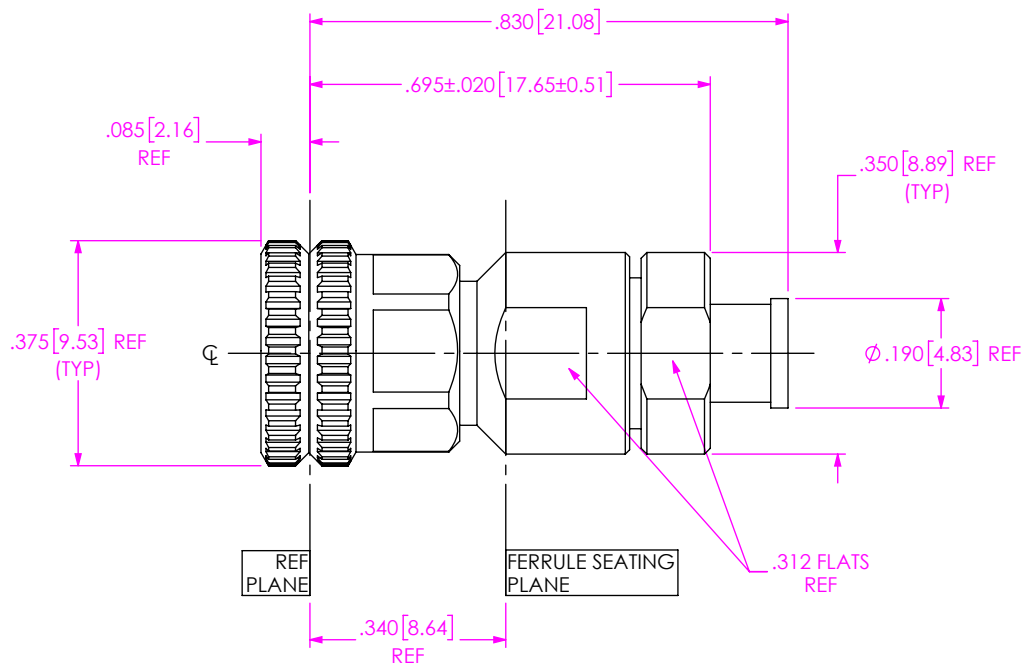


DO NOT  
SCALE FROM  
THIS PRINT



SERIES  
-18: 1.85MM

GENDER  
-P: PLUG

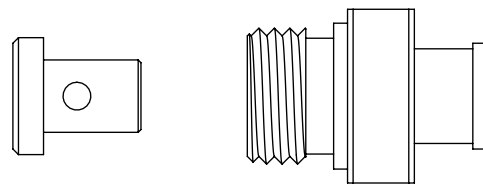
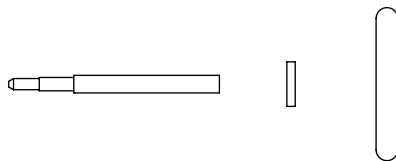
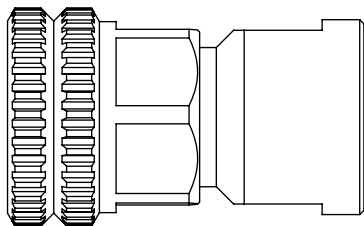
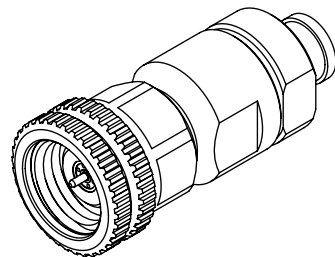
TYPE  
-C: CABLE

FINISH  
-EP: 50µ" EXTRA HEAVY GOLD  
CENTER CONTACT,  
PASSIVATED OUTER CONTACT

TERMINATION  
-S: SOLDER CLAMP

ORIENTATION  
-S: STRAIGHT

CABLE TYPE  
-085: HARBOUR SS405



EXPLODED VIEW  
NOT TO SCALE  
(FOR CLARITY ONLY)

NOTES:

1. MATERIAL:  
BODY, CLAMP NUT, COUPLING NUT: STAINLESS STEEL.  
GASKET, O-RING: SILICONE RUBBER.  
BEAD: NORYL.  
DIELECTRIC STOP: ULTEM.  
SOLDER FERRULE: BRASS ALLOY  
CONTACT, LOCK RING: BERYLLIUM COPPER.
2. FINISH:  
BODY, CLAMP NUT, COUPLING NUT: PASSIVATED.  
CONTACT, SOLDER FERRULE: GOLD OVER NICKEL PLATE,  
50 µIN MIN GOLD OVER 50 µIN MIN NICKEL.

3. PCI P/N: 3918.

UNLESS OTHERWISE SPECIFIED,  
DIMENSIONS ARE IN INCHES.

TOLERANCES ARE:

DECIMALS  
.XX: ±.01  
.XXX: ±.002  
.XXXX: ±.0005

ANGLES  
1°

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. 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.

