

DO NOT  
SCALE FROM  
THIS PRINT

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)

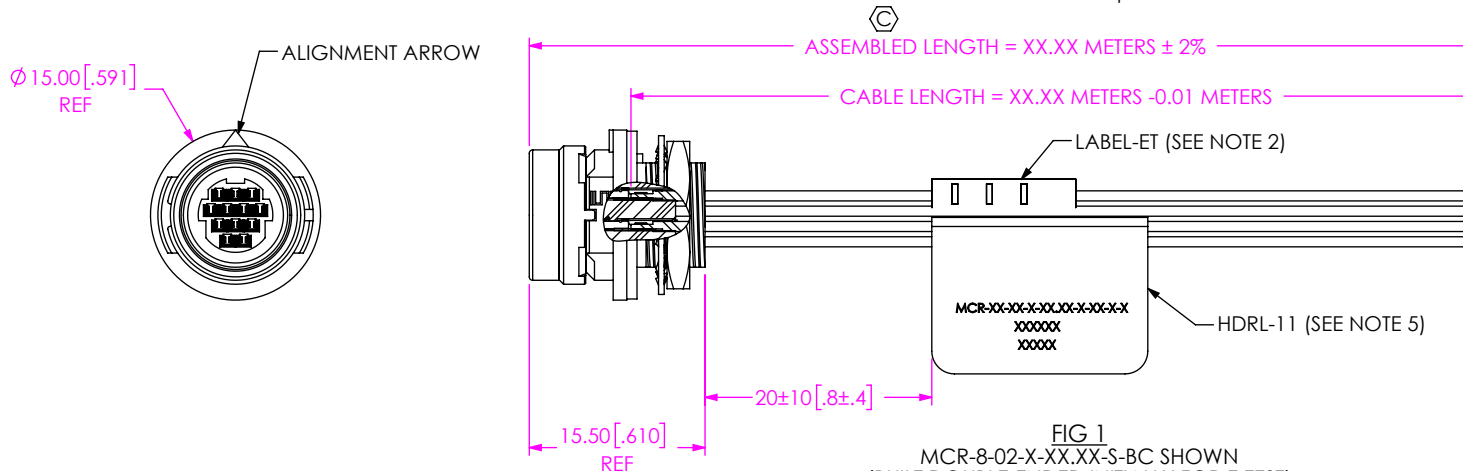


FIG 1  
MCR-8-02-X-XX.XX-S-BC SHOWN  
(BUILT DOUBLE-ENDED INITIALLY FOR E-TEST)

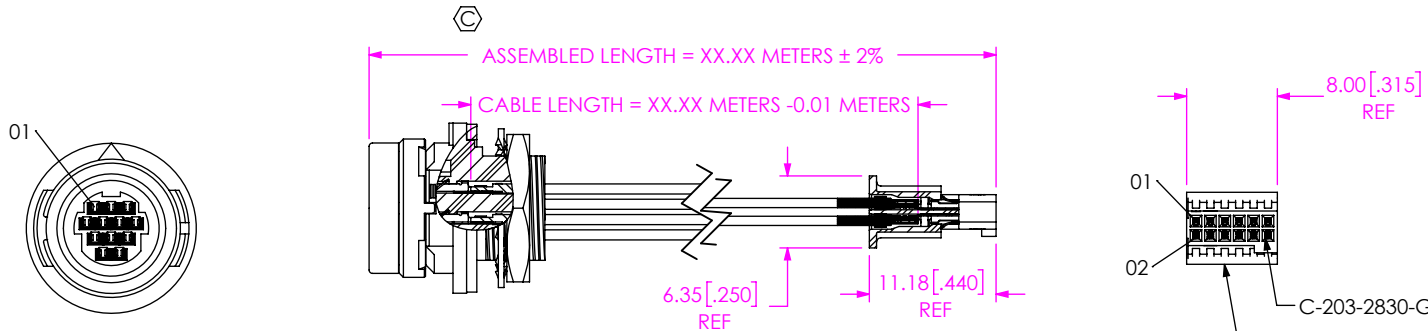
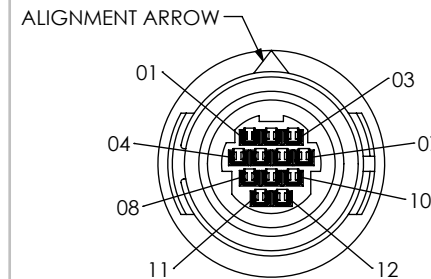


FIG 2  
MCR-8-02-X-XX.XX-S-01 SHOWN  
(PIN 1 TO PIN 1)  
(DIFFERENT AS SHOWN, OTHERWISE SAME AS FIG 1)

END 1 OPTIONS

12 POSITION  
(-S: SOCKET)



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 "XXXXXX"
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

UNLESS OTHERWISE SPECIFIED,  
DIMENSIONS ARE IN MILLIMETERS.  
TOLERANCES ARE:  
DECIMALS ANGLES  
X.X: ±0.3 [.01] 2°  
X.XX: ±0.13 [.005]  
X.XXX: ±0.051 [.0020]

