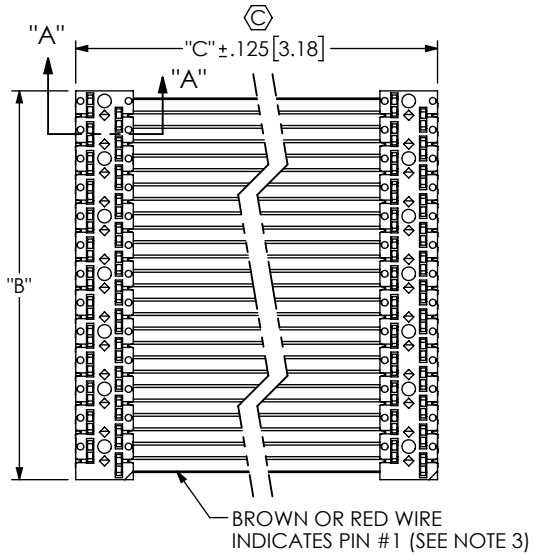


DO NOT SCALE FROM THIS PRINT



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" ± $\begin{matrix} .015[.38] \\ .005[.13] \end{matrix}$ = "XX" X .100[2.54] + .019[0.48] (-01 THRU -31)
OR 3.210[81.53] REF (-32)
"B" ± $\begin{matrix} .015[.38] \\ .005[.13] \end{matrix}$ = "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-IDMS) ONE XDMS & ONE IDS - ONE ON EACH END
-T: (TRANSFER-IDMD) ONE XDMD & ONE IDD - ONE ON EACH END

** = EXISTING CUSTOMERS ONLY

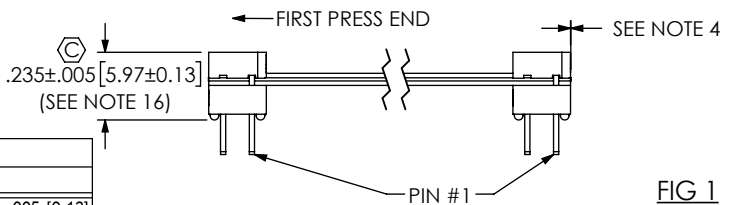


TABLE 1		
No. OF POS	"E"	
2, 3, 4	.360 [9.144]	+ .005 [0.13] - .000 [0.00]
5 AND UP	.365 [9.271]	+ .010 [0.25] - .005 [0.13]

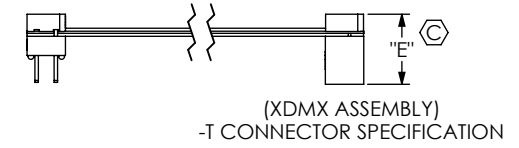
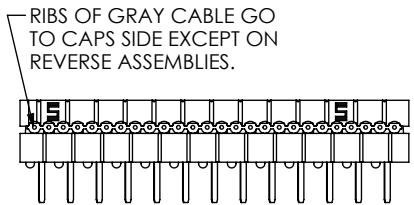


FIG 3
XDMD-13-D-XX.XX-X-X T SHOWN
(DIFFERENT AS SHOWN, OTHERWISE SAME AS FIG 1)

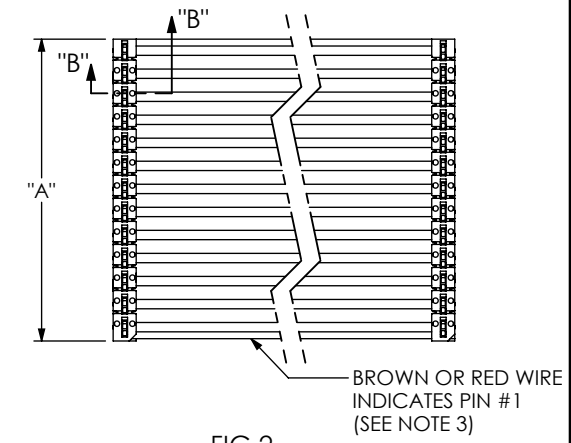
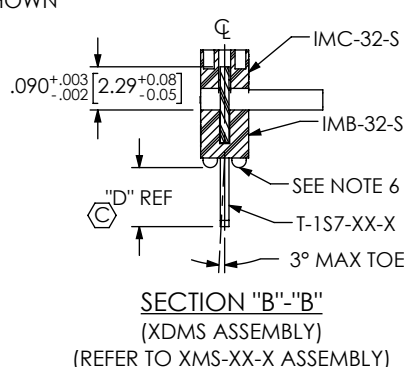
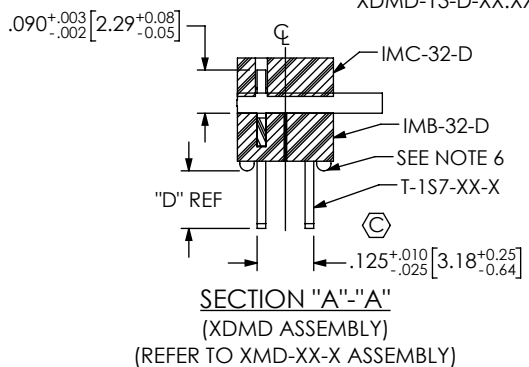


