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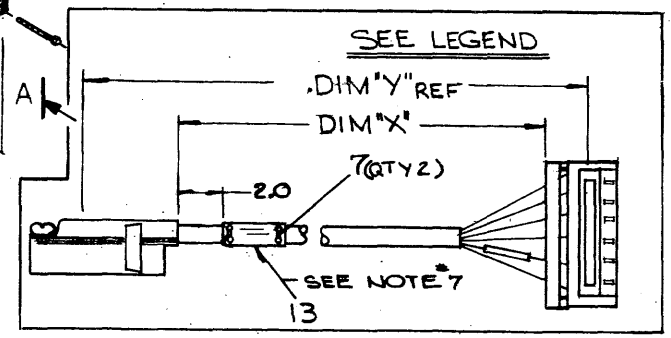
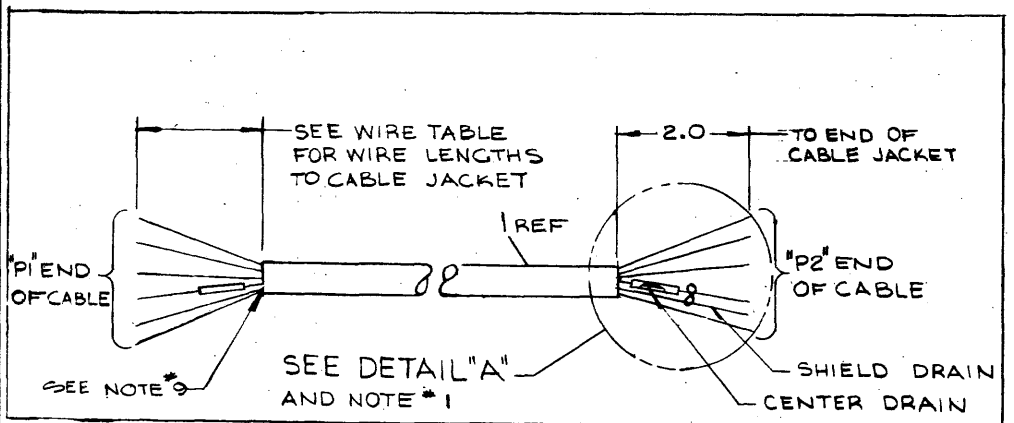
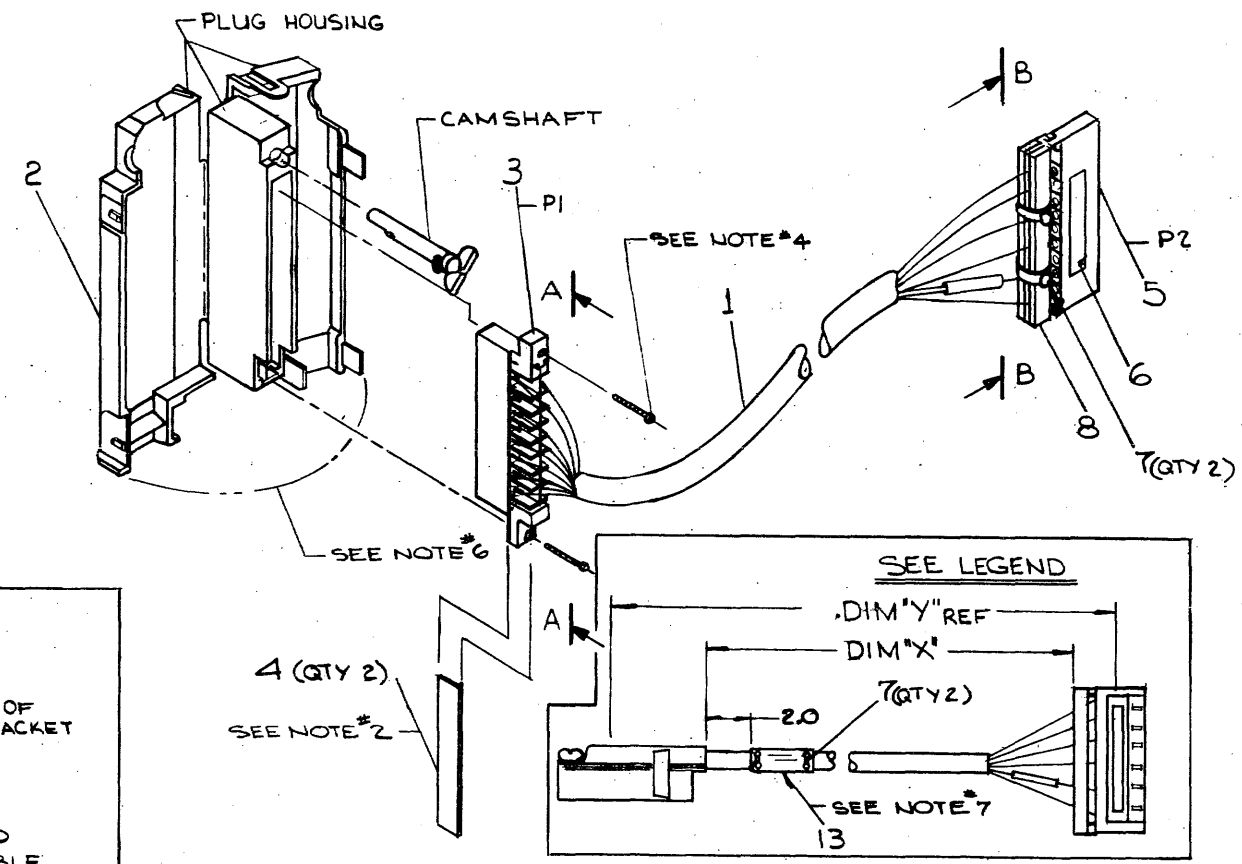
