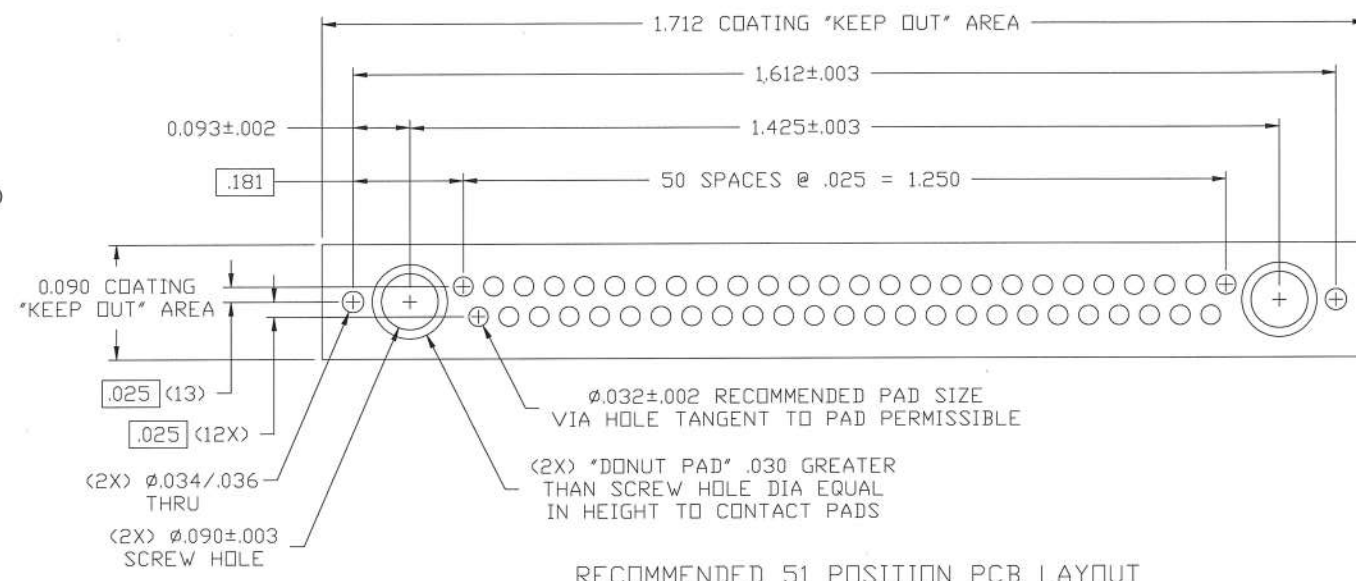
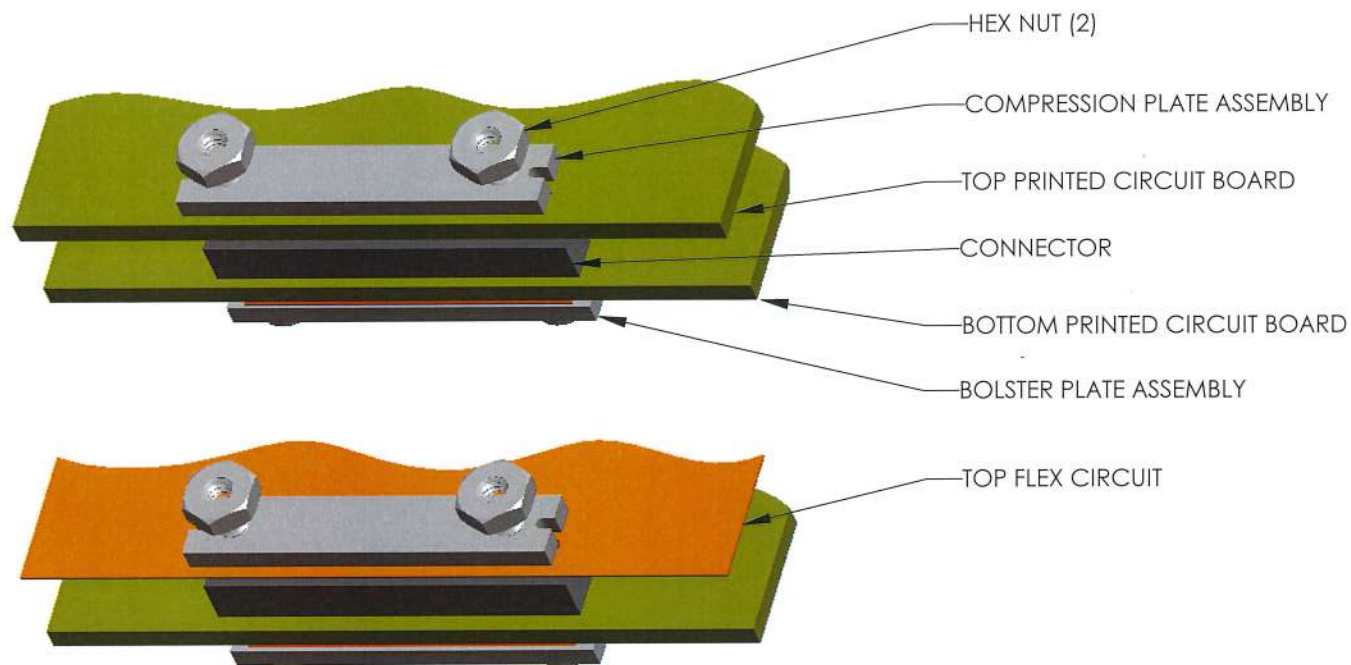