FIG 2
XDMS-13-D-XX.XX-X-X SHOWN
(DIFFERENT AS SHOWN, OTHERWISE SAME AS FIG 1)

- 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.
 - CABLE CAN BE RECESSED OR EXTENDED .010 [0.25] MAX. FROM FLUSH
 - 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 IDX-XX-X-PXX 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 WITH PAPER COVERS EITHER CRD-IDC004 OR CRD-IDC005 BASED ON POSITION.
 - 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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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**

REVISION AQ

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.

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

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

-G
GRAY CABLE

NOTE:

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

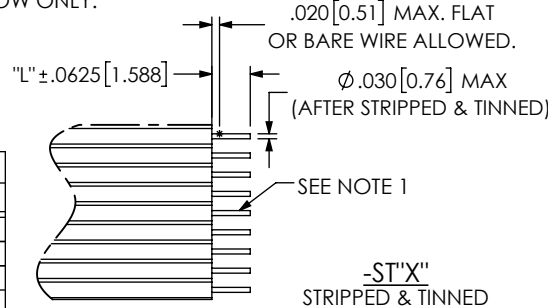
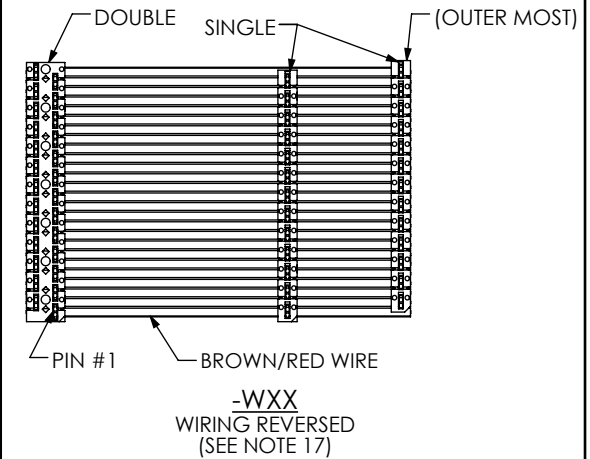
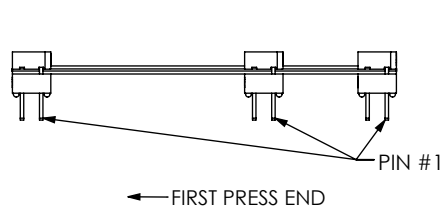
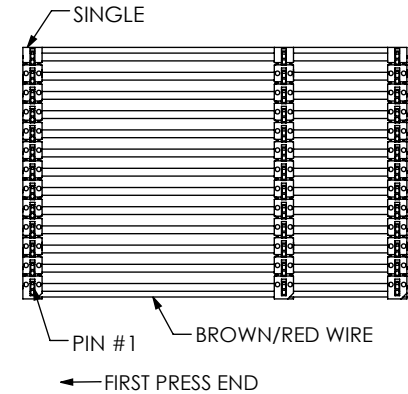
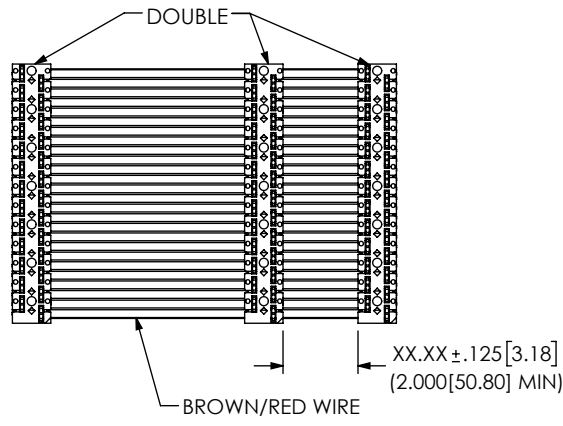
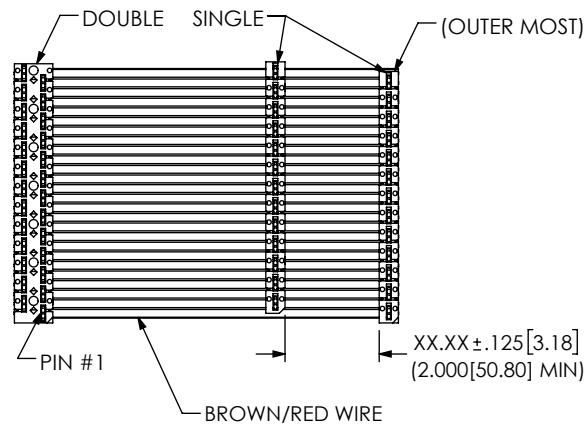


