


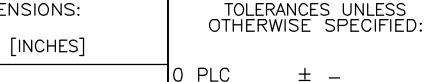
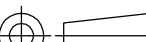
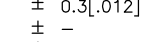
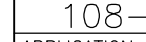
ASSEMBLY INSTRUCTIONS

- 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. METALLIC SHIELD SURFACES AND INTERIOR ENCLOSURE SURFACE MUST BE CLEAN AND DRY PER 3M REQUIREMENTS.
- H. CUT TWO PIECES OF 3M/SCOTCH VHB 4926, DOUBLE COATED ADHESIVE TAPE 6 TO 8mm WIDE BY 45 TO 52mm LONG.
- I. APPLY TAPE TO METALLIC SHIELD SURFACE. LENGTHWISE. ADJACENT TO CONNECTOR FLANGE.
- J. REMOVE ADHESIVE BACKING FROM TAPE AND PUSH ENCLOSURE OVER METALLIC SHIELD.
- K. 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.
- L. 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.
- M. INSERT JACK SCREWS.

SUPERSEDED BY 1571657-2	8	6	10.8 [.425]	1571657-2
		2	10.8 [.425]	1571657-1
	FINISH	CABLE DIA L	PART NUMBER	

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN M. BINNER	21NOV03	tyco Electronics		Tyco Electronics Corporation Harrisburg, Pa 17105-3608	
DIMENSIONS: mm [INCHES]		CHK -	-	NAME		BULK KIT, RECEPTACLE, AMPLIMITE SOLDER CUP SHIELDING ENCLOSURE 37 POSITION, SIZE 4	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD -	-	PRODUCT SPEC		108-40031	
0 PLC ± -		APPLICATION SPEC		SIZE		DRAWING NO	
1 PLC ± 0.3[.012]		WEIGHT		A1		00779	
2 PLC ± -		CUSTOMER DRAWING		SCALE		4:1	
3 PLC ± -		SHEET		1		OF 2	
4 PLC ± -		REV		D2			
ANGLES ± -							
FINISH							

ROHS 2002/95/EC COMPLIANT VERSION

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWG M. RINNER CHK — APVD — NAME		 Tyco Electronics Corporation Harrisburg, Pa 17105-3608	
DIMENSIONS: mm [INCHES]		TOLERANCES UNLESS OTHERWISE SPECIFIED:		PRODUCT SPEC 108-40031 APPLICATION SPEC —	
		0 PLC ± — 1 PLC ± 0.3 [0.12] 2 PLC ± — 3 PLC ± — 4 PLC ± — ANGLES ± — FINISH		BULK KIT, RECEPTACLE, AMPLIMITE SOLDER CUP SHIELDING ENCLOSURE 37 POSITION, SIZE 4	
MATERIAL 		WEIGHT —		SIZE A1	
				CAGE CODE 00779	
				DRAWING NO C-1571657	
CUSTOMER DRAWING				RESTRICTED TO —	
				SCALE 4:1	
				SHEET 2 OF 2	
				REV D2	