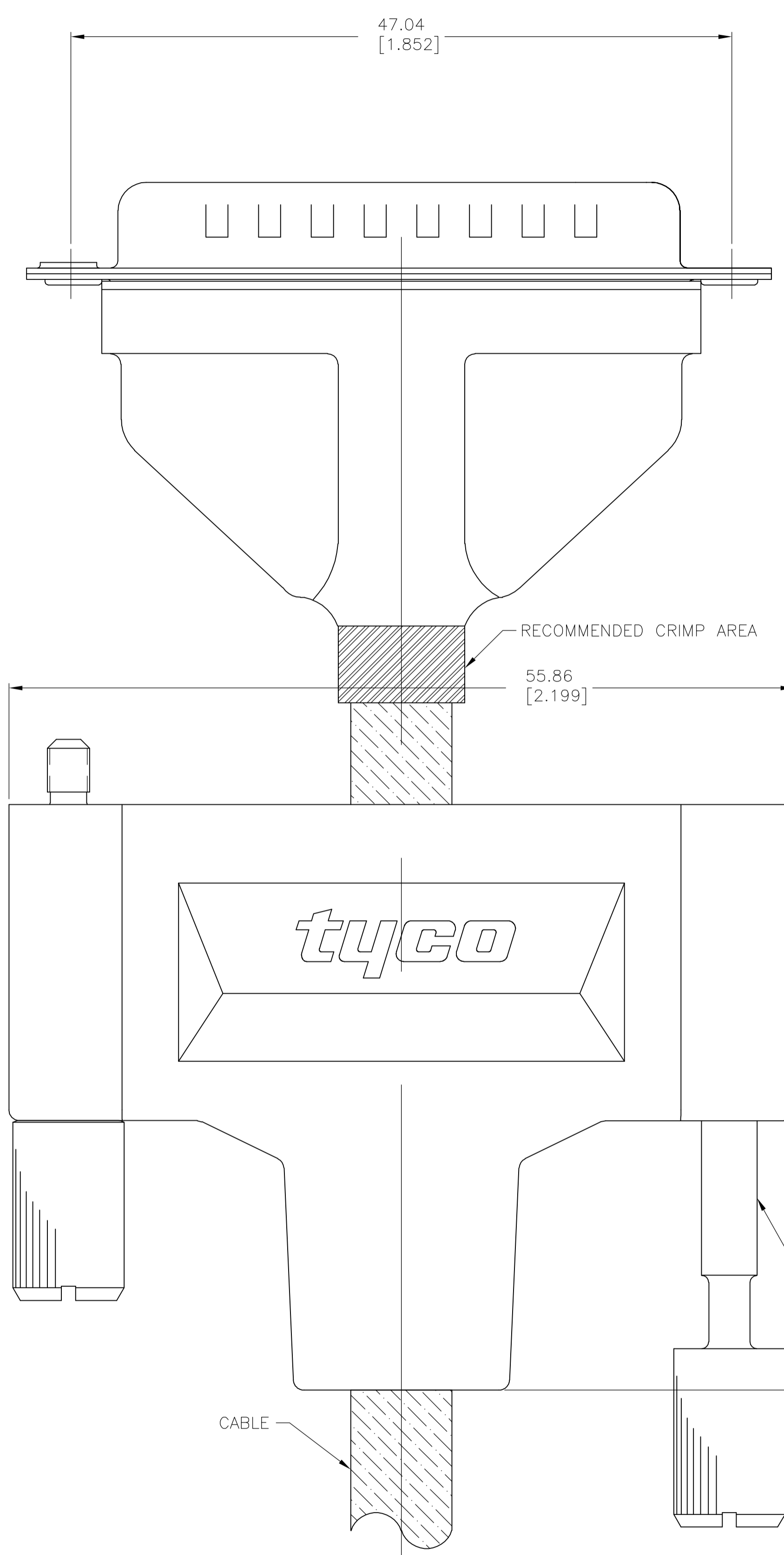
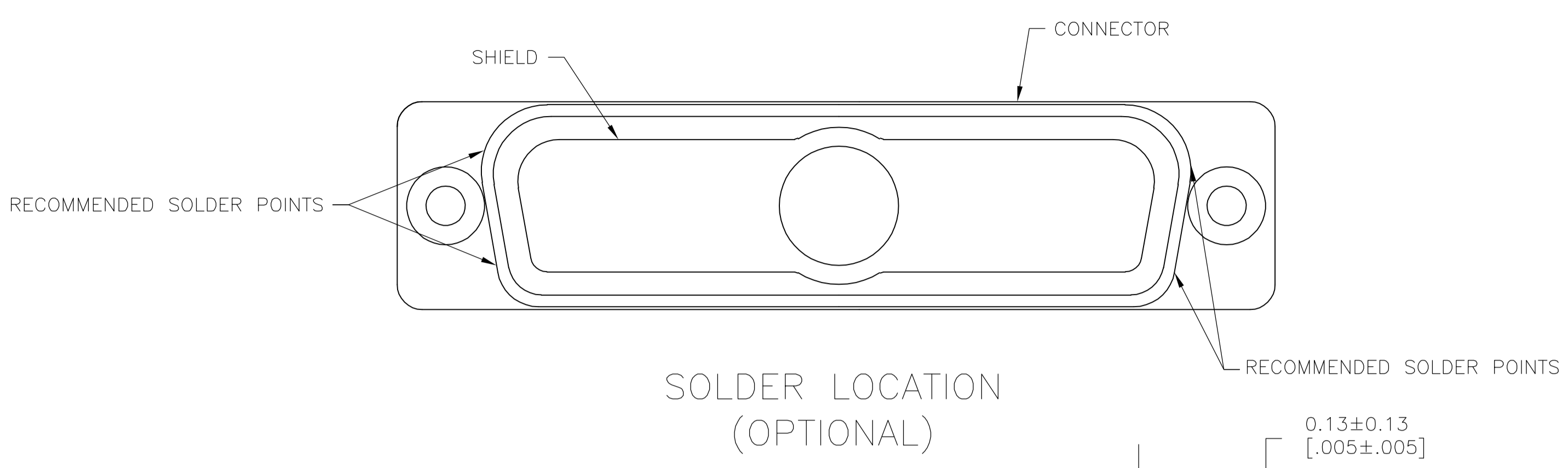


