REVISION E

DESIGNED & DIMENSIONED IN MILLIMETERS[INCHES]

MCR-8-02-X-XX.XX-X-XX

- RECEPTACLE
- SIZE
- LEAD STYLE
  - -02: 12 POS, 28 AWG
- PLATING SPECIFICATION
  - -L: 10µ" GOLD IN CONTACT AREA
- END 2 (SEE TABLE 1)
  - -BC: BLUNT CUT
  - -01: 2 x 6 SFSD (PIN 1 TO PIN 1)
- END 1
  - -S: SOCKET
- ASSEMBLED LENGTH
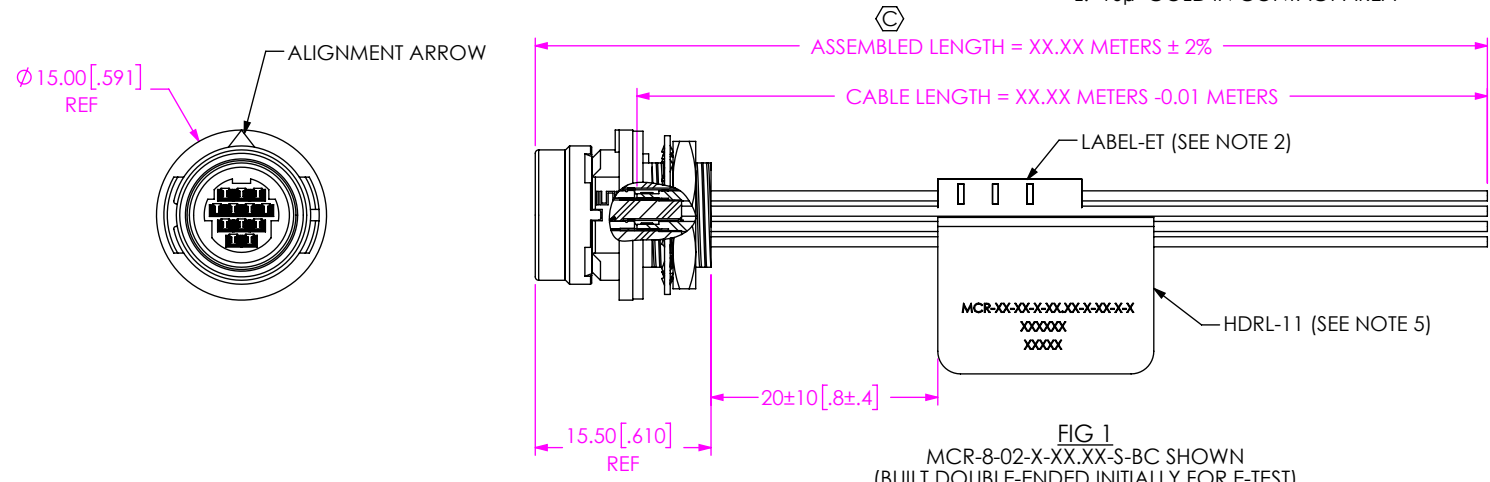 - XX.XX (IN METERS)
  - (0.10 METER MIN TO 50.00 METER MAX)

Ø15.00[.591] REF

ALIGNMENT ARROW

ASSEMBLED LENGTH = XX.XX METERS ± 2%

CABLE LENGTH = XX.XX METERS -0.01 METERS

LABEL-ET (SEE NOTE 2)

MCR-XX-XX-X-XX.XX-X-XX-X-X
XXXXXX
XXXXX

HDRL-11 (SEE NOTE 5)

20±10[.8±.4]

15.50[.610] REF

FIG 1
MCR-8-02-X-XX.XX-S-BC SHOWN
(BUILT DOUBLE-ENDED INITIALLY FOR E-TEST)

01

ASSEMBLED LENGTH = XX.XX METERS ± 2%

CABLE LENGTH = XX.XX METERS -0.01 METERS

8.00[.315] REF

6.35[.250] REF

11.18[.440] REF
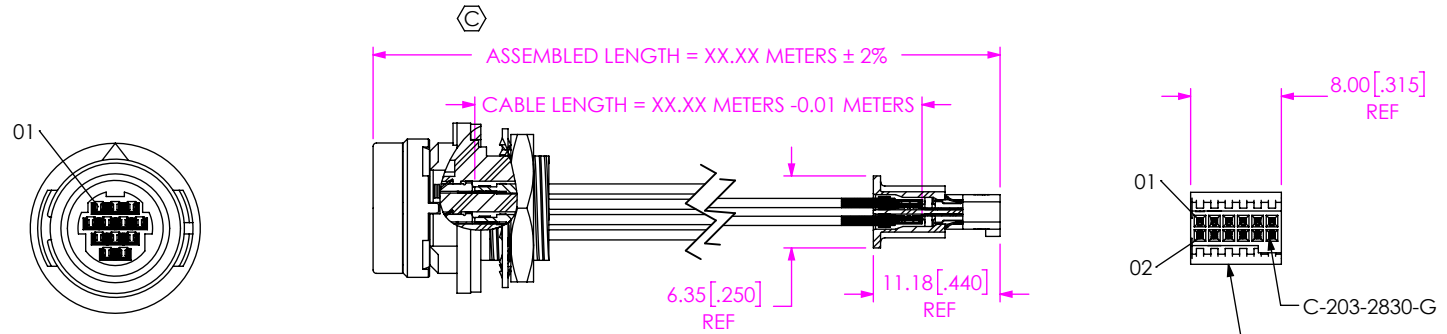
FIG 2
MCR-8-02-X-XX.XX-S-01 SHOWN
(PIN 1 TO PIN 1)
(DIFFERENT AS SHOWN, OTHERWISE SAME AS FIG 1)

