

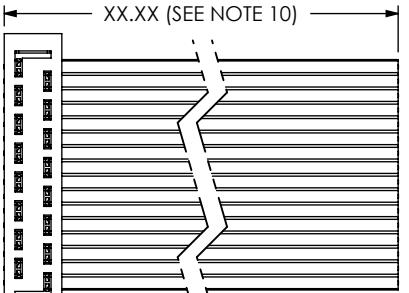
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FIG 2
HCSD-08-S-XX.XX-01 SHOWN
(DIFFERENT AS SHOWN, OTHERWISE SAME AS FIG1)

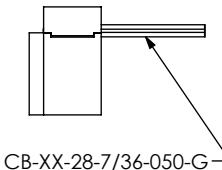


FIG 3
-G: GRAY CABLE
(DIFFERENT AS SHOWN, OTHERWISE
SAME AS FIG1)

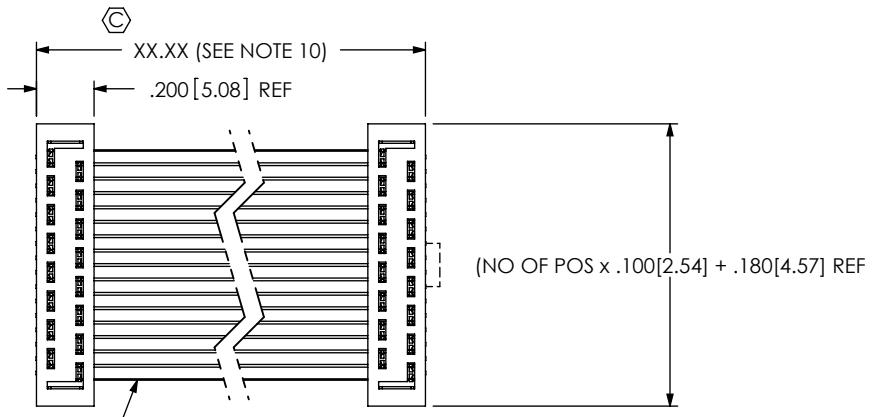


FIG 1
HCSD-08-D-XX.XX-01 SHOWN

NOTES:

- ① REPRESENTS A CRITICAL DIMENSION.
- HIDDEN LINES ARE USED TO SHOW POLARIZATION WHEN USING -N OPTION.
- ALL ASSEMBLIES TO BE 100% ELECTRICALLY TESTED FOR SHORTS AND OPENS
- ALL ASSEMBLIES TO BE 100% HI-POT TESTED AT 1000V.
- HCSD-XX-01-X TO BE PRESSED TOGETHER WITH NO GAPS BETWEEN CABLE & BODIES.
- CONDUCTORS SHALL BE CONSISTENT IN APPEARANCE, SOLDER MUST MAINTAIN CABLE STRANDS WITHIN THE MAX DIA. TOLERANCE.
- NOTE DELETED.
- FOR 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 THE CABLE THICKNESS ON NON-CONSECUTIVE STRANDS IS CONSIDERED A PROCESS INDICATOR.
- FOR LENGTHS LESS THAN 12.5", TOLERANCE SHALL BE $\pm .125$ [3.18], ALL OTHER LENGTHS SHALL BE $\pm 1\%$.

HCSD-XX-X-XX.XX-01-XXX-XXX

No of Positions
-02 THRU -36
(STANDARD COLOR
CODED CABLE)
(-32 & -36 ONLY AVAILABLE
WITH -G OPTION)

OPTION #2
(SEE FIG 3 THRU FIG 19
FOR AVAILABLE OPTIONS)
OPTION #1
(SEE FIG 3 THRU FIG 19 FOR
AVAILABLE OPTIONS)
LEAD STYLE

END ASSEMBLY
-S: SINGLE END
-D: DOUBLE END

ASSEMBLY LENGTH
(2 INCH MINIMUM)

-T: BRIGHT ACID TIN ON ENTIRE PIN
(USE HCSD-XX-01-TX)
LEAVE BLANK FOR 10u" SELECTIVE GOLD IN
CONTACT AREA, BRIGHT ACID TIN ON TAIL.