**samtec**

520 PARK EAST BLVD, NEW ALBANY, IN 47150  
PHONE: 812-944-6733 FAX: 812-948-5047  
e-Mail: info@SAMTEC.com code 55322

DO NOT SCALE DRAWING

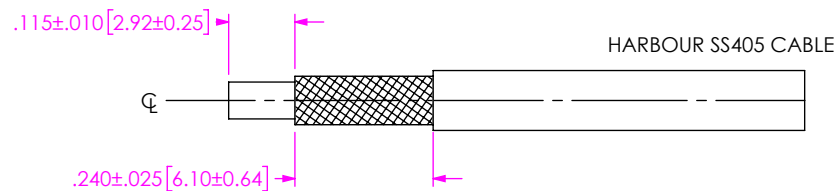
SHEET SCALE: 3:1

DESCRIPTION: 1.85MM PLUG. SOLDER CLAMP  
FOR SS405 CABLE. KNURL/HEX

DWG. NO. PRF18-P-C-EP-085-SS

BY: SAMUEL C 05/06/2019 SHEET 1 OF 2

1A. TRIM CABLE TO EXPOSE DIELECTRIC CORE AND OUTER BRAID AS SHOWN.



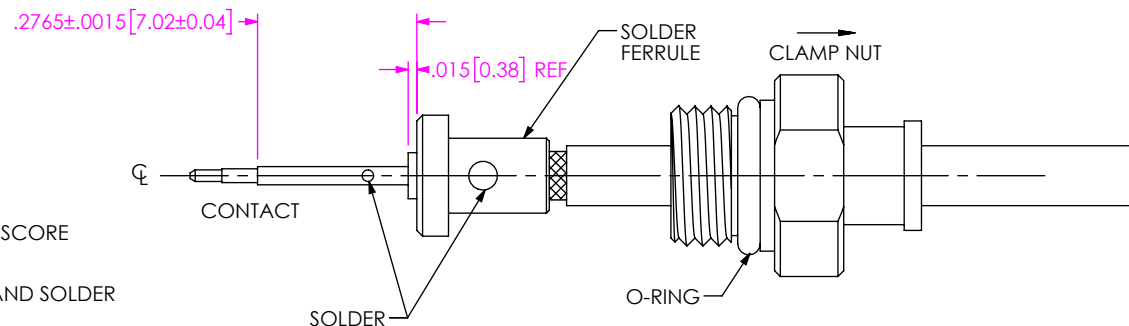
## IN-PROCESS VIEW 1

2A. SLIDE CLAMP NUT ONTO CABLE IN ORIENTATION SHOWN.

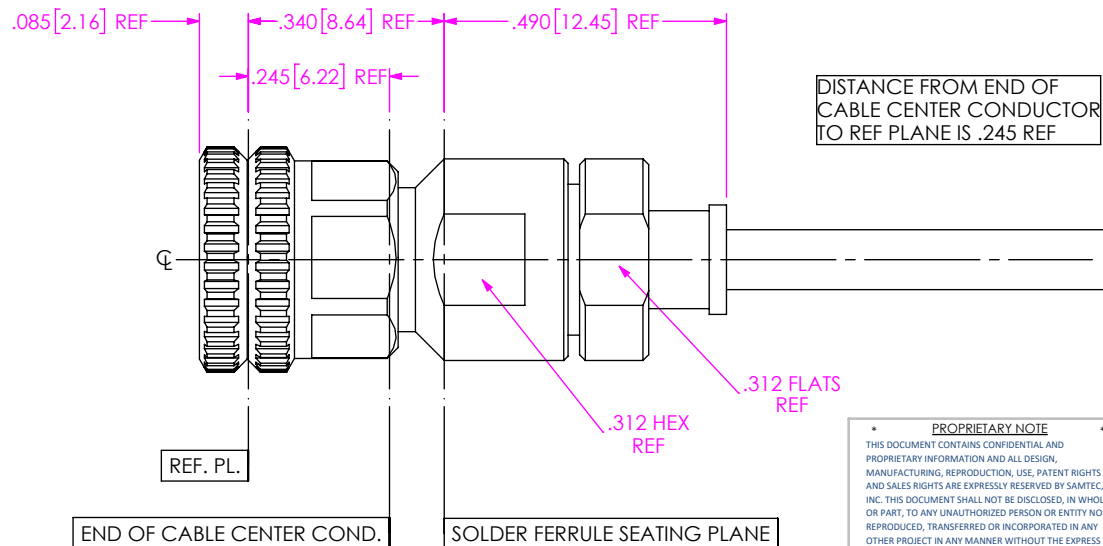
2B. INSERT CABLE INTO SOLDER FERRULE UNTIL FULLY SEATED. THEN SOLDER CABLE TO FERRULE WHERE SHOWN.

2C. TRIM CABLE DIELECTRIC FLUSH WITH FERRULE FACE (DO NOT SCORE CENTER CONDUCTOR).

2D. SLIDE DIELECTRIC STOP OVER CABLE CENTER CONDUCTOR AND SOLDER CONTACT FLUSH TO STOP TO DIMENSION SHOWN.



## IN-PROCESS VIEW 2



3A. INSERT CABLE SUB-ASSEMBLY INTO CONNECTOR BODY UNTIL SOLDER FERRULE IS SEATED AND TIGHTEN CLAMP NUT TO 25-35 IN. LBS.

## IN-PROCESS VIEW 3

**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. 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

SHEET SCALE: 3:1

**samtec**

520 PARK EAST BLVD, NEW ALBANY, IN 47150  
PHONE: 812-944-6733 FAX: 812-948-5047  
e-Mail: info@SAMTEC.com code 55322

DESCRIPTION: 1.85MM PLUG. SOLDER CLAMP FOR SS405 CABLE. KNURL/HEX

DWG. NO. PRF18-P-C-EP-085-SS

BY: SAMUEL C 05/06/2019 SHEET 2 OF 2