NON ROHS COMPLIANT VERSION

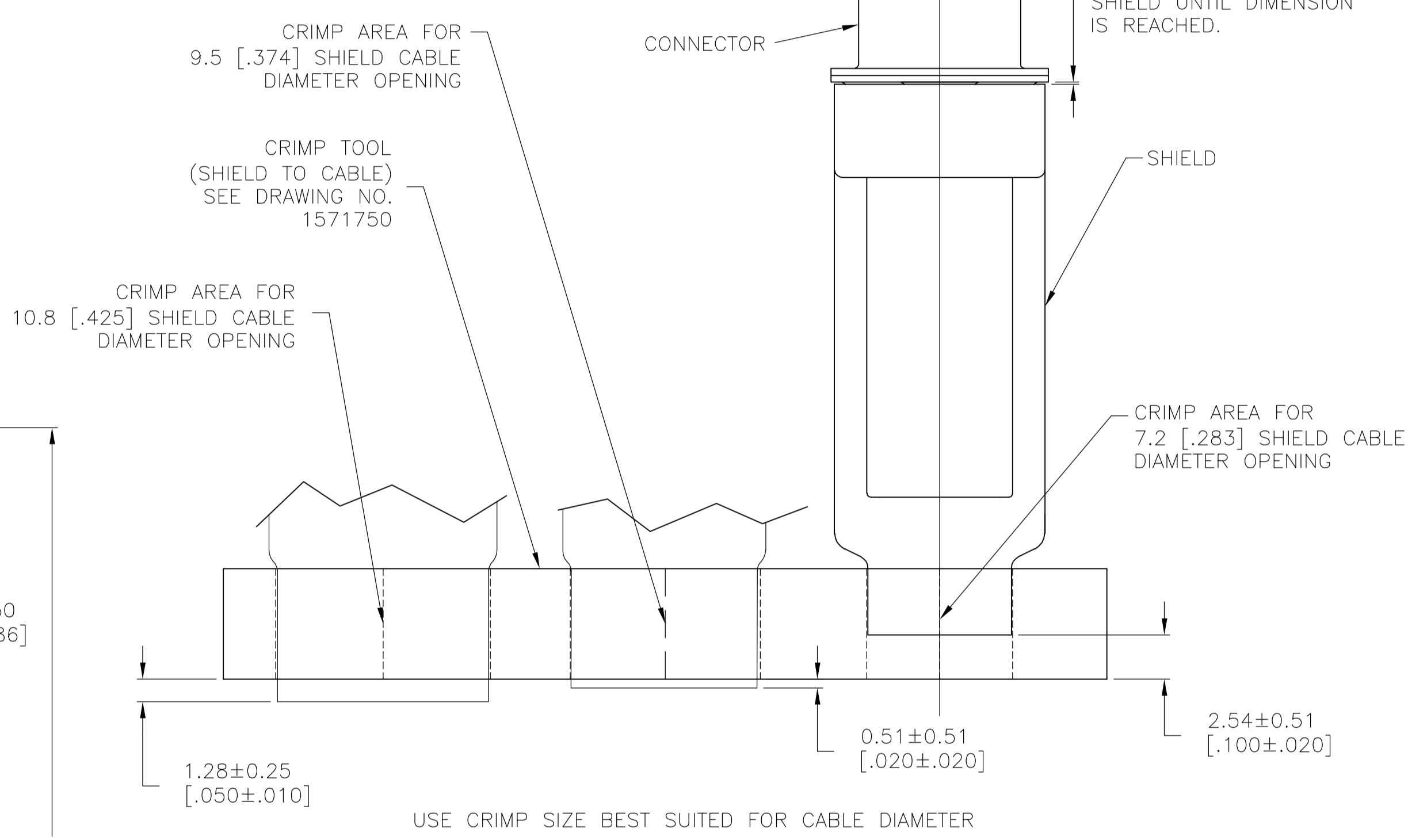
LOC		DIST		REVISIONS			
AD	00	REV	DATE	BY	APPV	DATE	BY