01
02

C-203-2830-G

ISDF-06-D

END 1 OPTIONS

12 POSITION
(-S: SOCKET)

ALIGNMENT ARROW

01   03
04   07
08   10
11   12
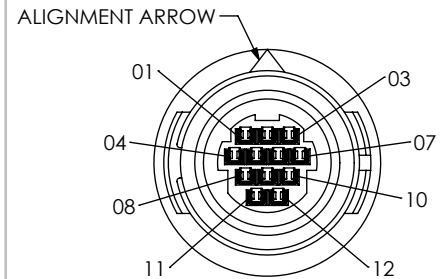
NOTES:

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 "MCR-8-XX-X-XX.XX-X-XX"
   LINE 2 - SHOP ORDER NUMBER "XXXXXX"
   LINE 3 - DATE CODE "XXXXX"
6. PANEL THICKNESS RANGE: 0.70[0.027] - 3.00[0.118].
7. WHEN MOUNTING PRODUCT TO PANEL TORQUE PN-30-8 TO 0.8 Nm[7.08 IN-LBS].
8. CONTACTS MUST BE INSERTED UNTIL RETENTION FEATURE LOCKS INTO PLACE.
9. REFER TO CRIMP-SPECIFICATIONS PRINT FOR CRIMP AND STRIP DIMENSIONS, TOLERANCES, TOOLING, AND ITS REQUIREMENTS.
10. -S (SOCKET): REFERENCE DC-MCR-8 PRINT FOR SOCKET DUSTCAP

MATERIAL:
DO NOT SCALE DRAWING
INSULATOR, C-RING: PPS
CONTACTS: PHOS BRONZE
GASKET: NEOPRENE RUBBER
LOCK WASHER: PHOS BRONZE, Ni PLATED
HEX NUT: BRASS, Ni PLATED

F:\DWG\MISC\MKTG\MCR-8-02-X-XX.XX-X-XX-MKT.SLDDRW

SHEET SCALE: 3:2

samtec
520 PARK EAST BLVD, NEW ALBANY, IN 47150
PHONE: 812-944-6733   FAX: 812-948-5047
e-Mail info@SAMTEC.com   code 55322

DESCRIPTION:
MINI CIRC. PANEL ASSEMBLY

DWG. NO.
MCR-8-02-X-XX.XX-X-XX

BY: J. BORGELT   4/11/2013   SHEET 1 OF 2

REVISION E

IN-PROCESS 1
CUT CABLE TO LENGTH SHOWN
(CABLE LENGTH FORMULA HAS ADDER
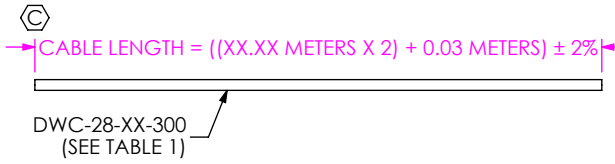FOR BUILDING CABLE DOUBLE ENDED)
(SEE NOTE 6)

Ⓒ

CABLE LENGTH = ((XX.XX METERS X 2) + 0.03 METERS) ± 2%

DWC-28-XX-300
(SEE TABLE 1)

TABLE 1

		-BC		-01	
POSITION	COLOR	DWC-XX-XX-XXX	COLOR	DWC-XX-XX-XXX	
01	BROWN	DWC-28-01-300	BLACK	DWC-28-10-300	
02	RED	DWC-28-02-300	BLACK	DWC-28-10-300	
03	ORANGE	DWC-28-03-300	BLACK	DWC-28-10-300	
04	YELLOW	DWC-28-04-300	BLACK	DWC-28-10-300	
05	GREEN	DWC-28-05-300	BLACK	DWC-28-10-300	
06	DARK BLUE	DWC-28-06-300	BLACK	DWC-28-10-300	
07	VIOLET	DWC-28-07-300	BLACK	DWC-28-10-300	
08	GRAY	DWC-28-08-300	BLACK	DWC-28-10-300	
09	WHITE	DWC-28-09-300	BLACK	DWC-28-10-300	
10	BLACK	DWC-28-10-300	BLACK	DWC-28-10-300	
11	GREEN/BLACK	DWC-28-11-300	BLACK	DWC-28-10-300	
12	TAN	DWC-28-12-300	BLACK	DWC-28-10-300	

