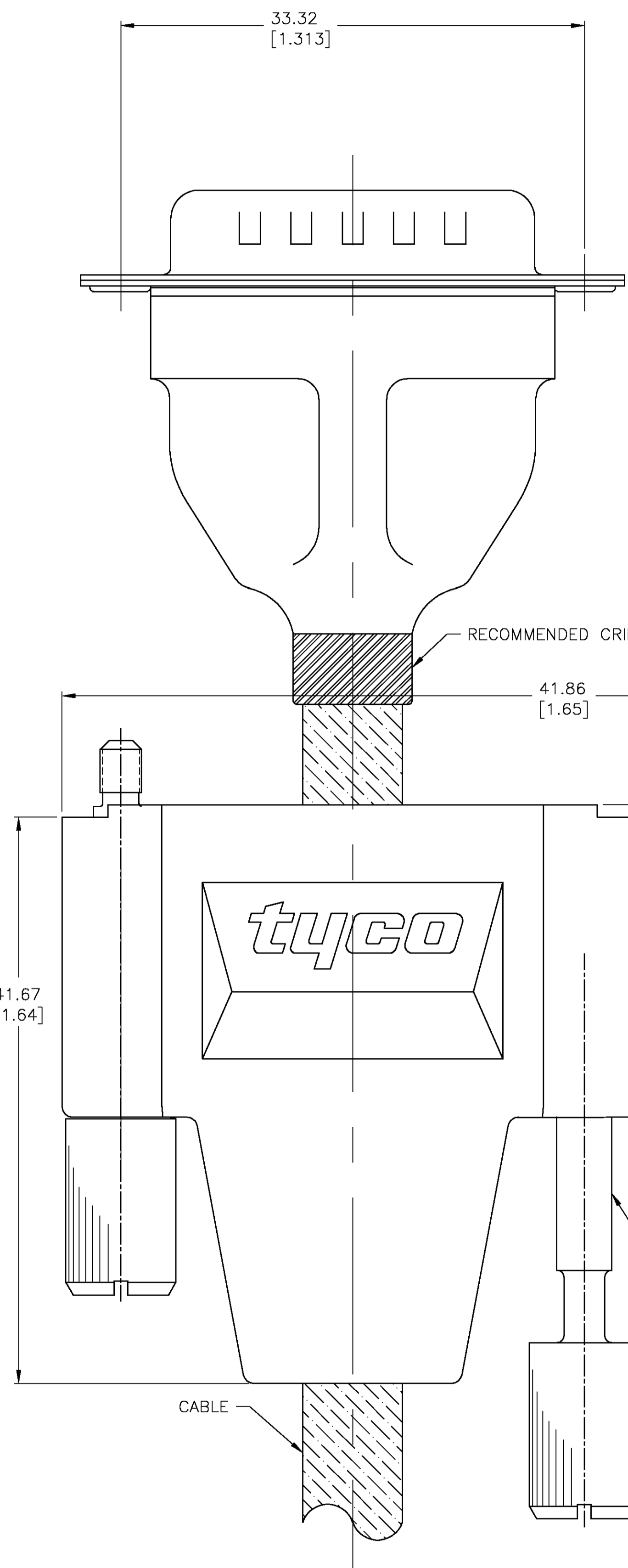
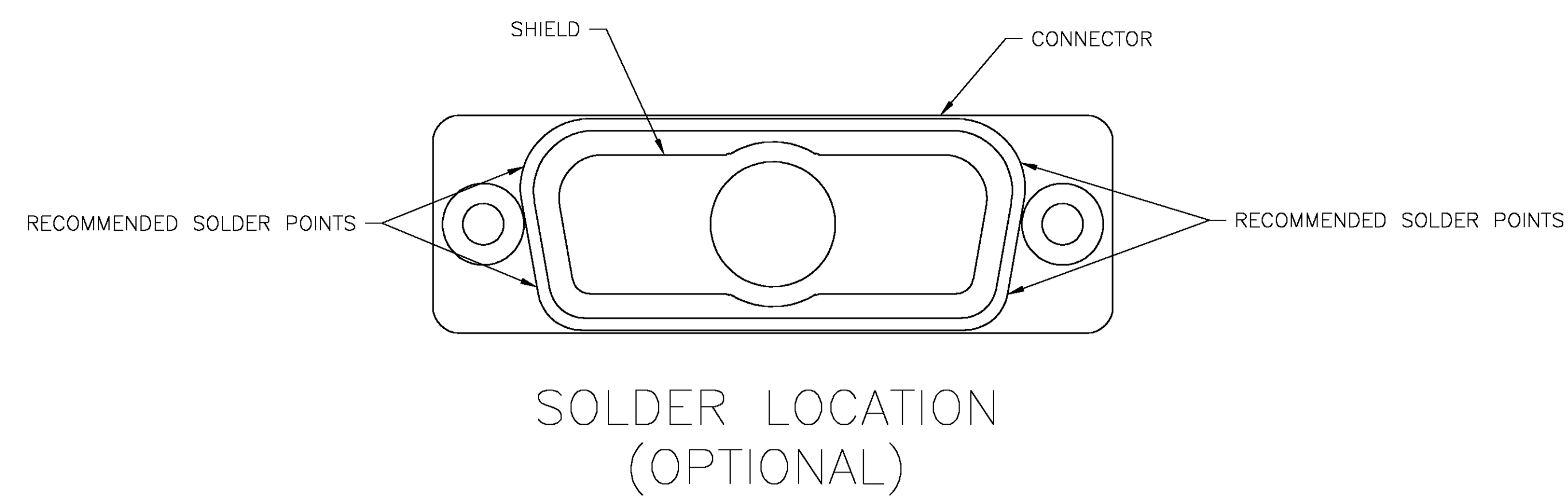