		D2	ECO-07-03605			15FEB07	MB JO



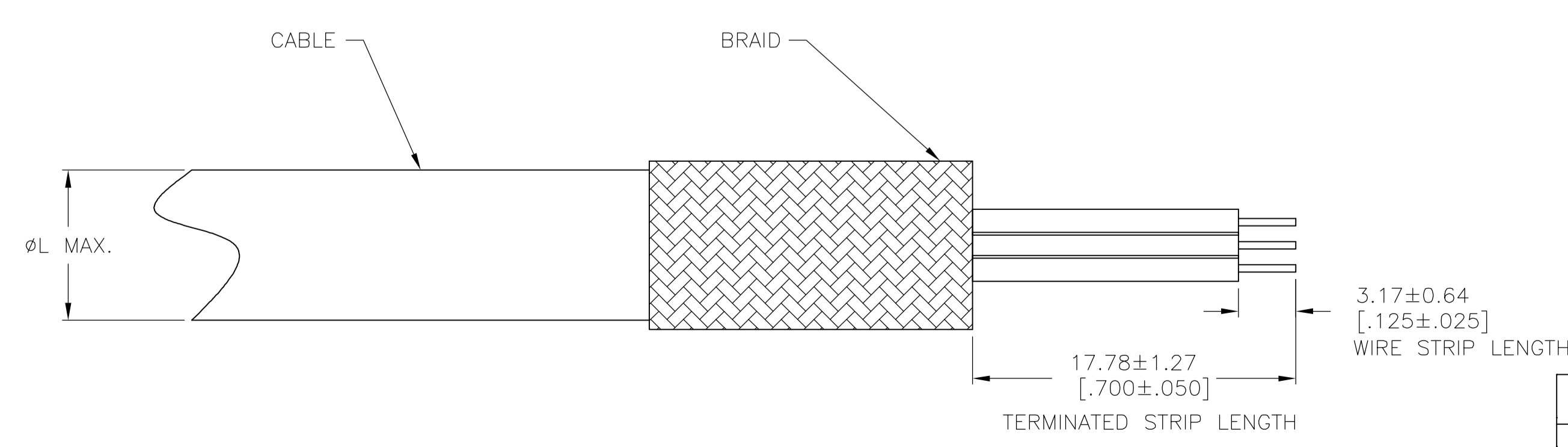
EXPLODED VIEW OF ASSEMBLED KIT



SOLDER LOCATION (OPTIONAL)