TABLE 3	
ST "X"	"L"
ST8	.125 [3.18]
ST4	.250 [6.35]
ST3	.375 [9.53]
ST2	.500 [12.70]

-ST"X"
STRIPPED & TINNED

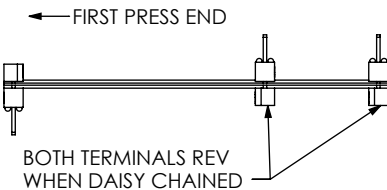
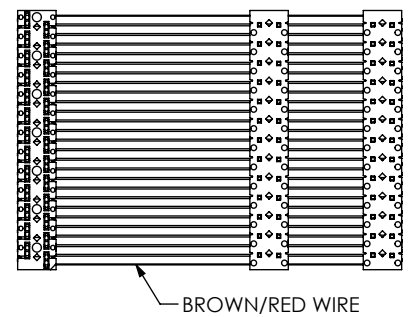
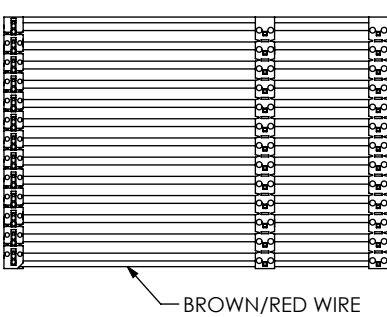


-WXX
WIRING REVERSED
(SEE NOTE 17)

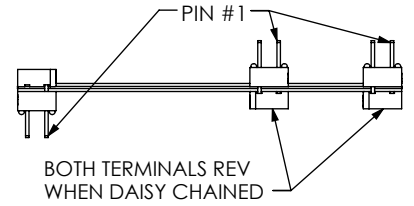


-DXX
DAISY CHAIN -DOUBLE

2 INCH MINIMUM LENGTH;
ONE INCH INCREMENTS ONLY



SINGLE ROW



DOUBLE ROW

-R
REVERSED CONNECTOR
(NOT AVAILABLE WITH -M OR -O OPTIONS)

-SXX
DAISY CHAIN - SINGLE
(SEE NOTE 2 & 8)

2 INCH MINIMUM LENGTH;
ONE INCH INCREMENTS ONLY

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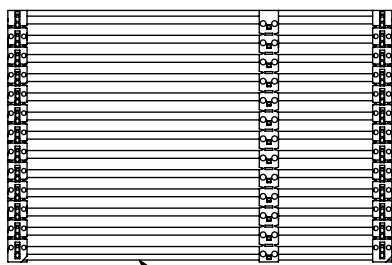
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DESCRIPTION:
ASSEMBLY INSULATION DISPLACEMENT TERMINAL CONNECTOR