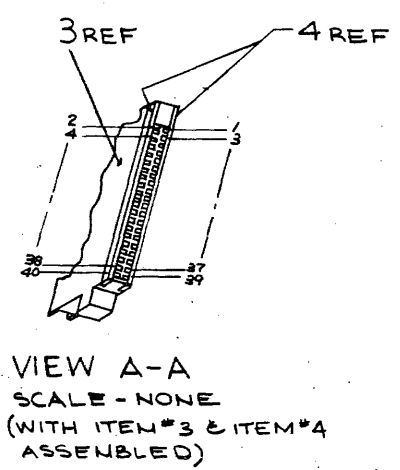
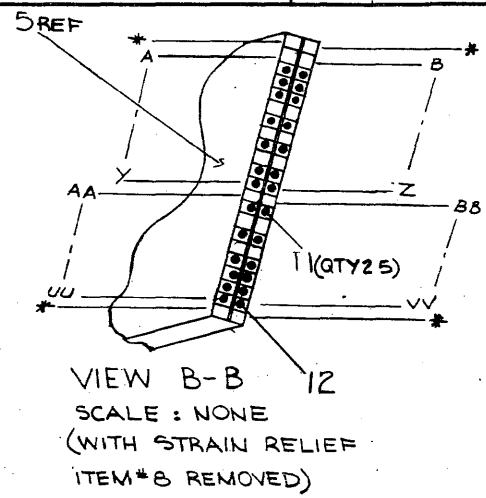
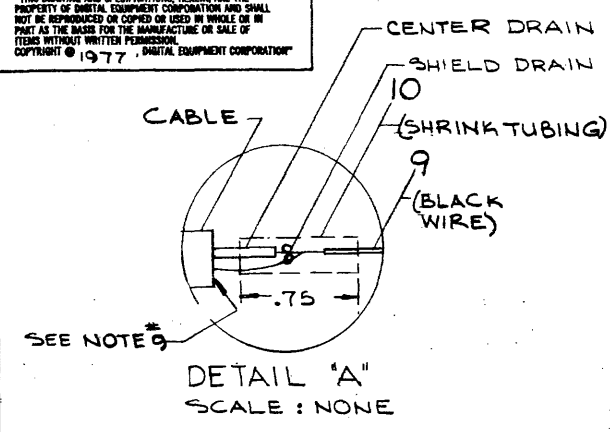
0-0-10808 M1a 2