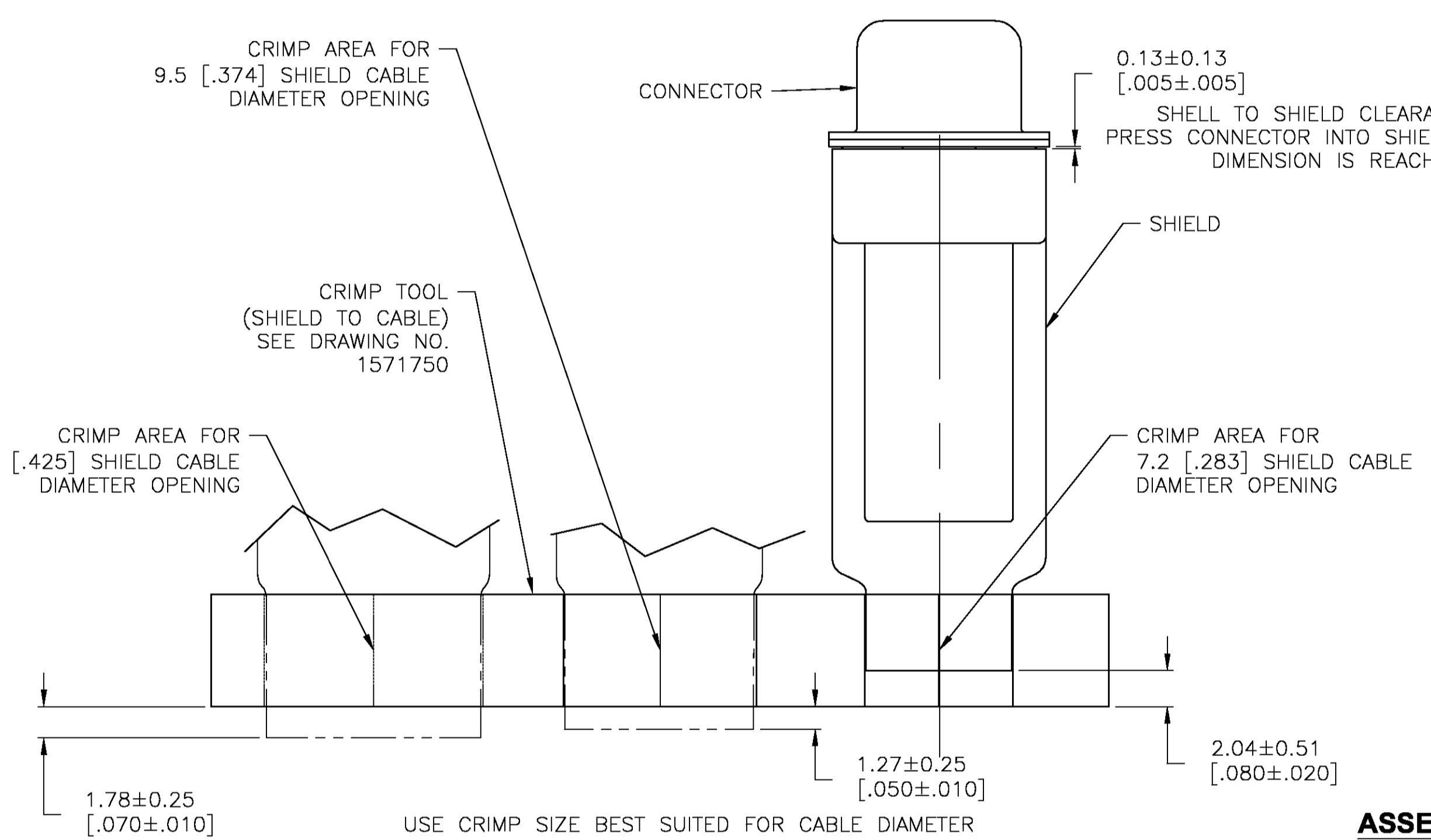
LOC		DIST		REVISIONS				
P	LR	DATE	BY	APPD	DESCRIPTION	DATE	BY	APPD
D	REV PER EC	0G3C-0606-04	19OCT04	MB	JO			