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MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 3:2  
INSULATOR, C-RING: PPS  
CONTACTS: PHOS BRONZE  
GASKET: NEOPRENE RUBBER  
LOCK WASHER: PHOS BRONZE, NI PLATED  
HEX NUT: BRASS, NI PLATED

**samtec**

520 PARK EAST BLVD, NEW ALBANY, IN 47150  
PHONE: 812-944-6733 FAX: 812-948-5047  
e-Mail: info@SAMTEC.com code 53322

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 F

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

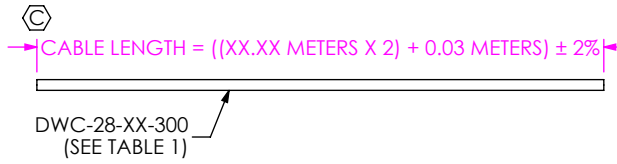


TABLE 1				
POSITION	-BC		-01	
	COLOR	DWC-XX-XX-XXX	COLOR	DWC-XX-XX-XXX
01	BROWN	DWC-28-01-300	BLACK	DWC-28-10-300
02	RED	DWC-28-02-300	BLACK	DWC-28-10-300
03	ORANGE	DWC-28-03-300	BLACK	DWC-28-10-300
04	YELLOW	DWC-28-04-300	BLACK	DWC-28-10-300
05	GREEN	DWC-28-05-300	BLACK	DWC-28-10-300
06	DARK BLUE	DWC-28-06-300	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

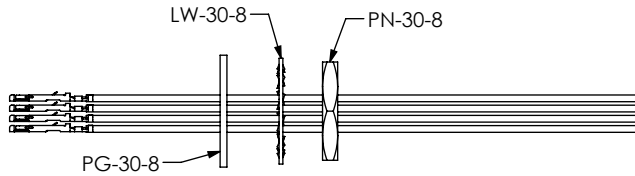
**IN-PROCESS 2**  
 STRIP CONDUCTORS



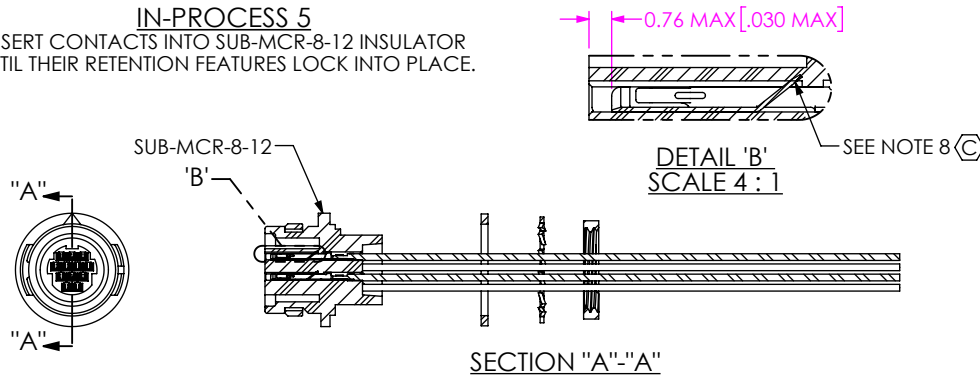
**IN-PROCESS 3**  
 CRIMP CONTACTS  
 (SEE NOTE 9)



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



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



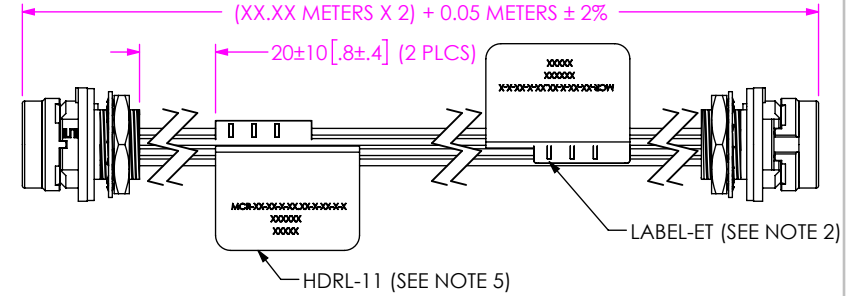
**IN-PROCESS 6**

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

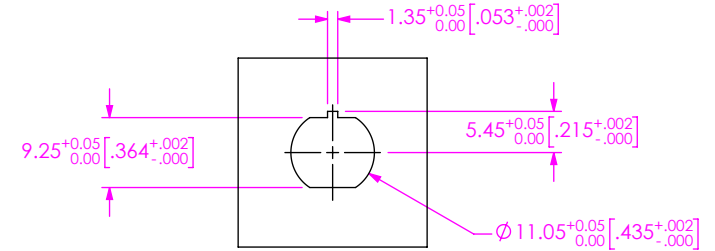


**IN-PROCESS 7**

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.



**RECOMMENDED PANEL OPENING**  
 (SEE NOTES 6 & 7)



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DO NOT SCALE DRAWING  
 SHEET SCALE: 1:1



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