FIG 4
-T: TIN PLATING

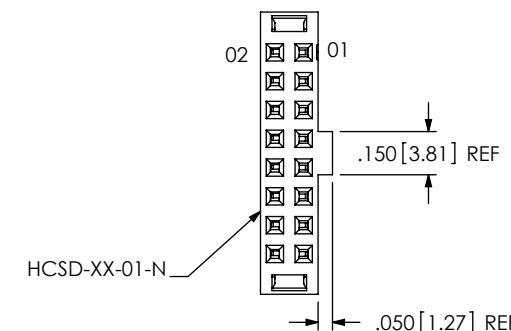


FIG 5
-N: NOTCH
(NOT AVAILABLE ON -02 POSITION)
(DIFFERENT AS SHOWN, OTHERWISE
SAME AS FIG1)

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE: DECIMALS ANGLES .XX: $\pm .01$ [.3] .XXX: $\pm .005$ [.13] .XXXX: $\pm .0020$ [.051]	* PROPRIETARY NOTE THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION AND ALL DESIGN, MANUFACTURING, REPRODUCTION, USE, PATENT RIGHTS AND SALES RIGHTS ARE EXPRESSLY RESERVED BY SAMTEC, INC. IN THIS DOCUMENT SHALL NOT BE DISCLOSED, IN WHOLE OR PART, TO ANY UNAUTHORIZED PERSON OR ENTITY NOR REPRODUCED, TRANSFERRED OR INCORPORATED IN ANY OTHER PROJECT IN ANY MANNER WITHOUT THE EXPRESS WRITTEN CONSENT OF SAMTEC, INC.	DO NOT SCALE DRAWING INSULATOR: LCP, UL 94 VO, COLOR: BLACK CONTACT: PHOS BRONZE CABLE: COLOR-CODED OR GRAY PVC/TIN PLATED COPPER	DESCRIPTION: .100 CL MOLD TO POS DOUBLE ROW FEMALE ASSEMBLY DWG. NO. HCSD-XX-X-XX.XX-01-XXX-XXX BY: KOLB 08/03/1990 SHEET 1 OF 4

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REVISION AB

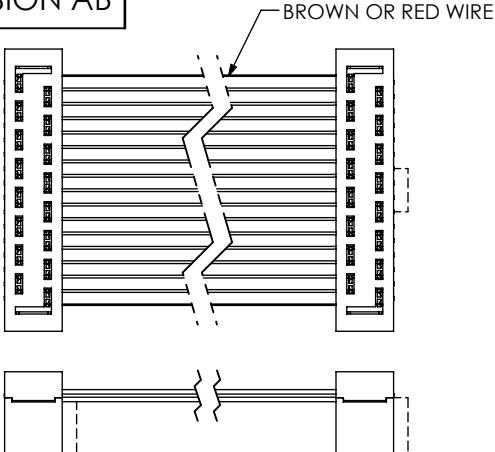


FIG 6

-RW: REVERSE WIRING
(DIFFERENT AS SHOWN, OTHERWISE SAME AS FIG1)

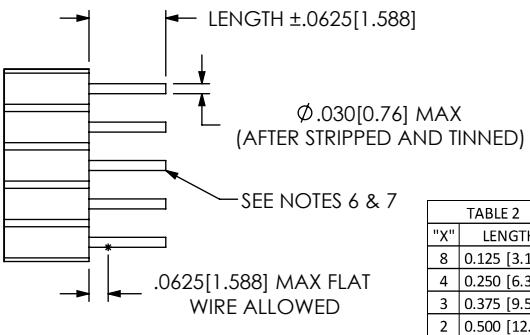


FIG 7
-ST"X": STRIPPED AND TINNED
(DIFFERENT AS SHOWN, OTHERWISE SAME AS FIG1)
(NOT AVAILABLE IN 28 POS AND UP)

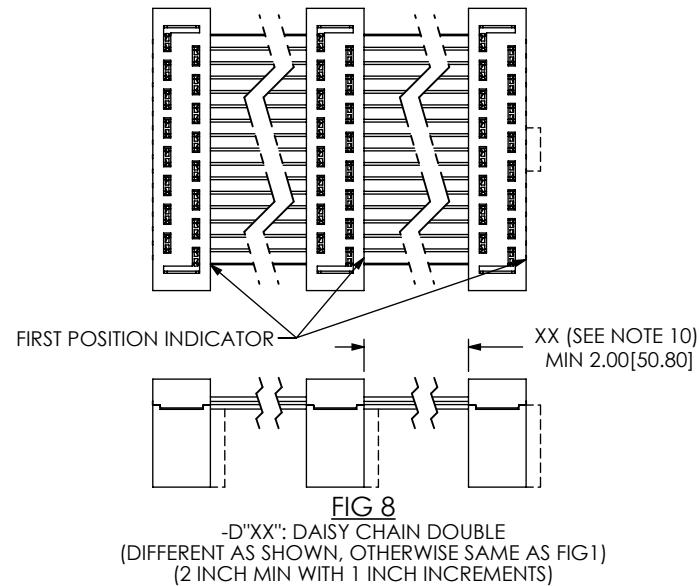


FIG 8

-D"XX": DAISY CHAIN DOUBLE
(DIFFERENT AS SHOWN, OTHERWISE SAME AS FIG1)
(2 INCH MIN WITH 1 INCH INCREMENTS)

