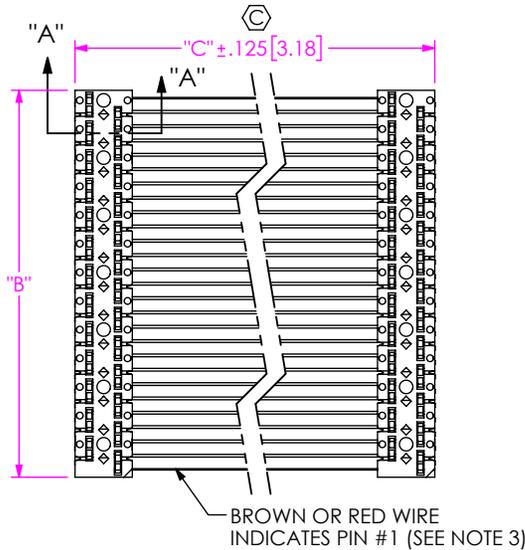


DO NOT SCALE FROM THIS PRINT

XDMX-XX-X-XX.XX-XXX-XXX



TAIL SPECIFICATION
(SEE SECT "A"-"A" & "B"-"B")
I: D = .125[3.18] (T-1S7-01-X)
**E: D = .200[5.08] (T-1S7-02-X)

ROW SPECIFICATION
-S: SINGLE
-D: DOUBLE

NO OF CONDUCTORS (SEE NOTE 3)
(-02 THRU -32 PER ROW)
USE CABLE CB-XX-28-7/36-100-C (XDMS)
USE CABLE CB-XX-28-7/36-050-C (XDMD)
"A" ±.015 [0.38] = "XX" X .100[2.54] + .019[0.48] (-01 THRU -31)
OR 3.210[81.53] REF (-32)
"B" ±.015 [0.38] = "XX" X .100[2.54] + .059[1.50] (-01 THRU -31)
OR 3.250[82.55] REF (-32)
* NOTE: STANDARD COLOR-CODED CABLE N/A FOR DOUBLE ROW 31 & 32 POSITION - SEE -G OPTION.

OPTION SPECIFICATION
SEE OPTIONS
(SEE SHT 2 & SHT 3)

OPTION SPECIFICATION
SEE OPTIONS
(SEE SHT 2 & SHT 3)

LENGTH OF CABLE
MEASURED IN INCHES
(SEE FIG 1, "C" DIM)

CONNECTOR SPECIFICATION
-S: (SINGLE) ONE XDM ASSEMBLY
-D: (DOUBLE) TWO XDM ASSEMBLIES
-ONE ON EACH END
-T: (TRANSFER-IDS) ONE XDMS & ONE IDS
-ONE ON EACH END
-T: (TRANSFER-IDMD) ONE XDMD & ONE IDD
-ONE ON EACH END

