INSULATORS, CABLE NUT, C-RING: PPS
TERMINALS & CONTACTS: PHOS BRONZE
GASKET, O-RING: SILICONE
SPRING: STAINLESS STEEL
COUPLING RING, SPACER: PBT
CABLE CLAMP: POM
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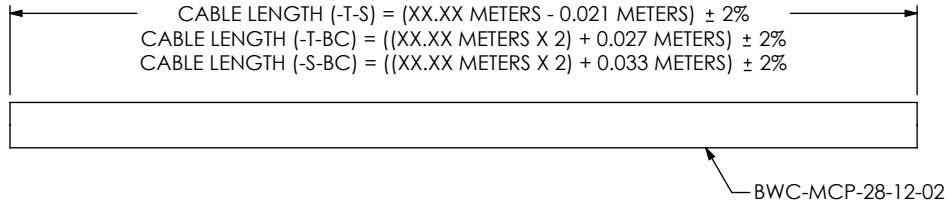
DESCRIPTION:
MINI CIRC. CABLE ASSEMBLY
DWG. NO.
MCP-8-02-X-XX.XX-X-XX
BY: J. BORGELT 2/15/13 SHEET 1 OF 3

REVISION A

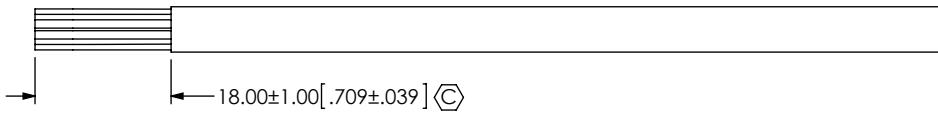
IN-PROCESS 1

CUT CABLE TO LENGTH SHOWN BASED ON END 1 & 2 GENDER
 (-BC FORMULA LENGTHS ADJUSTED TO INITIALLY BUILD CABLES DOUBLE ENDED)

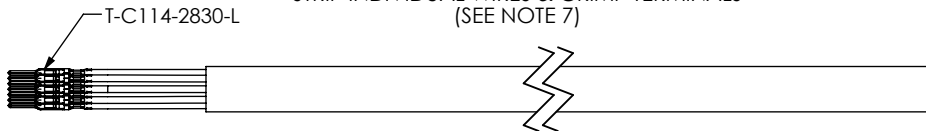
- ⊗ CABLE LENGTH (-T-T) = (XX.XX METERS - 0.02 METERS) ± 2%
- ⊗ CABLE LENGTH (-S-S) = (XX.XX METERS - 0.017 METERS) ± 2%
- ⊗ CABLE LENGTH (-T-S) = (XX.XX METERS - 0.021 METERS) ± 2%
- ⊗ CABLE LENGTH (-T-BC) = ((XX.XX METERS X 2) + 0.027 METERS) ± 2%
- ⊗ CABLE LENGTH (-S-BC) = ((XX.XX METERS X 2) + 0.033 METERS) ± 2%



IN-PROCESS 2
 STRIP OUTER JACKET

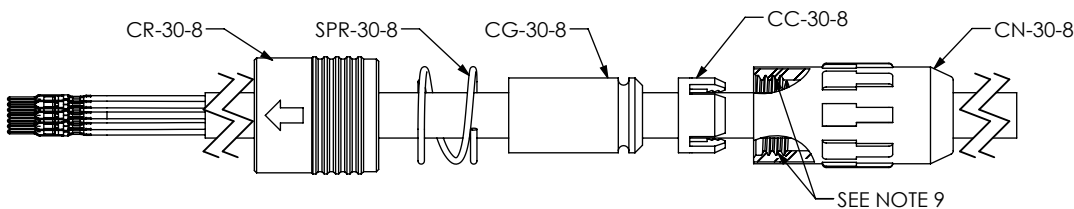


-T (TERMINAL): IN-PROCESS 3
 STRIP INDIVIDUAL WIRES & CRIMP TERMINALS
 (SEE NOTE 7)