BOTH SOCKETS REVERSED
WHEN DAISY CHAINED

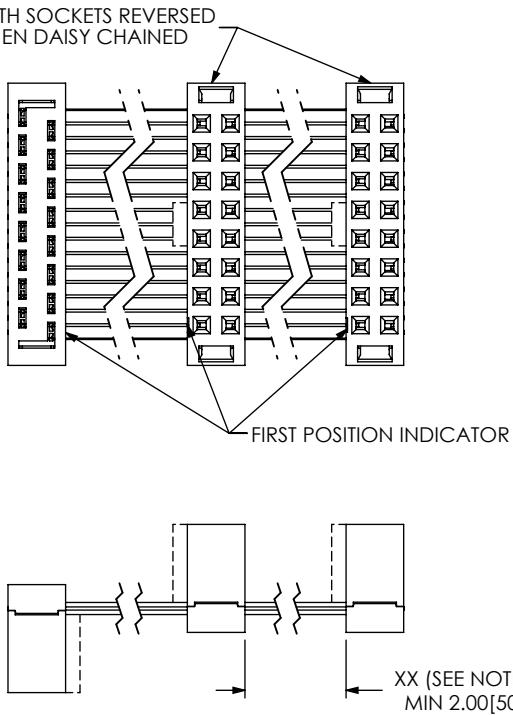


FIG 9

-R: REVERSE CONNECTOR
(DIFFERENT AS SHOWN, OTHERWISE SAME AS FIG1)

MIDDLE SINGLE TO TERMINATE
TO CONDUCTOR #1

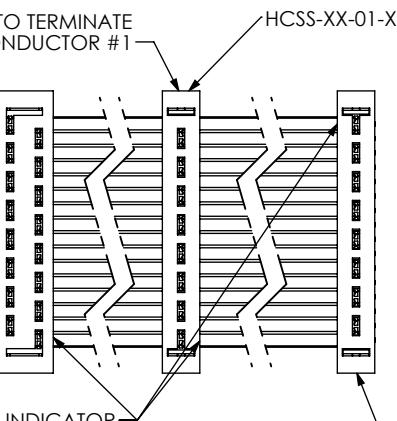


FIG 10

-W"XX": WIRING REVERSED
(DIFFERENT AS SHOWN, OTHERWISE SAME AS FIG1)

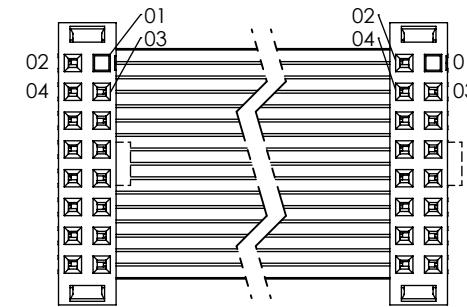


FIG 11

-P"XX": POLARIZED MATING
(DIFFERENT AS SHOWN, OTHERWISE SAME AS FIG1)
XX = POSITION NO
INSERT POLARIZING KEY PART NO PK-06-N
INTO SPECIFIED POSITION -XX (BOTH ENDS)

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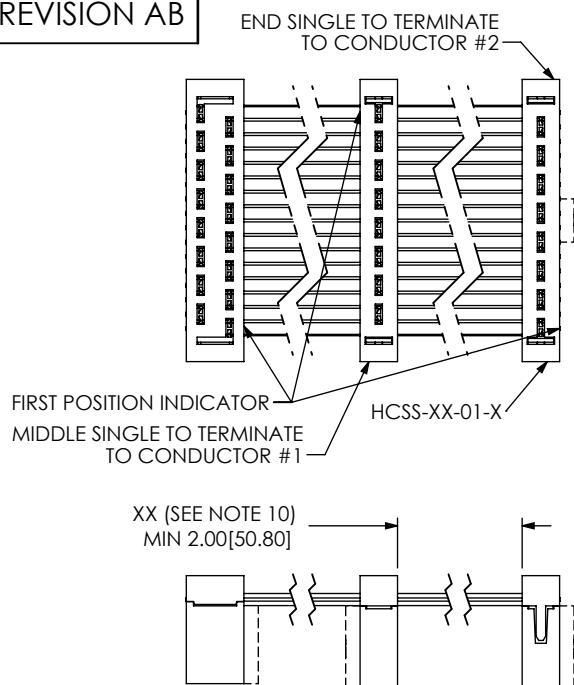
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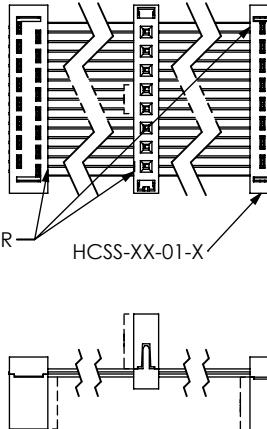
DESCRIPTION: .100 CL MOLD TO POS DOUBLE
ROW FEMALE ASSEMBLY