** = EXISTING CUSTOMERS ONLY

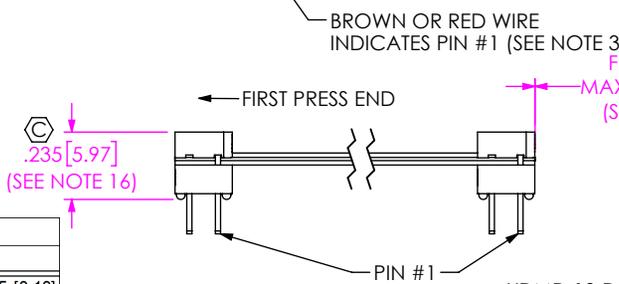


FIG 1
XDMD-13-D-XX.XX-X-X SHOWN

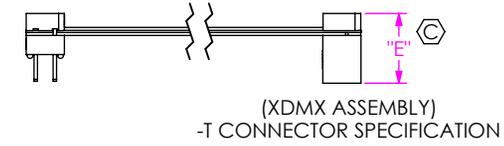
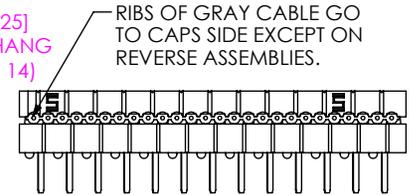
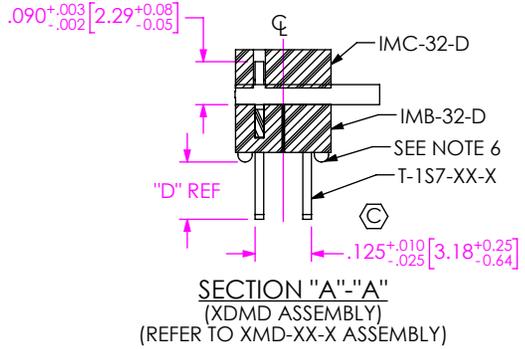
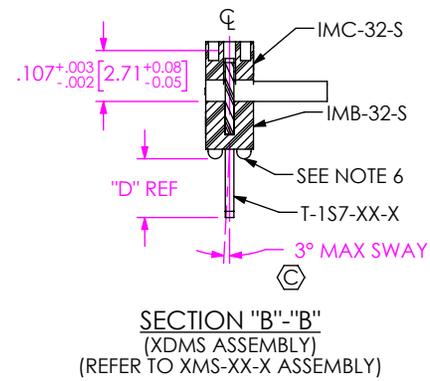


FIG 3
XDMD-13-D-XX.XX-X-X-T SHOWN
(DIFFERENT AS SHOWN, OTHERWISE SAME AS FIG 1)

TABLE 1		
No. OF POS	"E"	
2, 3, 4	.360 [9.144]	+ .005 [0.13] - .000 [0.00]
5 AND UP	.365 [9.271]	+ .010 [0.25] - .005 [0.13]



SECTION "A"-"A"
(XDMD ASSEMBLY)
(REFER TO XMD-XX-X ASSEMBLY)



SECTION "B"-"B"
(XDMS ASSEMBLY)
(REFER TO XMS-XX-X ASSEMBLY)

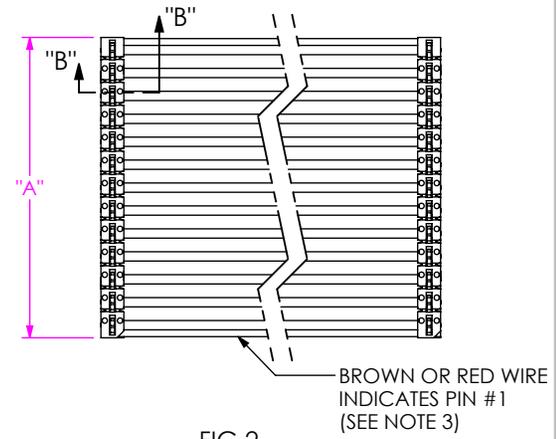


FIG 2
XDMS-13-D-XX.XX-X-X SHOWN
(DIFFERENT AS SHOWN, OTHERWISE SAME AS FIG 1)

NOTES:

- ⊕ REPRESENTS A CRITICAL DIMENSION.
- OPTION -SXX WHEN MATING DOUBLE ROW CONNECTOR WITH 2 SINGLE ROW CONNECTORS, THE OUTER MOST SINGLE WILL BE CONNECTED TO CONDUCTOR #1 AND THE INSIDE SINGLE TO CONDUCTOR #2.
- ON FIRST CABLE INSERTION PRESS, THE BROWN WIRE (COLORED CABLE) OR THE RED WIRE (GRAY CABLE) IS POSITIONED TO THE RIGHT WITH THE "FAT END" OF THE BASE AND CAP.
- WHEN CUTTING BASE AND CAPS TO POSITION, END WALLS ON CUT ENDS SHALL BE .010 [0.25] MIN.
- NOTE DELETED.
- STANDOFFS ON BASE SHALL STAND .010 [0.25] MIN. FROM SURFACE OF IMB-32-X.
- OPTION -PXX: POLARIZING OPTION CAN ONLY BE USED ON IDX END OF -T (TRANSFER) OPTION.
- WHEN DAISY CHAINING A TRANSFER END OPTION, ONLY THE FIRST CONNECTOR IS MALE; THE REMAINING CONNECTORS ARE FEMALE.
- A CHAMFER ON THE END OF THE CAP IS GUARANTEED ON FINAL ASSEMBLIES THAT ARE AT LEAST 18 POSITIONS FOR MALE AND FEMALE TERMINATION.
- ALL ASSEMBLIES TO BE 100% ELECTRICALLY TESTED FOR SHORTS AND OPENS.
- ALL ASSEMBLIES TO BE 100% HI-POT TESTED AT 1000V.
- CONTACT NOT TO BE VISIBLE THROUGH THE END WALL OF IMC-32-X CAP.
- REFERENCE XMD-XX-X (AND IDS-XX-X-PXX OR IDD-XX-X FOR -T OPTION) FOR CUT DIMENSIONS.
- 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 CABLE THICKNESS ON NON-CONSECUTIVE STRANDS IS CONSIDERED A PROCESS INDICATOR.
- PACKAGE TERMINAL ENDS WITH CS-IDC002 CLAMSHHELLS; PACKAGE -STX OPTIONS USING SKIN PACKAGING.
- DEMINSION FROM TOP OF CAP TO STANDOFF.
- SAME AS -SXX EXCEPT OUTER STRIP CONNECTED TO CONDUCTOR #2 AND INSIDE STRIP CONNECTED TO CONDUCTOR #1.