SHIELD TO CABLE CRIMP



CABLE PREPARATION

1. NOTES:  
 MATERIAL  
 INSERT: PBT, BLACK, UL94V-0 RATED  
 CONTACT & JACKSCREWS: BRASS  
 SHELLS & SHIELD: STEEL  
 ENCLOSURE: PVC, BLACK
2. 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.
3. SPECIFICATION:  
 ELECTRICAL CHARACTERISTICS:  
 CURRENT RATING: 3 AMPERES  
 DIELECTRIC WITHSTANDING VOLTAGE: AC 1000V r.m.s  
 INSULATION RESISTANCE: 5000 MEGAOHMS MINIMUM AT DC 500V  
 CONTACT RESISTANCE: 10 MILLIOHMS MAXIMUM.
4. PLUG CONNECTOR FULLY LOADED WITH CONTACTS. ALL OTHER PARTS ARE SHIPPED UNASSEMBLED, EACH PART INDIVIDUALLY BULK PACKED.
5. SOLDER CUP WILL ACCOMMODATE 20 MAX. AWG WIRE.
6. 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
8. ROHS 2002/95/EC COMPLIANT PART (SEE SHEET 2).

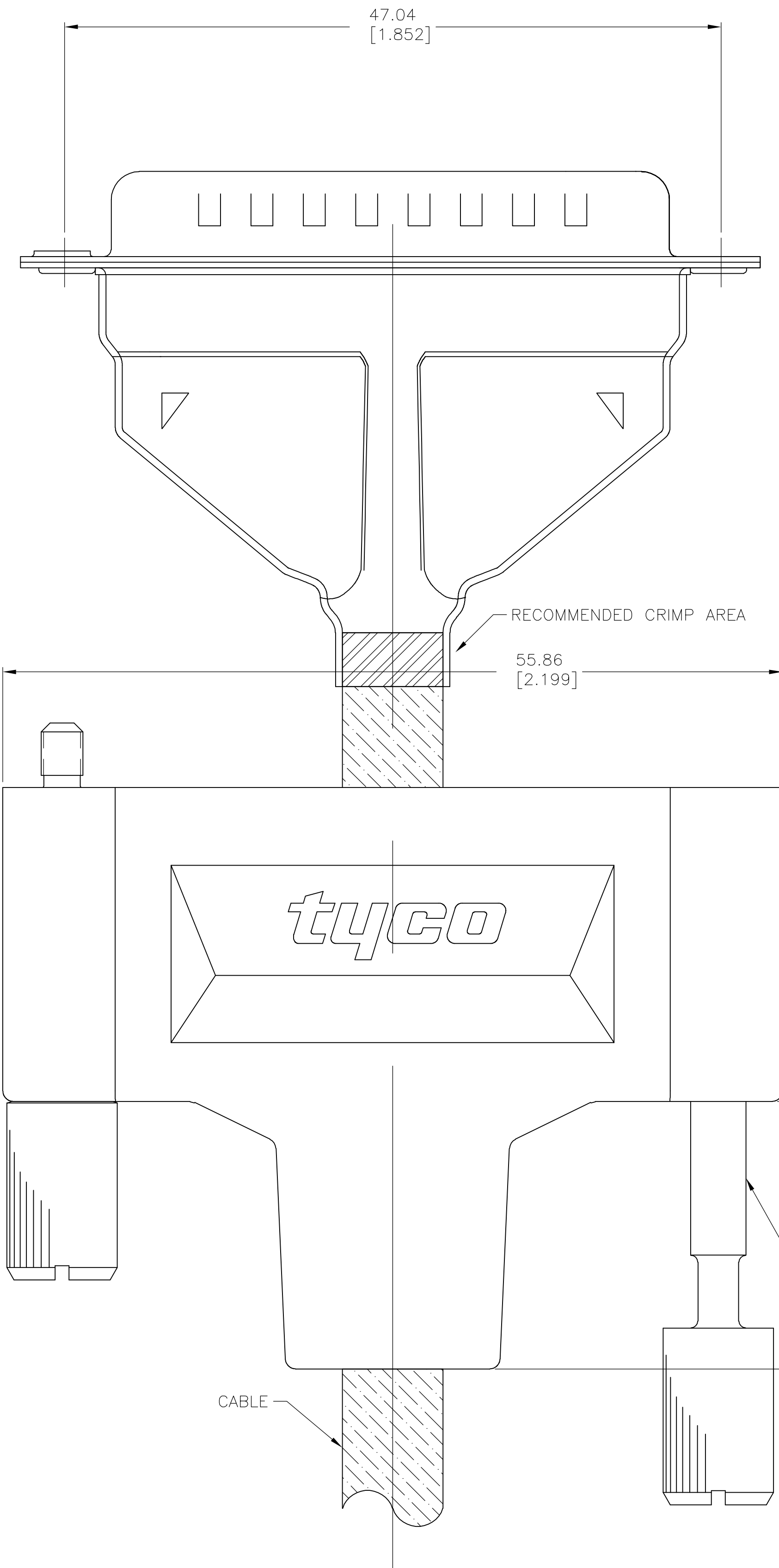
ASSEMBLY INSTRUCTIONS

- 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 ACROSS 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.

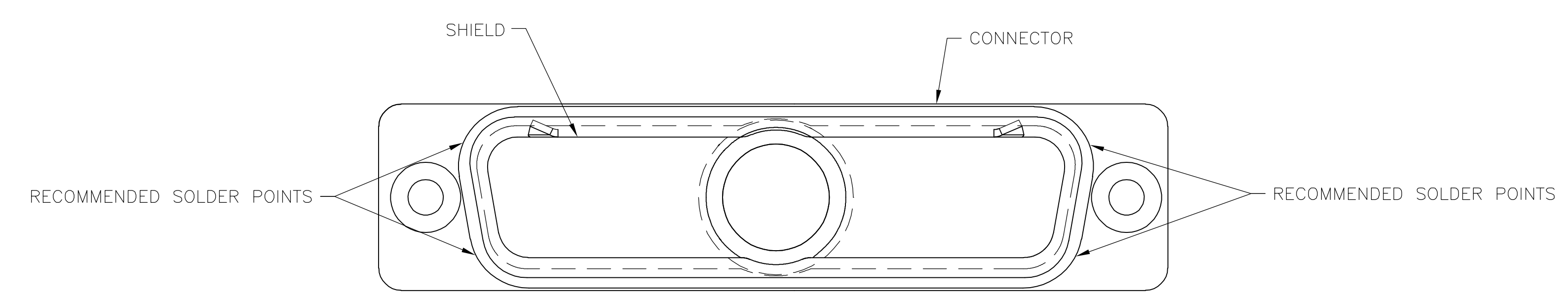
FINISH	CABLE DIA L	PART NUMBER
△8	△6 10.8 [.425]	1571652-6
△8	△6 9.5 [.374]	1571652-5
△8	△6 7.2 [.283]	1571652-4
SUPERSEDED BY 1571652-6	△2 10.8 [.425]	1571652-3
SUPERSEDED BY 1571652-5	△2 9.5 [.374]	1571652-2
SUPERSEDED BY 1571652-4	△2 7.2 [.283]	1571652-1