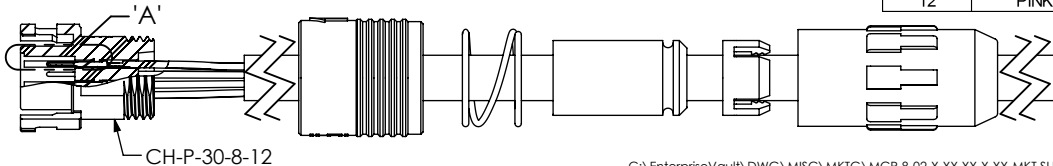
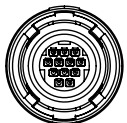
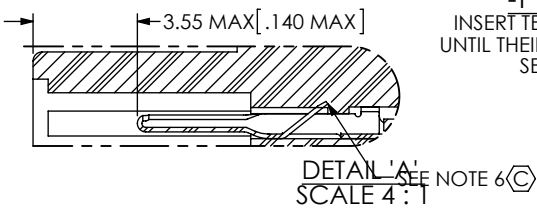


-T (TERMINAL): IN-PROCESS 4

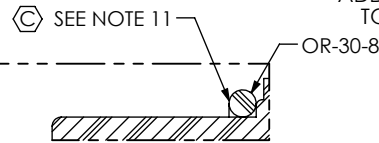
APPLY EPOXY-40 (LOCTITE 7649) TO THE INTERNAL THREADS OF CN-30-8 (SEE NOTE 9).
 THEN SLIDE COMPONENTS ONTO CABLE IN ORDER SHOWN



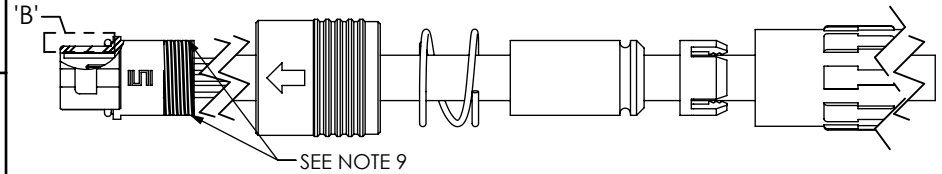
-T (TERMINAL): IN-PROCESS 5
 INSERT TERMINALS INTO CH-P-30-8-12 INSULATOR
 UNTIL THEIR RETENTION FEATURES LOCK INTO PLACE.
 SEE TABLE 1 FOR COLOR MAPPING.



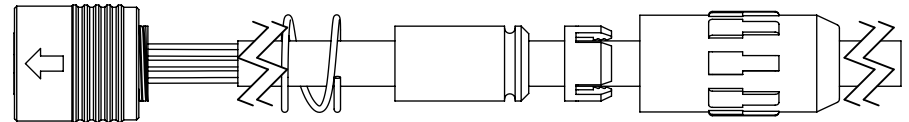
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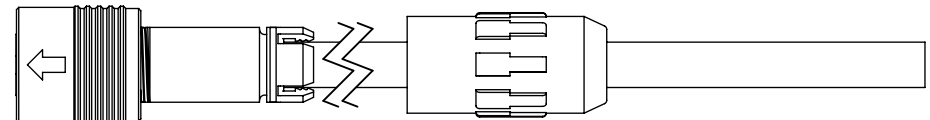
DETAIL 'B'
 SCALE 4:1



-T (TERMINAL): IN-PROCESS 7
 WHILE ALIGNING ORIENTATION FEATURES
 SLIDE CR-30-8 ONTO CH-P-30-8-12



-T (TERMINAL): IN-PROCESS 8
 SLIDE SPR-30-8 INTO CR-30-8.
 THEN SLIDE CG-30-8 UNTIL IT SEATS AGAINST THE BACK OF CH-P-30-8-12.
 THEN SLIDE CC-30-8 IN UNTIL IT SEATS AGAINST THE BACK OF CG-30-8.



-T (TERMINAL): IN-PROCESS 9
 APPLY EPOXY-41 (LOCTITE 271) TO THREADS OF CN-30-8 (SEE NOTE 10). THEN
 THREAD CN-30-8 ON TO THE CH-P-30-8-12 & TORQUE TO 0.5 Nm [4.4 IN-LBS].

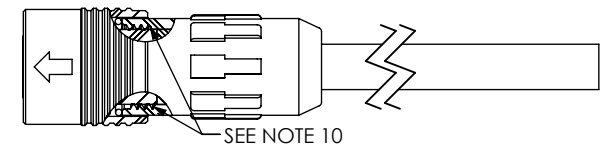


TABLE 1	
POSITION	COLOR
01	BROWN
02	RED
03	ORANGE
04	YELLOW
05	GREEN
06	BLUE
07	VIOLET
08	GRAY
09	WHITE
10	BLACK
11	LIGHT BLUE
12	PINK