LEGEND		
NUMBER	DIM"X" VARIATION	DIM"Y" (PRECUT) REF
BC80J-10	10FT-0IN. ± 2 IN.	10FT-4.50 IN.
BC80J-20	20FT-0IN. ± 3 IN.	20FT-4.50 IN.
BC80J-30	30FT-0IN. ± 6 IN.	30FT-4.50 IN.
BC80J-50	50FT-0IN. ± 1 FT.	50FT-4.50 IN.
BC80J-75	75FT-0IN. ± 1 FT. 6 IN.	75FT-4.50 IN.
BC80J-04	4 FT-0IN. ± 1 IN.	4 FT-4.50 IN.
BC80J-06	6 FT-0IN. ± 2 IN.	6 FT-4.50 IN.

**NOTE:**

- CUT CENTER & SHIELD DRAIN BACK TO 1.0 IN. FROM JACKET AND STRIP INSULATION OF CENTER DRAIN APPROXIMATELY .30 IN. THEN USING BLACK WIRE (ITEM 9) AND STRIPPING INSULATION ON ONE END APPROXIMATELY .30 IN. TWIST TOGETHER STRIPPED AREAS OF CENTER DRAIN AND BLACK WIRE ALONG WITH SHIELD DRAIN AND SOLDER CAREFULLY THEN APPLY SHRINK TUBING (ITEM 10) OVER SOLDERED AREA. (SEE DETAIL "A".)
- AFTER ASSEMBLING WIRES TO PLUG (PI) INSTALL CONTACT COVER (ITEM 4) OVER CONTACTS.
- CUT BACK WHT WIRE TO CABLE JACKET BOTH ENDS OF CABLE.
- SCREWS (#2 x .3 LG SELF TAPPING) ARE PART OF PLUG HOUSING AND CAMSHAFT KIT (ITEM #2)
- REF ONLY, CONTACT (DEC. PART # 1211591-27) FOR REPLACEMENT ONLY
- PRIOR TO SNAPPING SIDES OF PLUG HOUSING TOGETHER CARE SHOULD BE TAKEN TO ASSURE THAT ALL WIRES ARE SUFFICIENTLY WITHIN HOUSING TO PREVENT PINCHING OF INDIVIDUAL STRANDS
- CABLE TO BE MARKED WITH PART NUMBER BC80J & REV IN AREA SHOWN
- \* DENOTES CAVITIES NOT TO BE USED OR DESIGNATED BY LETTERS
- ALTERNATE PART NO. FOR ITEM #1 (1700051-01) IS 1700051-00. WHEN USING THIS ALTERNATE PART CUT OFF UNUSED CONDUCTORS AT BOTH ENDS OF CABLE JACKET.

FOR WIRE TABLE SEE SHEET #2



FOR PARTS LIST SEE K-PL-BC80J-0-0

REV.	DESCRIPTION

QUANTITY & VARIATION	DRN: <i>[Signature]</i>	DATE: 77	FIRST USED ON: RL8A
	CHK'D: <i>[Signature]</i>	ENG: <i>[Signature]</i>	PROD: <i>[Signature]</i>
REMOVE BURRS AND BREAK SHARP CORNERS	TITLE: CABLE CONTROLLER (RL8A)		
DO NOT SCALE DWG	NEXT HIGHER ASSY:		
MATERIAL SEE PARTS LIST	E-UA-RL8A-0	SIZE CODE: D	NUMBER: UA BC80J-0-0
FINISH	SCALE: 1	SHEET: 1	OF 2