THIS DRAWING IS A CONTROLLED DOCUMENT.		DIN M. BINNER 21NOV03	<b>tyco</b> Tyco Electronics Corporation Harrisburg, Pa 17105-3608	
DIMENSIONS: mm [INCHES]	TOLERANCES UNLESS OTHERWISE SPECIFIED:	APVD	NAME	BULK KIT, PLUG, AMPLIMITE 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	WEIGHT	1571652
4 PLC ±	ANGLES ±	RESTRICTED TO	CUSTOMER DRAWING	SCALE 4:1 SHEET 1 OF 2 REV D2

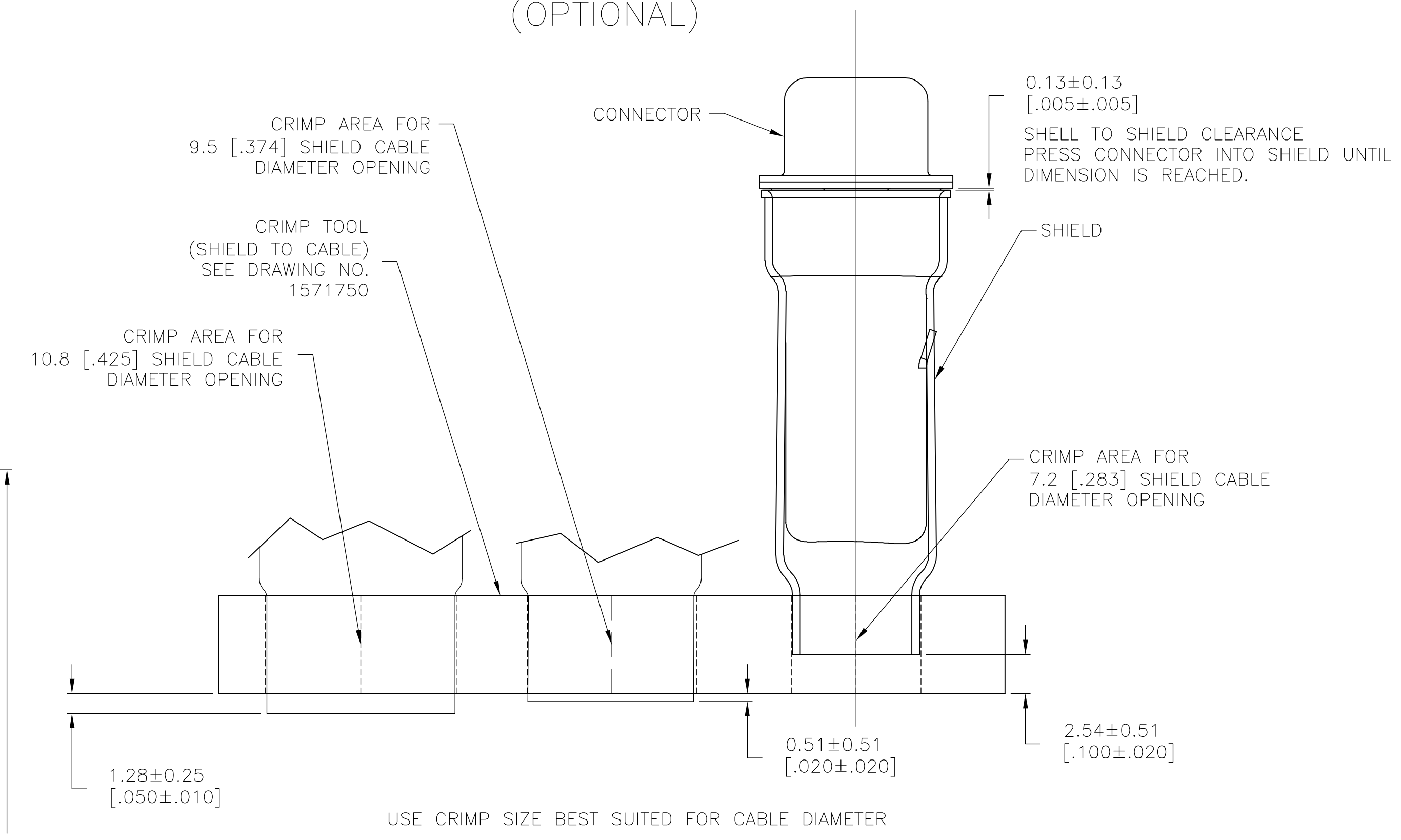
ROHS 2002/95/EC COMPLIANT VERSION



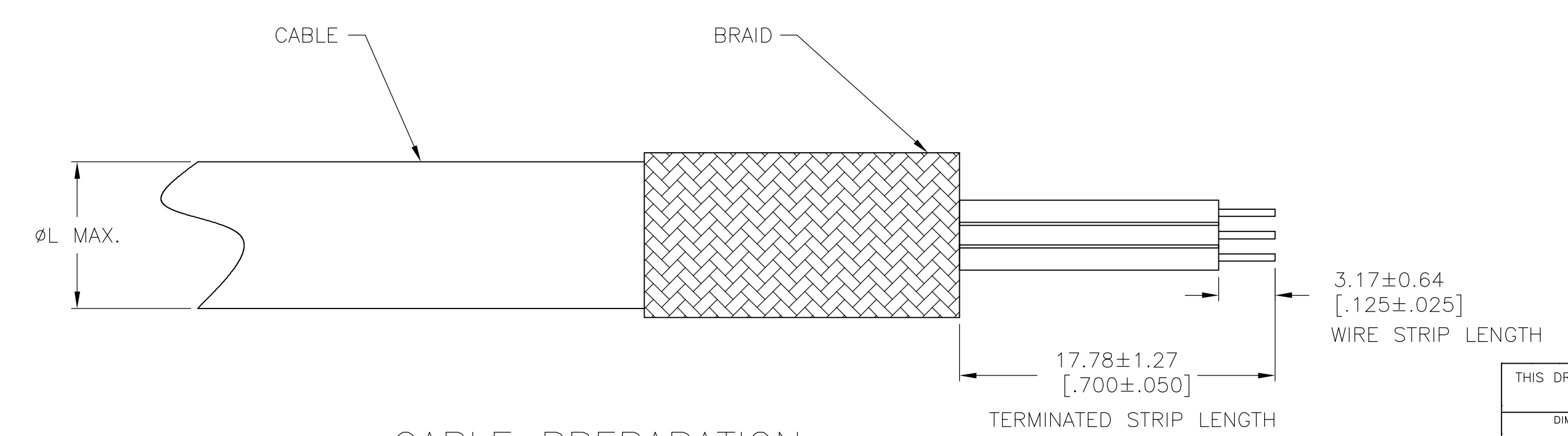
EXPLODED VIEW OF ASSEMBLED KIT



SOLDER LOCATION (OPTIONAL)



SHIELD TO CABLE CRIMP



CABLE PREPARATION

**ASSEMBLY INSTRUCTIONS**

- A. USE SHIELD ENCLOSURE EXPANSION TOOL, 58241-1 TO GET ENCLOSURE ON CABLE.
- B. PREPARE CABLE AS SHOWN.
- C. PLACE CABLE THROUGH SHIELD.
- D. SOLDER CONDUCTORS TO CONTACTS.
- E. PRESS SHIELD ONTO CONNECTOR AS SHOWN.
- F. SOLDER SHIELD TO CONNECTOR AS SHOWN (OPTIONAL).
- G. CRIMP SHIELD TO CABLE AS SHOWN IN CRIMP DETAIL
- H. PRESS ENCLOSURE OVER SHIELD UNTIL CONNECTOR FLANGE IS FLUSH WITH ENCLOSURE EDGE.
- I. INSERT JACKSCREWS.

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	M. BINNER	21NOV03	<b>tyco</b> Electronics	Tyco Electronics Corporation Harrisburg, Pa 17105-3608
DIMENSIONS: mm [INCHES]		CHK				NAME
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD			PRODUCT SPEC	108-40031
0 PLC	±				APPLICATION SPEC	
1 PLC	±	0.3[012]			SIZE	A1
2 PLC	±				CAGE CODE	00779
3 PLC	±				DRAWING NO	1571652
4 PLC	±				RESTRICTED TO	
ANGLES	±				WEIGHT	
FINISH	±				CUSTOMER DRAWING	