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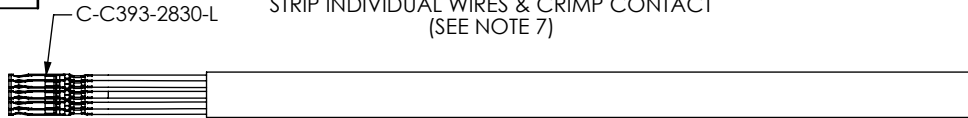
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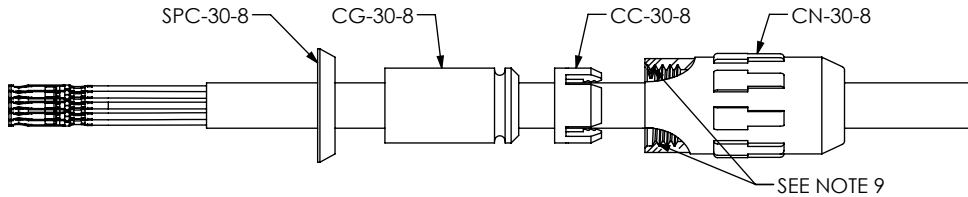
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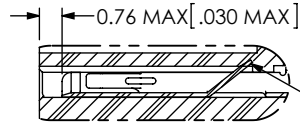
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STRIP INDIVIDUAL WIRES & CRIMP CONTACT
(SEE NOTE 7)



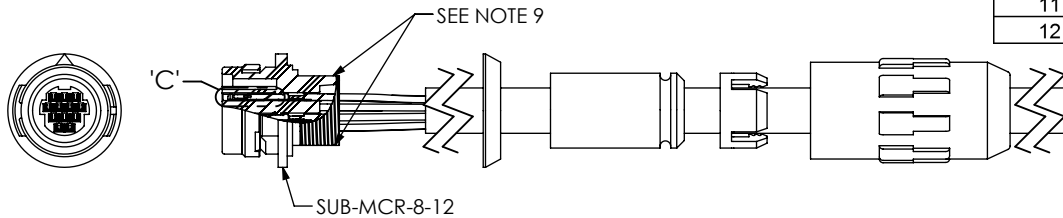
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SLIDE COMPONENTS ONTO CABLE IN ORDER SHOWN



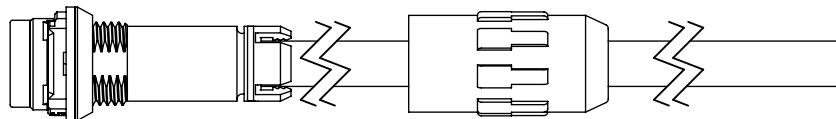
-S (SOCKET): IN-PROCESS 5
APPLY EPOXY-40 (LOCTITE 7649) TO THE THREADS OF SUB-MCR-8-12.
INSERT CONTACTS INTO SUB-MCR-8-12 INSULATOR
UNTIL THEIR RETENTION BEAMS ENGAGE.
SEE TABLE 2 FOR COLOR MAPPING.
(SEE NOTE 9)



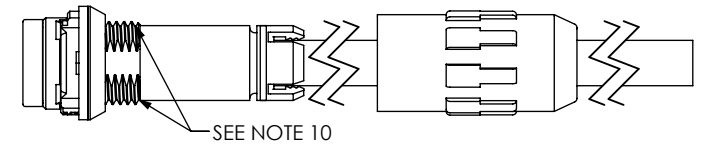
DETAIL 'C'
SCALE 4:1



-S (SOCKET): IN-PROCESS 6
SLIDE SPC-30-8 ONTO SUB-MCR-8-12.
THEN SLIDE CG-30-8 UNTIL IT SEATS AGAINST THE BACK OF SUB-MCR-8-12.
THEN SLIDE CC-30-8 UNTIL IT SEATS AGAINST THE BACK OF CG-30-8.



-S (SOCKET): IN-PROCESS 7
APPLY EPOXY-41 (LOCTITE 271)
TO THE THREADS OF SUB-MCR-8-12. (SEE NOTE 10)



-S (SOCKET): IN-PROCESS 8
THREAD CN-30-8 ON TO SUB-MCR-8-12 & TORQUE TO 0.5 Nm [4.4 IN-LBS].

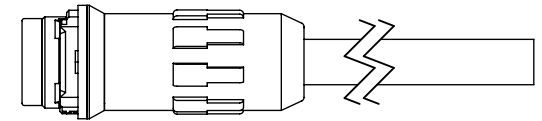


TABLE 2	
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