IN-PROCESS 2
STRIP CONDUCTORS

SEE NOTE 9

IN-PROCESS 3
CRIMP CONTACTS
(SEE NOTE 9)
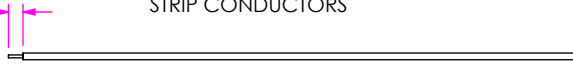
C-C393-2830-L

IN-PROCESS 4
SLIDE PG-30-8, LW-30-8, & PN-30-8 COMPONENTS ONTO WIRES
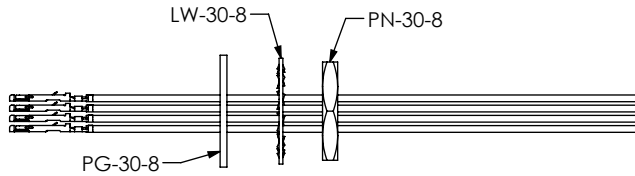
LW-30-8
PN-30-8
PG-30-8

IN-PROCESS 5
INSERT CONTACTS INTO SUB-MCR-8-12 INSULATOR
UNTIL THEIR RETENTION FEATURES LOCK INTO PLACE.

0.76 MAX [.030 MAX]

DETAIL 'B'
SEE NOTE 8
SCALE 4:1
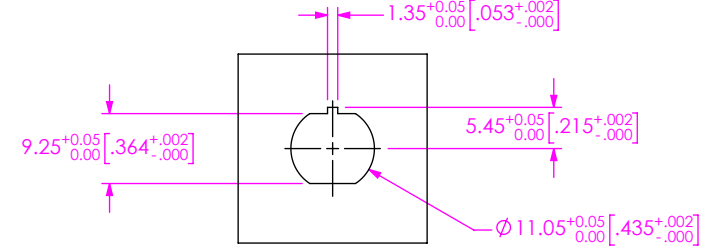
SUB-MCR-8-12
'B'
"A"
"A"

SECTION "A"-"A"
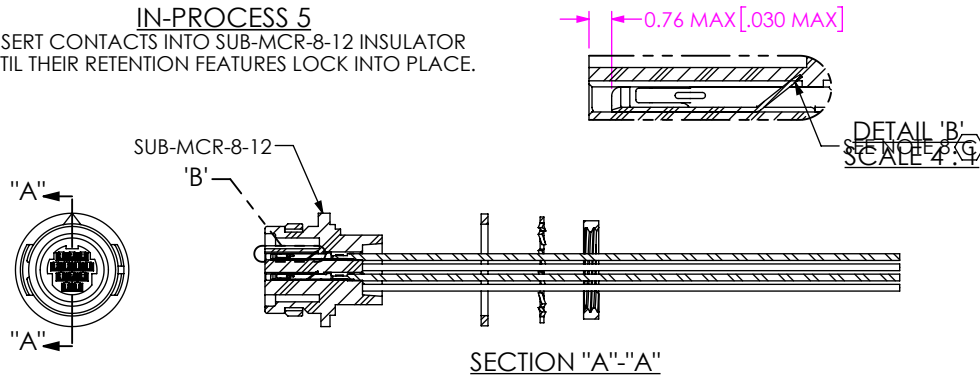
IN-PROCESS 6
SLIDE PG-30-8 FORWARD AND SEAT AGAINST FLANGE ON
SUB-MCR-8-12. SLIDE LW-30-8 FORWARD & LOOSELY THREAD
PN-30-8 ONTO SUB-MCR-8-12 TO HOLD ITEMS IN PLACE

IN-PROCESS 7
REPEAT STEPS 2-6 FOR END 2, E-TEST CABLE, APPLY
LABEL-ET & HDRL-11 TO BOTH ENDS, CUT CABLE IN
HALF & TRIM BOTH ENDS TO FINISHED LENGTH.

(XX.XX METERS X 2) + 0.05 METERS ± 2%

20±10 [.8±.4] (2 PLCS)

LABEL-ET (SEE NOTE 2)

HDRL-11 (SEE NOTE 5)

RECOMMENDED PANEL OPENING
(SEE NOTES 6 & 7)

$1.35^{+0.05}_{0.00}$ [$.053^{+.002}_{-.000}$]

$5.45^{+0.05}_{0.00}$ [$.215^{+.002}_{-.000}$]

$9.25^{+0.05}_{0.00}$ [$.364^{+.002}_{-.000}$]

$\varnothing 11.05^{+0.05}_{0.00}$ [$.435^{+.002}_{-.000}$]

DO NOT SCALE DRAWING

SHEET SCALE: 1:1

DESCRIPTION:
MINI CIRC. PANEL ASSEMBLY

DWG. NO.
MCR-8-02-X-XX.XX-X-XX

BY: J. BORGELT   4/11/2013   SHEET 2 OF 2

F:\DWG\MISC\MKTG\MCR-8-02-X-XX.XX-X-XX-MKT.SLDDRW