DUA BC80J-0-0

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WIRE TABLE									
ITEM NO.	WIRE LENGTH TO CABLE JACKET	DESCRIPTION		FROM		TO		SIGNAL NAME	REMARKS
		TWP	COLOK	CONN	TERM	CONN	TEKM		
1				PI-1		P2-A			NO CONN
				PI-2		P2-B			
	2.50	TWP	RED	PI-3		P2-C	ITEM#11	DRV ERR +	
	2.50	TWP	WHT/RED	PI-4		P2-D		DRV ERR -	
	2.38	TWP	RED	PI-5		P2-E		DRV RDY +	
	2.38	TWP	WHT/GRN	PI-6		P2-F		DRV RDY -	
	2.25	TWP	RED	PI-7		P2-H		SEC PLS +	
	2.25	TWP	WHT/ORN	PI-8		P2-J	ITEM#11	SEC PLS -	
				PI-9		P2-K			NO CONN
				PI-10		P2-L			
	2.00	TWP	RED	PI-11		P2-M	ITEM#11	STAT CLK +	
	2.00	TWP	WHT/YEL	PI-12		P2-N	ITEM#11	STAT CLK -	
				PI-13		P2-P			NO CONN
				PI-14		P2-R			
	1.75	TWP	RED	PI-15		P2-S	ITEM#11	STAT IN +	
	1.75	TWP	WHT/BLK/RED	PI-16		P2-T	ITEM#11	STAT IN -	
				PI-17		P2-U			NO CONN
				PI-18		P2-V			
	1.62	TWP	RED	PI-19		P2-W	ITEM#11	READ DATA +	
	1.62	TWP	WHT/BLK/ORN	PI-20		P2-X		READ DATA -	
	1.50	TWP	RED	PI-21		P2-Y		DRIVE CMND +	
	1.50	TWP	WHT/BLK/BLU	PI-22		P2-Z	ITEM#11	DRIVE CMND -	

WIRE TABLE									
ITEM NO.	WIRE LENGTH TO CABLE JACKET	DESCRIPTION		FROM		TO		SIGNAL NAME	REMARKS
		TWP	COLOR	CONN	TERM	CONN	TERM		
1				PI-23		P2-AA			NO CONN
				PI-24		P2-BB			
	1.38	TWP	RED	PI-25		P2-CC	ITEM#11	WRT DATA -	
	1.38	TWP	WHT/BLK/BRN	PI-26		P2-DD	ITEM#11	WRT DATA +	
				PI-27		P2-EE			NO CONN
				PI-28		P2-FF			
	1.25	TWP	RED	PI-29		P2-HH	ITEM#11	SYS CLK -	
	1.25	TWP	WHT/GRN/RED	PI-30		P2-JJ	ITEM#11	SYS CLK +	
				PI-31		P2-KK			NO CONN
				PI-32		P2-LL			
	1.13	TWP	RED	PI-33		P2-MM	ITEM#11	WRT GATE -	
	1.13	TWP	WHT/GRN/BLU	PI-34		P2-NN		WRT GATE +	
	1.00	TWP	RED	PI-35		P2-PP		DRV SEL I -	
	1.00	TWP	WHT/GRN/YEL	PI-36		P2-RR		DRV SEL I +	
	.88	TWP	RED	PI-37		P2-SS		DRV SEL 0 -	
	.88	TWP	WHT/GRN/BLU	PI-38		P2-TT		DRV SEL 0 +	
	.75	TWP	YEL	PI-39		P2-UU	ITEM#11	DC OK	
			WHT						SEE NOTE 3
	1.75		BLK	PI-40		P2-VV	ITEM#12	GND	SEE DETAIL #1 & NOTE 1

REVISIONS		
CHK	CHANGE NO.	REV.