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

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PHONE: 812-944-6733 FAX: 812-948-5047
e-Mail: info@SAMTEC.com code 55322

MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 2:1
INSULATOR: VALOX DR-48, COLOR: BLACK
CONTACT: BeCu
TERMINAL: PHOSPHOR BRONZE
CABLE: TINNED COPPER/PVC

DESCRIPTION:
ASSEMBLY INSULATION DISPLACEMENT TERMINAL CONNECTOR
DWG. NO.
XDMX-XX-X-XX.XX-XXX-XXX
BY: JORDAN 12/30/1987 SHEET 1 OF 3

TABLE 2

OPTION	CONTACTS
-T	T-1S7-XX-T (XDMX)
	C-10-T (IDSX)
-C***	T-1S7-XX-T (XDMX)
	C-10-G (IDSX)
-A***	T-1S7-XX-G (XDMX)
	C-10-T (IDSX)

***CAN ONLY BE USED WITH CONNECTOR SPECIFICATION -T

PLATING
-T, -C*** OR -A***

SUBSTITUTE GRAY CABLE FOR STANDARD COLOR CODED CABLE.

XDMX: CB-XX-28-7/36-050-G
XDMX: CB-XX-28-7/36-100-G
(SEE FIG 1)

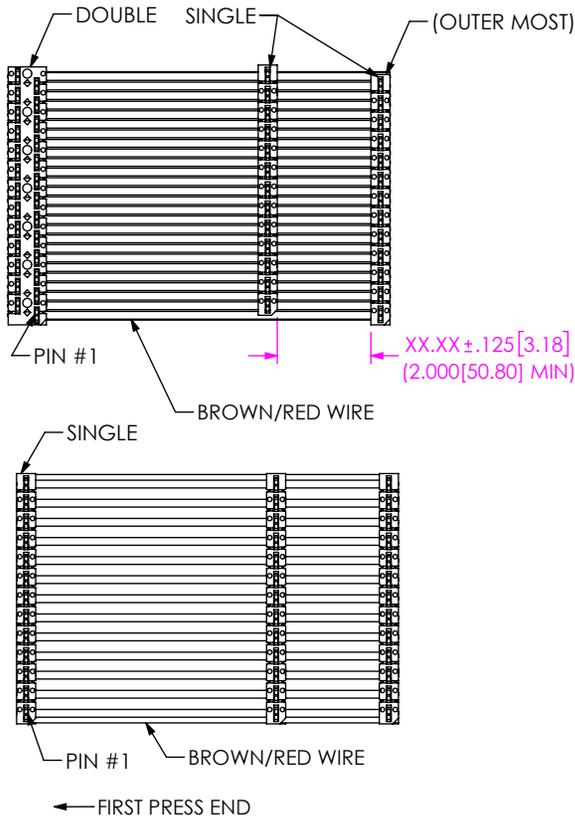
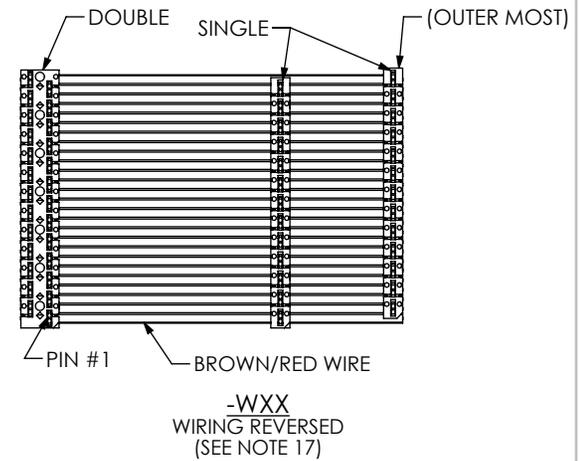
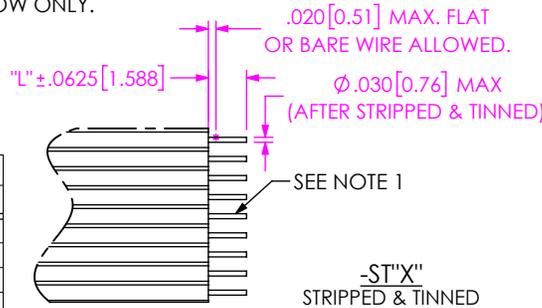
NOTE: USE GRAY CABLE FOR DOUBLE ROW, -31 & -32 POSITION.