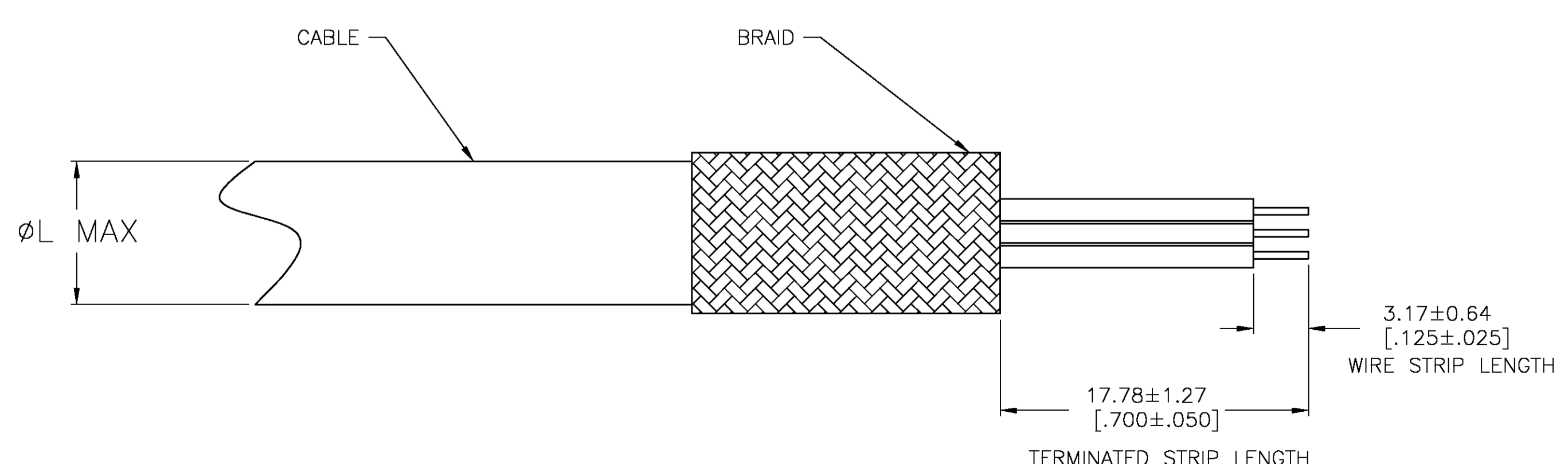
EXPLODED VIEW OF ASSEMBLED KIT



SOLDER LOCATION (OPTIONAL)



SHIELD TO CABLE CRIMP



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.
 - PLUG 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 19 TO 21mm 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.

FINISH	CABLE DIA L	PART NUMBER
△6	10.8 [0.425]	△7 1571651-6
△6	9.5 [0.374]	△7 1571651-5
△6	7.2 [0.283]	△7 1571651-4
△2	10.8 [0.425]	1571651-3
△2	9.5 [0.374]	1571651-2
△2	7.2 [0.283]	1571651-1

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: mm [INCHES]	TOLERANCES UNLESS OTHERWISE SPECIFIED:	0 PLC ±	1 PLC ± 0.3[0.012]	2 PLC ±	3 PLC ±	4 PLC ±	ANGLES ±
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MATERIAL	FINISH	WEIGHT	SCALE	SHEET	OF	REV
△1	△2		A1	4:1	1	1

THIS DRAWING IS A CONTROLLED DOCUMENT. DIM M. BINNER 21NOV03
 CHK - APVD - NAME -
 PRODUCT SPEC 108-40031
 APPLICATION SPEC -
 SIZE A1 00779 C=1571651
 CUSTOMER DRAWING SCALE 4:1 SHEET 1 OF 1 REV D

tyco Tyco Electronics Corporation
 Harriburg, Pa 17105-3608

BULK KIT, PLUG, AMPLIMITE
 SOLDER CUP SHIELDING ENCLOSURE
 15 POSITION, SIZE 2