REV. 1  
DUA BC80J-0-0

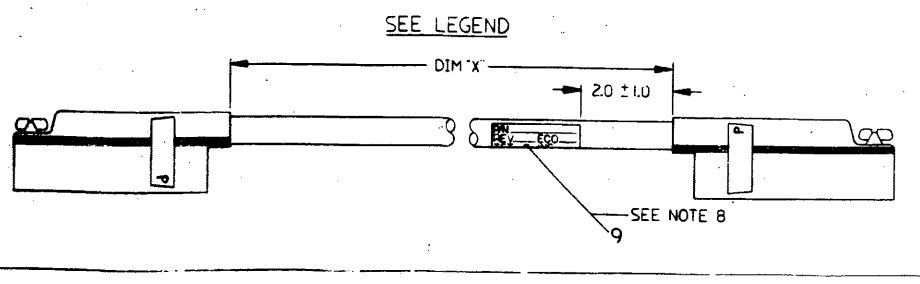
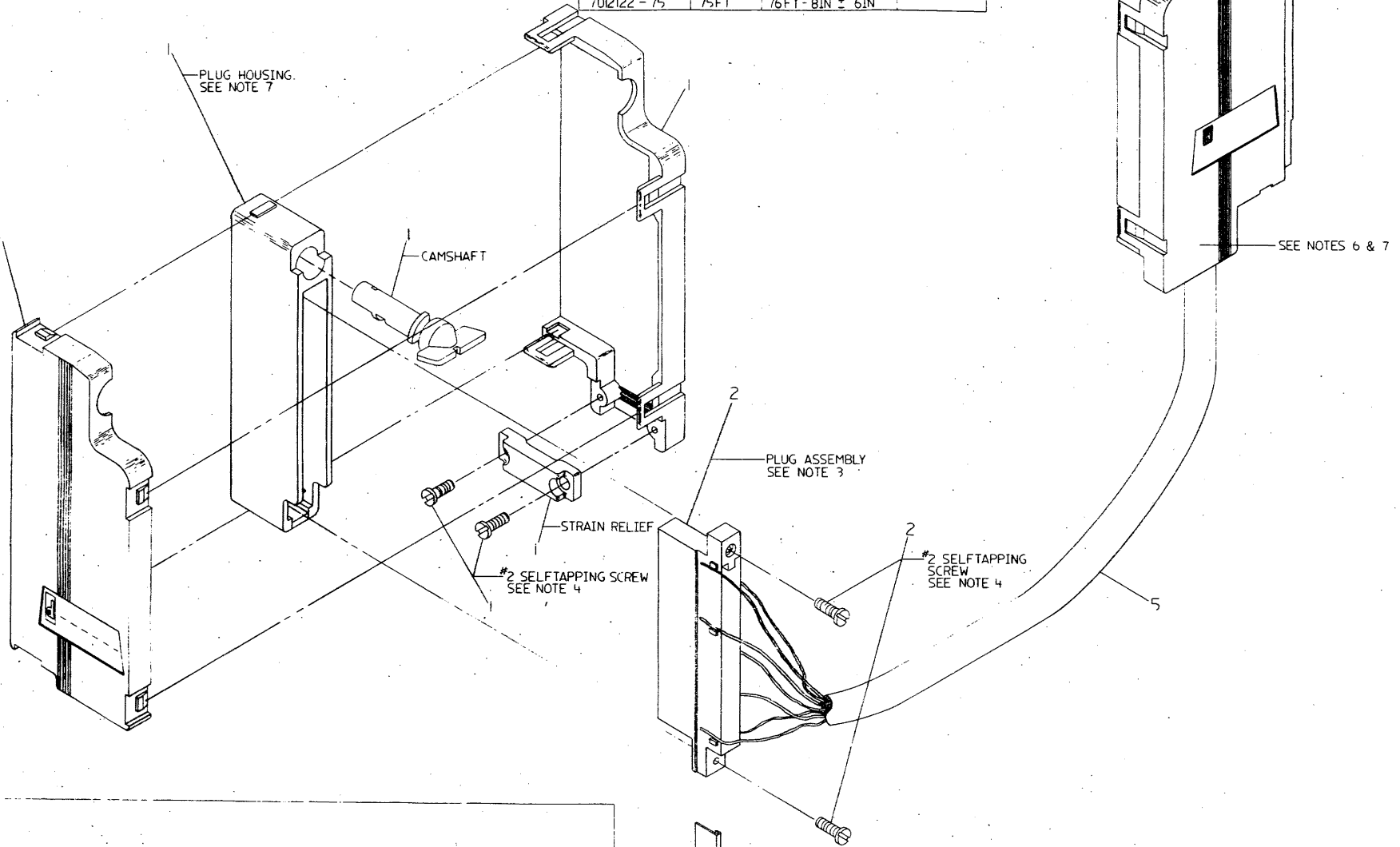
7012122-0000