-G
GRAY CABLE

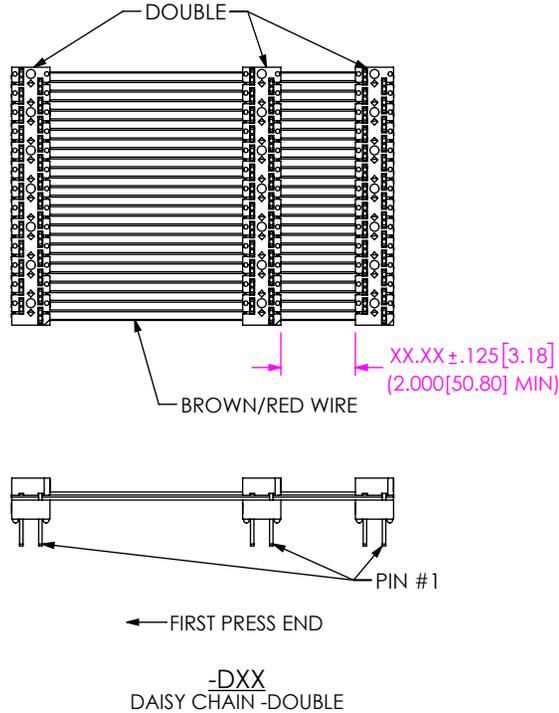
- NOTE:
- CONDUCTORS SHALL BE CONSISTENT IN APPEARANCE. SOLDER MUST MAINTAIN CABLE STRAINS WITHIN THE MAX DIA. TOLERANCE.
 - USE 60/40 TIN/LEAD SOLDER ONLY.
 - NOT AVAILABLE IN 28 POSITION AND UP IN DOUBLE ROW ONLY.

TABLE 3

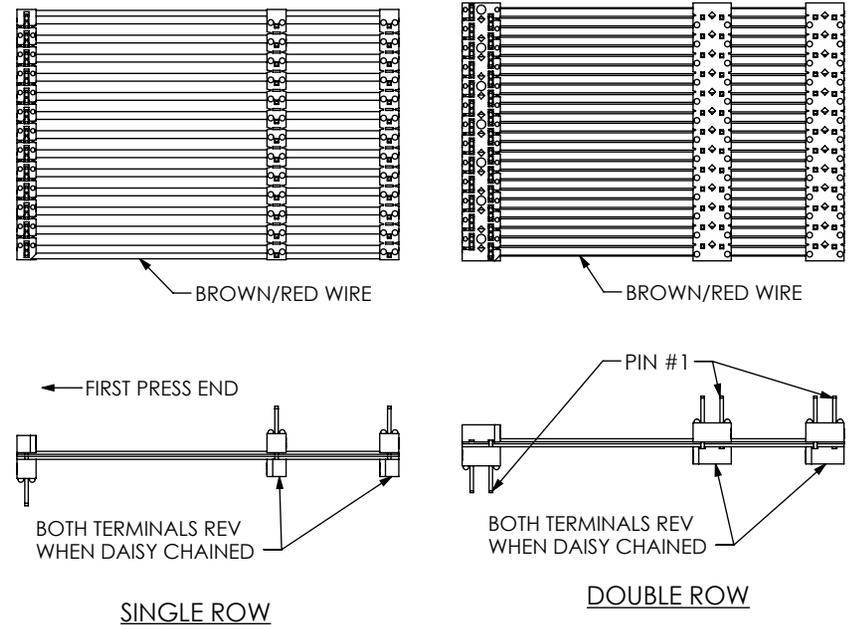
ST "X"	"L"
ST8	.125 [3.18]
ST4	.250 [6.35]
ST3	.375 [9.53]
ST2	.500 [12.70]