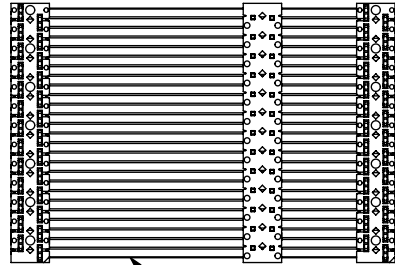
DWG. NO.
XDMX-XX-X-XX.XX-XXX-XXX

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

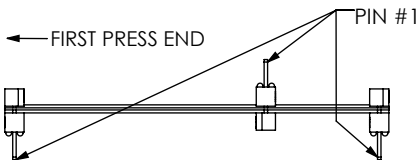
REVISION AQ



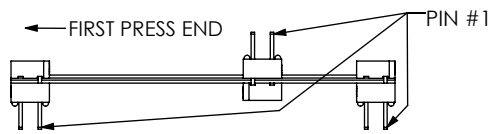
BROWN/RED WIRE



BROWN/RED WIRE

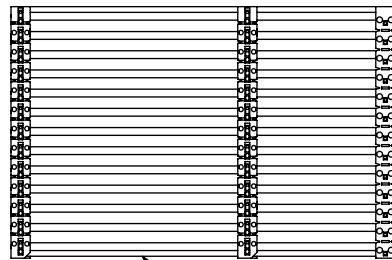


SINGLE ROW

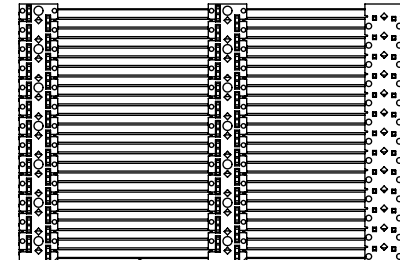


DOUBLE ROW

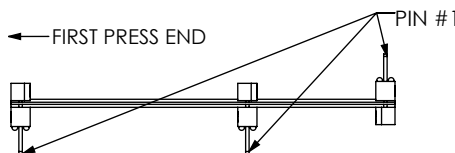
-M
MIDDLE REVERSED
(REQUIRES -SXX, -WXX OR -DXX OPTIONS)
(NOT AVAILABLE WITH -R OR -O OPTIONS)



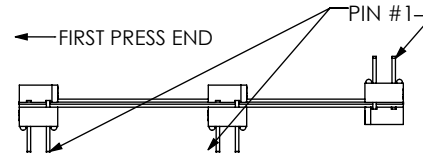
BROWN/RED WIRE



BROWN/RED WIRE

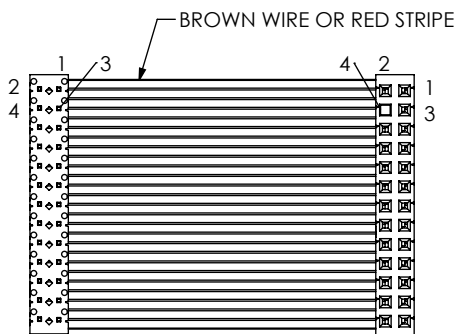


SINGLE ROW



DOUBLE ROW

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

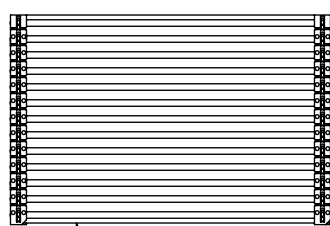


IDMD IDSD

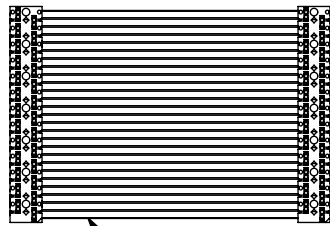


-PXX
POLARIZED MATING (SEE NOTE 7)
(XX = POSITION NO.)
(NOT AVAILABLE WITH -R OR -M OPTIONS)

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.

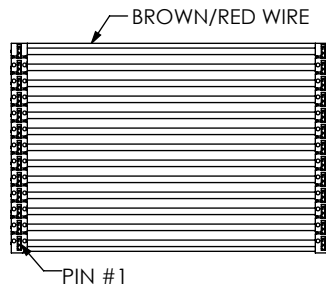


BROWN OR RED WIRE INDICATES PIN #1
SINGLE ROW

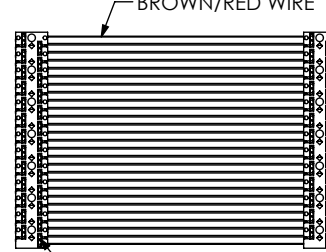


BROWN OR RED WIRE INDICATES PIN #1
DOUBLE ROW

STANDARD WIRING

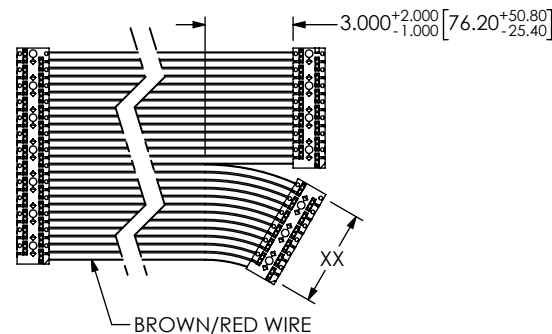


BROWN/RED WIRE
PIN #1
SINGLE ROW



BROWN/RED WIRE
PIN #1
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

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

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