**LEGEND**

NUMBER	DIM 'X'	PRE-CUT LENGTH	REMARKS
7012122-06	6 FT	7 FT-8 IN ± 2 IN	
7012122-08	8 FT	9 FT-8 IN ± 2 IN	
7012122-10	10 FT	11 FT-8 IN ± 2 IN	
7012122-12	12 FT	13 FT-8 IN ± 3 IN	
7012122-20	20 FT	21 FT-8 IN ± 3 IN	
7012122-25	25 FT	26 FT-8 IN ± 3 IN	
7012122-30	30 FT	31 FT-8 IN ± 6 IN	
7012122-40	40 FT	41 FT-8 IN ± 6 IN	
7012122-50	50 FT	51 FT-8 IN ± 6 IN	
7012122-60	60 FT	61 FT-8 IN ± 6 IN	
7012122-75	75 FT	76 FT-8 IN ± 6 IN	

**NOTES:**

1. "CUT AND REMOVE 9.0 ± .5 INCHES OF THE OUTER CABLE JACKET FROM BOTH ENDS OF CABLE. CAUTION: DO NOT CUT OR NICK DRAIN WIRE UNDER OUTER JACKET. REMOVE THE MYLAR WRAP AND ALUMINUM SHIELD FLUSH TO JACKET."
2. "AMP SEMI-AUTOMATIC INSERTION MACHINES (CHAMPOMATOR OR CHAMPATIC) MUST BE USED TO TERMINATE THE LEADS TO PLUG ASSEMBLY ITEM 2. THE STANDARD CABLE CLAMP SUPPLIED WITH THE AMP MACHINES MAY REQUIRE MODIFYING TO POSITION CABLE, ITEM 5, TO PLUG ASSEMBLY, ITEM 2. PER DETAIL B. AFTER ASSEMBLY OF WIRES TO PLUG, INSTALL COVER, ITEM 3, TO EACH SIDE OF PLUG."
3. "THE DRAIN WIRE AND INNER GND WIRE MUST BE PREPARED AS FOLLOWS BEFORE TERMINATING CABLE TO PLUG. THESE PROCEDURES ARE DESCRIBED IN DEC ASSEMBLY PROCESSES FOR THIS ASSEMBLY. A SIGNED DISCLOSURE STATEMENT IS REQUIRED TO OBTAIN COPIES OF ANY DEC PROCESS SPECIFICATION."
- 3.1 "CUT BACK THE CENTER BLACK GND WIRE .4 ± .1 INCH ABOVE JACKET, STRIP END .25 ± .06 INCH."
- 3.2 "FIND AND SEPARATE THE SOLID WHITE AND YELLOW PAIRED WIRES. CUT THE WHITE WIRE FLUSH WITH JACKET. STRIP END OF LOOSE WHITE WIRE .25 ± .06 INCH."
- 3.3 "POSITION STRIPPED END OF WHITE WIRE PARALLEL TO THE STRIPPED END OF THE BLACK GND WIRE. WRAP THE DRAIN WIRE AROUND THE STRIPPED END OF THE BLACK AND WHITE WIRE 2-4 TIMES. SOLDER WIRE SPLICE AND CUT OFF END OF DRAIN FLUSH WITH SPLICE."
- 3.4 "COVER SPLICE WITH 0.5 ± .06 INCH OF SHRINK TUBING. ITEM 4, TWIST THE WHITE AND YELLOW WIRES (PREVIOUSLY SEPARATED) BACK TOGETHER FOR APPROXIMATELY (3) THREE INCHES."
4. "SCREWS (2 X .31 S.T.) ARE PART OF ITEM 1. TORQUE SCREWS TO 2.5 ± .5 IN/LBS CABLE CLAMP SHOULD BE CLAMPED IN POSITION BEFORE INSTALLING SCREWS. CABLE CLAMP MUST BE FLUSH TO HOUSING BOTH SIDES."
5. "ACTIVE CONTACT (DEC 1211501-27) AND BLACK 28 AWG WIRE (DEC 9107769-00) IS FOR PRODUCTION REPAIR ONLY. REF AMP CONTACT (66555-3 L.P.) HARD CRIMP TOOL (90209-1) EXTRACTION TOOL(91111-1)."
6. "BAG, ITEM 8, TO BE INSTALLED OVER EACH CONNECTOR AND SECURED AFTER COMPLETION OF ASSEMBLY."
7. "PRIOR TO SHAPPING SIDES OF HOUSING TOGETHER, ASSURE THAT ALL WIRES ARE WELL WITHIN HOUSING."
8. "LABEL, ITEM 9, TO CONTAIN:  
ASSEMBLY P/N  
REVISION (LEVEL)  
MFG (PLACE OF BUILD) DATE (OF MFG)  
TEST (STAMP) INSP. (STAMP)"
9. "DEC STANDARD 116 (WORKMANSHIP) APPLIED TO THIS ASSEMBLY."
10. "MARK SHIPPING CONTAINER AS TO:  
ASSEMBLY NO.  
REVISION (LEVEL)  
MFG BY  
DATE  
QTY"