2 INCH MINIMUM LENGTH;
ONE INCH INCREMENTS ONLY



2 INCH MINIMUM LENGTH;
ONE INCH INCREMENTS ONLY



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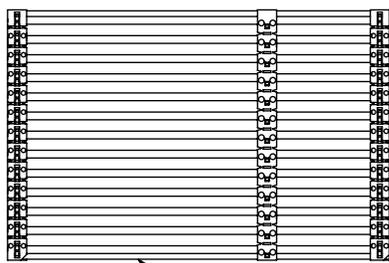
DO NOT SCALE DRAWING

SHEET SCALE: 2:1

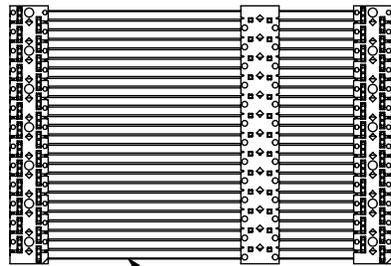
DESCRIPTION:
ASSEMBLY INSULATION DISPLACEMENT TERMINAL CONNECTOR

DWG. NO.
XDMX-XX-X-XX.XX-XXX-XXX

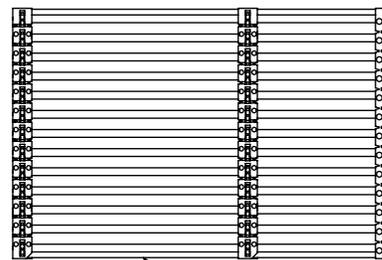
BY: JORDAN 12/30/1987 SHEET 2 OF 3



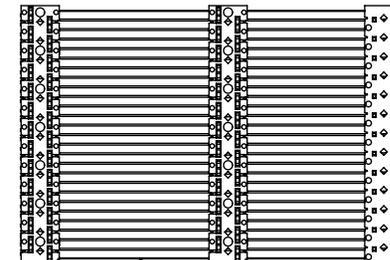
BROWN/RED WIRE



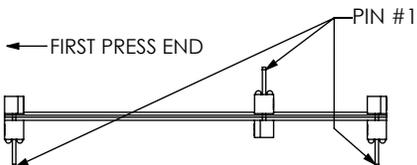
BROWN/RED WIRE



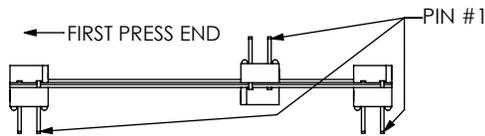
BROWN/RED WIRE



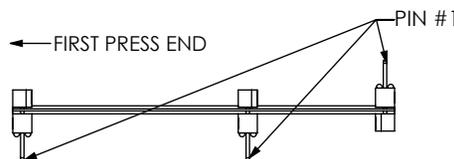
BROWN/RED WIRE



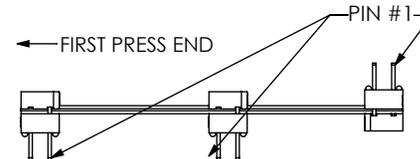
SINGLE ROW



DOUBLE ROW



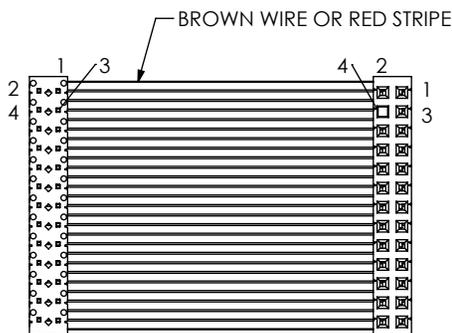
SINGLE ROW



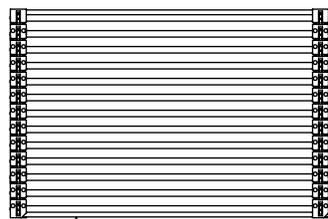
DOUBLE ROW

-M
MIDDLE REVERSED
(REQUIRES -SXX, -WXX OR -DXX OPTIONS)
(NOT AVAILABLE WITH -R OR -O OPTIONS)

-O
OUTSIDE REVERSED
(REQUIRES -SXX, -WXX OR -DXX OPTIONS)
(NOT AVAILABLE WITH -R OR -M OPTIONS)

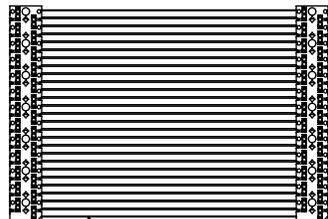


IDMD



BROWN OR RED WIRE INDICATES PIN #1

