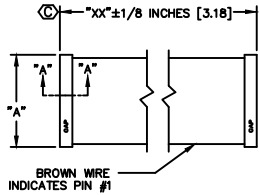
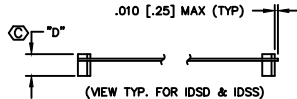


REVISION Y

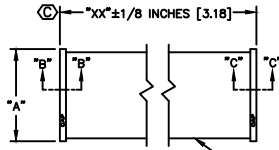
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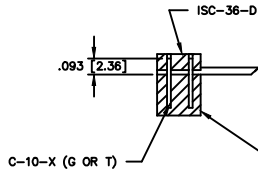
IDSS



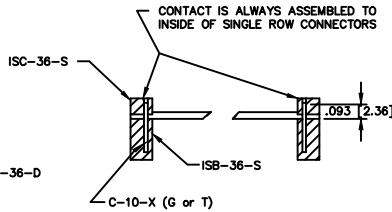
POSITION	D
2,3,4	.360 ± .005 [9.14 ± .05]
5 AND UP	.365 ± .005 [9.27 ± .05]



IDSS



SECT. A-A



SECT. B-B

SECT. C-C

DIMENSIONS ARE IN INCHES		UNLESS OTHERWISE NOTED		TOLERANCES ARE:	
ONE PLACE DECIMALS: ± .1 [3]	THREE PLACE DECIMALS: ± .005 [.13]	ANGLES	± 5'		
TWO PLACE DECIMALS: ± .01 [.3]	FOUR PLACE DECIMALS: ± .0020 [.051]				

TITLE: ASSEMBLY
 INSULATION DISPLACEMENT SOCKET CONNECTOR
 DWG NO: IDSX-XX-X-XX-XXX-XXX
 SHEET OF 2

IDSX-XX-X-XX.XX-XXX-XXX

ROW SPECIFICATION

-S: SINGLE ROW
 -D: DOUBLE ROW

NO. OF CONDUCTORS
 (-02 THRU -36 PER ROW)

USE CABLE: CB-XX-28-7/36-050-C (IDSD)
 USE CABLE: CB-XX-28-7/36-100-C (IDSS)
 IDSD FULL STRIP: "A"=3.650±.005 [92.71±.13] REF
 IDSS FULL STRIP: "A"=3.810±.005 [91.69±.13] REF
 CUT STRIP: "A"=3.88 [97.78] = ("XC" x .100 [2.54])+.059 [1.50]
 CUT STRIP: "A"=3.88 [97.78] = ("XC" x .100 [2.54])+.019 [.48]
 * NOTE: STANDARD COLOR-CODED CABLE N/A
 FOR DOUBLE ROW 31 THRU 36 POSITION -
 SEE -G OPTION.

END ASSEMBLY SPECIFICATIONS

-S: (SINGLE) ONE IDC ASSEMBLY
 -D: (DOUBLE) TWO IDC ASSEMBLIES

NOTES

- OPTION -SXX WHEN MATING DOUBLE ROW CONNECTOR WITH 2 SINGLE ROW CONNECTORS. THE OUTER MOST SINGLE WILL BE CONNECTED TO CONDUCTOR #1 AND THE INSIDE SINGLE TO CONDUCTOR #2.
- USING A #22 MICRO FINISHED .0025±.0005 [.64±.013] SQ POST, INSERTION / WITHDRAWAL FORCES TO BE:
 INSERTION: 4.0 OZ [114 GRAMS] AVG / 6.0 OZ [170 GRAMS] MAX
 WITHDRAWAL: 2.75 OZ [78.0 GRAMS] AVG / 2.0 OZ [57 GRAMS] MIN.
- MAX ALLOWABLE BOW AFTER ASSEMBLY TO BE .008 INCH/INCH [.20/MM].
- (C) REPRESENTS CRITICAL DIMENSION FOR STATISTICAL PROCESS CONTROL.
- A CHAMFER ON THE END OF THE CAP IS GUARANTEED ON FINAL ASSEMBLIES THAT ARE AT LEAST 18 POSITIONS FOR MALE AND FEMALE TERMINATION.
- ALL ASSEMBLIES TO BE 100% ELECTRICALLY TESTED FOR SHORTS AND OPENS.
- ALL ASSEMBLIES TO BE 100% HI-POT TESTED AT 1000V.
- WIRE: 28 AWG, 7/36, TINNED, STRANDED WITH PVC INSULATOR
- FOR IDSX WITH R OR RW OPTION, CABLE RIB ORIENTATION CAN BE EITHER TOWARDS OR AWAY FROM THE CAP.
- WHEN CUTTING CABLE TO LENGTH, CONDUCTORS SHOULD NOT EXTEND PAST THE CABLE INSULATION, EXTENDING LESS THAN 25% OF CABLE THICKNESS ON CONSECUTIVE AND LESS THAN 50% OF CABLE THICKNESS ON NON-CONSECUTIVE STRANDS IS CONSIDERED A PROCESS INDICATOR.

CONTACT IS ALWAYS ASSEMBLED TO INSIDE OF SINGLE ROW CONNECTORS
 RIBS OF GRAY CABLE GO TO CAP SIDE

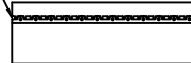


FIG 1
 (SEE NOTE 9)

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 CODE 95322

MADE BY: PURVIS 11-02-88
 IDSX-XX-X-XX-XXX-XXX
 SHEET 1 OF 2