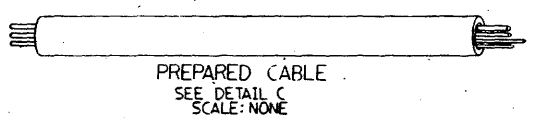
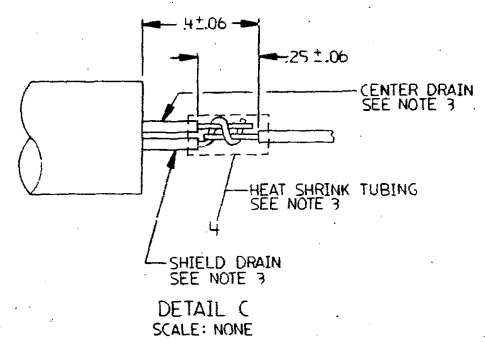
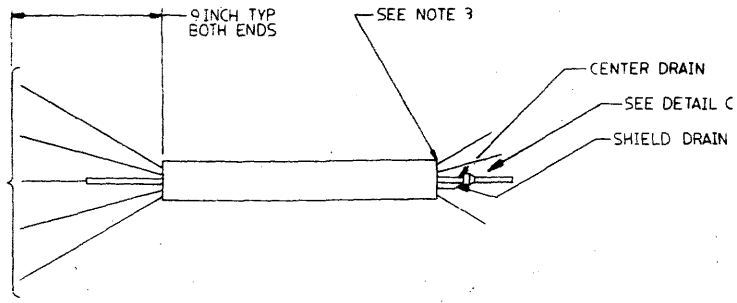
CAUTION: OFF SHEET PARTS LIST EXISTS. SEE K-PL-7012122-0-DBP (21758)

QUANTITY & VARIATION	DESCRIPTION		PART NO.	QTY REQD.
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			
1	ACTIVE CONTACT	DEC 1211501-27	1	1
1	BLACK WIRE	DEC 9107769-00	1	1
1	CONTACT COVER	SEE NOTE 2	3	4
1	PLUG ASSEMBLY	SEE NOTE 3	1	1
1	PLUG HOUSING	SEE NOTE 7	1	1
1	STRAP	SEE NOTE 8	1	1
1	STRAP	SEE NOTE 8	1	1