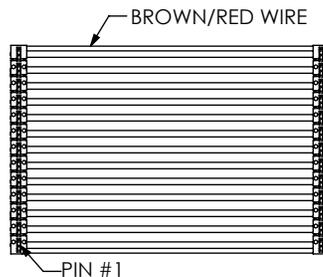
SINGLE ROW



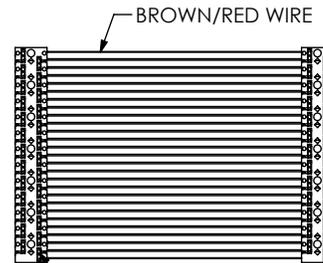
BROWN OR RED WIRE INDICATES PIN #1

DOUBLE ROW

STANDARD WIRING

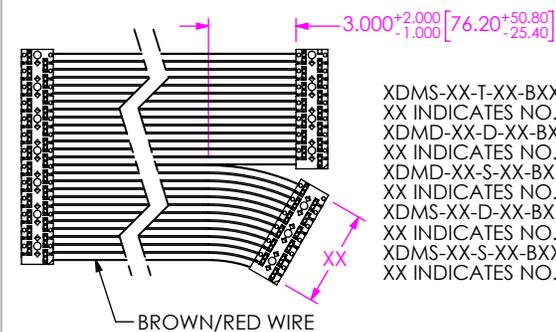


SINGLE ROW



DOUBLE ROW

-RW
REVERSED WIRING



-BXX
BREAKOUT

XDMS-XX-T-XX-BXX:
XX INDICATES NO. OF POSITIONS
XDMD-XX-D-XX-BXX:
XX INDICATES NO. OF CONDUCTORS
XDMD-XX-S-XX-BXX:
XX INDICATES NO. OF CONDUCTORS
XDMS-XX-D-XX-BXX:
XX INDICATES NO. OF POSITIONS
XDMS-XX-S-XX-BXX:
XX INDICATES NO. OF POSITIONS

NOTE: MUST HAVE EVEN NUMBER OF BREAKOUT POSITIONS ON DOUBLE ROW ASSEMBLIES



-PXX
POLARIZED MATING (SEE NOTE 7)
(XX = POSITION NO.)
(NOT AVAILABLE WITH -R OR -M OPTIONS)

NOTE:
1. INSERT POLARIZING KEY PART NO. PK-06 INTO SPECIFIED POSITION -XX OF IDS END OF -T (TRANSFER) END ONLY.
2. POLARIZED POSITION WILL HAVE SAME ELECTRICAL POSITION FROM BROWN WIRE.

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e-Mail info@SAMTEC.com code 55322

DO NOT SCALE DRAWING

SHEET SCALE: 1:1

DESCRIPTION:
ASSEMBLY INSULATION DISPLACEMENT TERMINAL CONNECTOR

DWG. NO.
XDMX-XX-X-XX.XX-XXX-XXX

BY: JORDAN 12/30/1987 SHEET 3 OF 3