DWG. NO.
HCS-D-XX-X-XX.XX-01-XXX-XXX

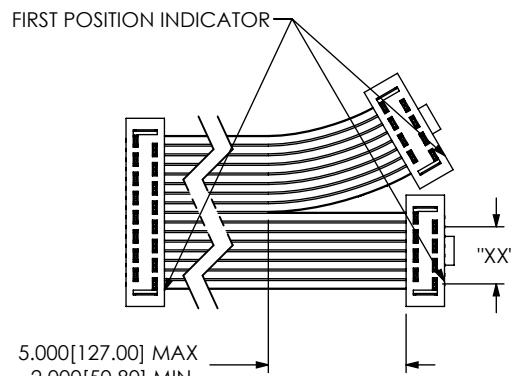
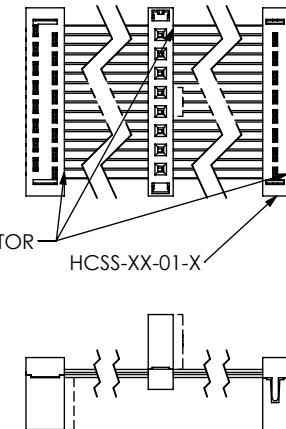
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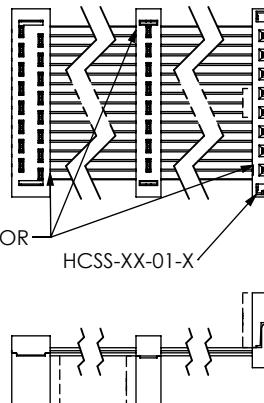
FIRST POSITION INDICATOR



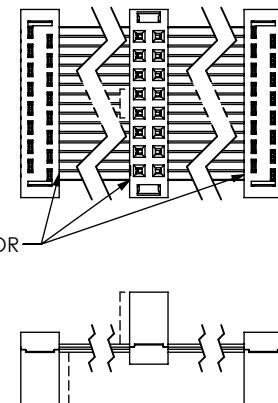
FIRST POSITION INDICATOR



FIRST POSITION INDICATOR



FIRST POSITION INDICATOR



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ROW FEMALE ASSEMBLY

DWG. NO.

HCS-XX-X-XX.XX-01-XXX-XXX

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SHEET 3 OF 4

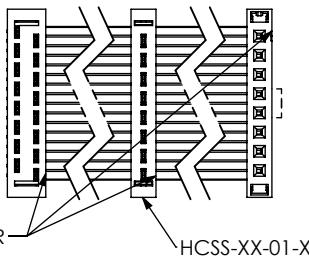
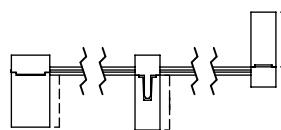
FIRST POSITION INDICATOR
HCSS-XX-01-X

FIG 18
-W"XX"-O: OUTSIDE REVERSED
(SAME AS FIG 1, DIFFERENT AS SHOWN)

FIRST POSITION INDICATOR

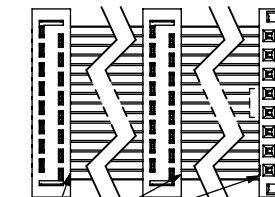
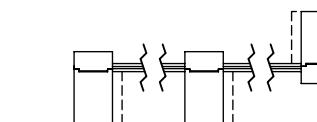


FIG 19
-D"XX"-O: OUTSIDE REVERSED
(SAME AS FIG 1, DIFFERENT AS SHOWN)



CRITICAL DIMENSION INSPECTION INSTRUCTION TABLE

ASSEMBLY OPERATION	IN-PROCESS INSPECTION
ASSEMBLE CB-XX-28-7/36-050-C	C1, C2

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