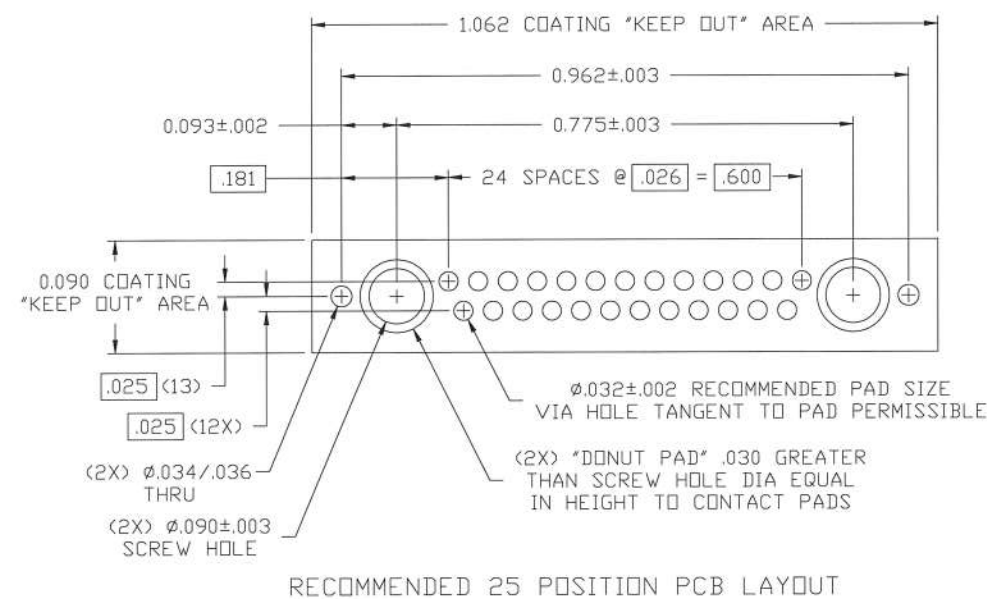
DRAWING REVISIONS (RELEASE DATE ON FILE)			
REV	DOCUMENT	APP	APPROVAL DATE
A	INITIAL RELEASE	KR	2/12/19



ASSEMBLY NOTES:

1. PRODUCE PRINTED CIRCUIT / FLEX BOARDS USING RECCOMENDED DESIGN LAYOUT SHOWN BELOW.
2. BOARD CONTACT PADS MUST BE CLEAN.
3. ASSEMBLE BOTTOM PRINTED CIRCUIT BOARD OVER SCREWS OF BOLSTER PLATE ASSEMBLY AS SHOWN.
4. REMOVE PROTECTIVE TAPE FROM CONNECTOR AND ASSEMBLE OVER SCREWS MAKING SURE CONTACTS ARE IN PROPER ALIGNMENT. PADS ON BOARD.
5. ASSEMBLE TOP PRINTED CIRCUIT BOARD OR FLEX OVER SCREWS AS SHOWN.
6. ASSEMBLE COMPRESSION PLATE ASSEMBLY WITH INSULATED SIDE AGAINST THE TOP BOARD AS SHOWN.
7. ASSEMBLE TWO HEX NUTS AND TIGHTEN EVENLY TO 2.5 INCH-POUNDS.

NUMBER OF CONNECTOR CONTACT POSITIONS	STACKING CONNECTOR PART NUMBER (REF.)	TOTAL PRINTED CIRCUIT BOARD / FLEX STACK HEIGHT **	USE HARDWARE KIT PART NUMBER
25	380 05 20 001	.095" MAXIMUM	318 02 99 351
25	380 05 20 001	.155" MAXIMUM	318 02 99 352
25	380 05 20 001	.215" MAXIMUM	318 02 99 353
51	380 05 20 013	.095" MAXIMUM	318 02 99 354
51	380 05 20 013	.155" MAXIMUM	318 02 99 355
51	380 05 20 013	.215" MAXIMUM	318 02 99 356



UNITS: ENGLISH INCHES		DESIGN ENGINEER: K. ROSBOROUGH	DATE: 3/18/19	CINCH <small>1700 FINLEY RD LOMBARD, IL. 60148</small>	
DO NOT SCALE DRAWING		UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES FILLET/RADII .02 MAX.		TITLE: STACKING CONNECTOR HARDWARE ASSEMBLY CUSTOMER DRAWING	
TOLERANCES: .X ± .1 .XX ± .01 .XXX ± .005 ANGULAR ± .5°		MATERIAL: SEE CHART		CONTROL SPEC NUMBER: N/A	
CONFIDENTIAL THIS DOCUMENT IS THE PROPERTY OF CINCH. NEITHER THIS DOCUMENT NOR ANY OF THE INFORMATION CONTAINED IN IT MAY BE DUPLICATED OR DISCLOSED WITHOUT PRIOR WRITTEN CONSENT OF CINCH. ©COPYRIGHT 2012 CINCH.		MATERIAL SPEC NUMBER: N/A		FINISH: N/A	
APPROVALS ON FILE		CAD FILE NUMBER: 3180299351S		DRAWING NUMBER: 318 02 99 351S	
CAGE IDENT NO.: 71785		SIZE: B		SCALE: NONE	
				SHEET 1 OF 1	