TITLE: I/O CABLE ASSEMBLY  
 DATE: 7-10-78  
 SCALE: 1:1  
 SHEET: 8 OF 8  
 PART NO.: 7012122-0-00

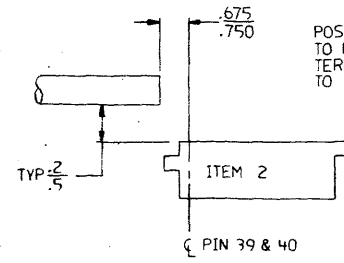
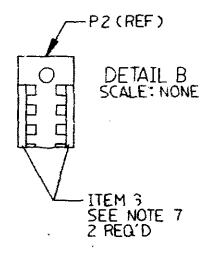
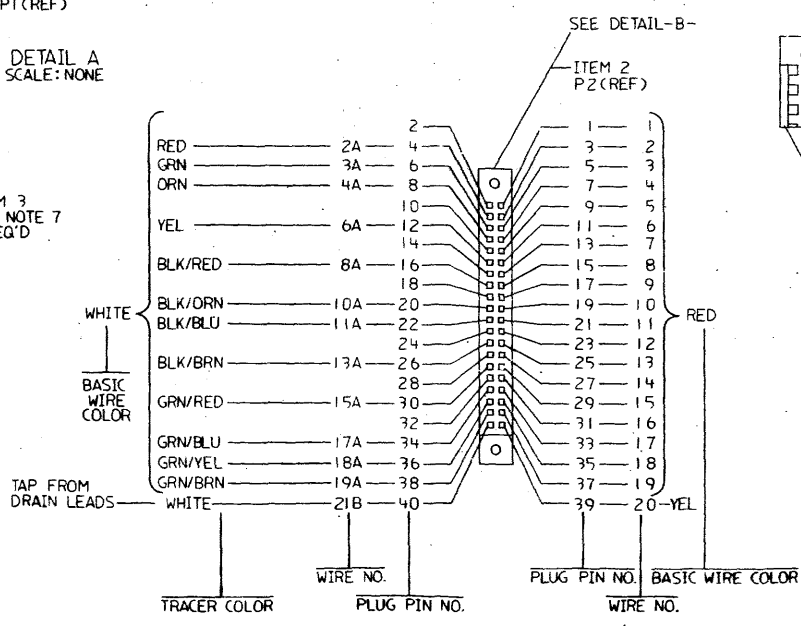
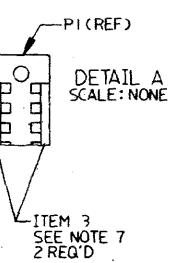
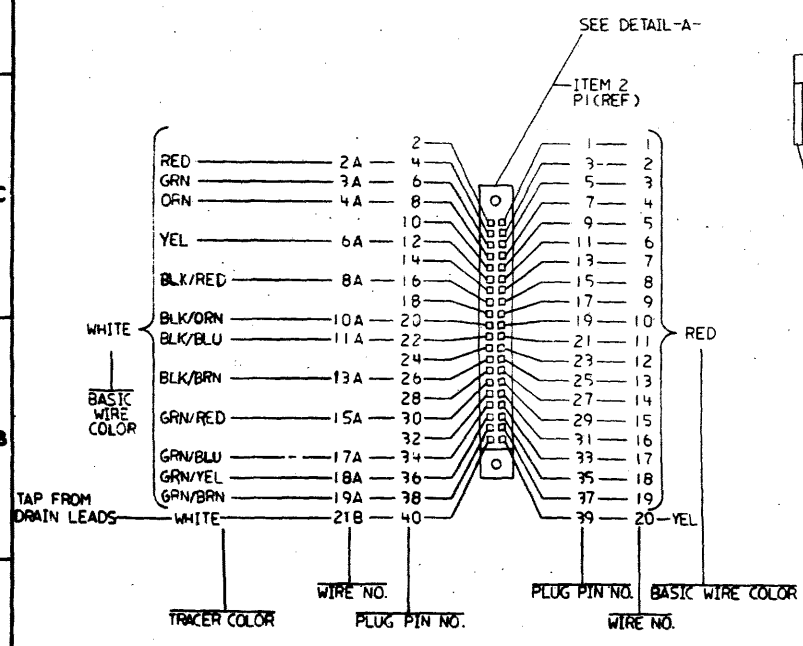
REV	DESCRIPTION	DATE
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2	7012122-0001	7/10/78
3	7012122-0002	7/10/78
4	7012122-0003	7/10/78
5	7012122-0004	7/10/78
6	7012122-0005	7/10/78
7	7012122-0006	7/10/78
8	7012122-0007	7/10/78
9	7012122-0008	7/10/78
10	7012122-0009	7/10/78

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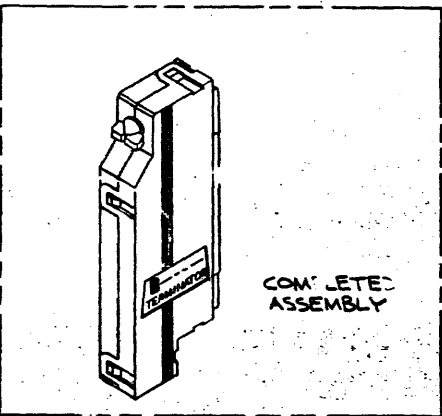
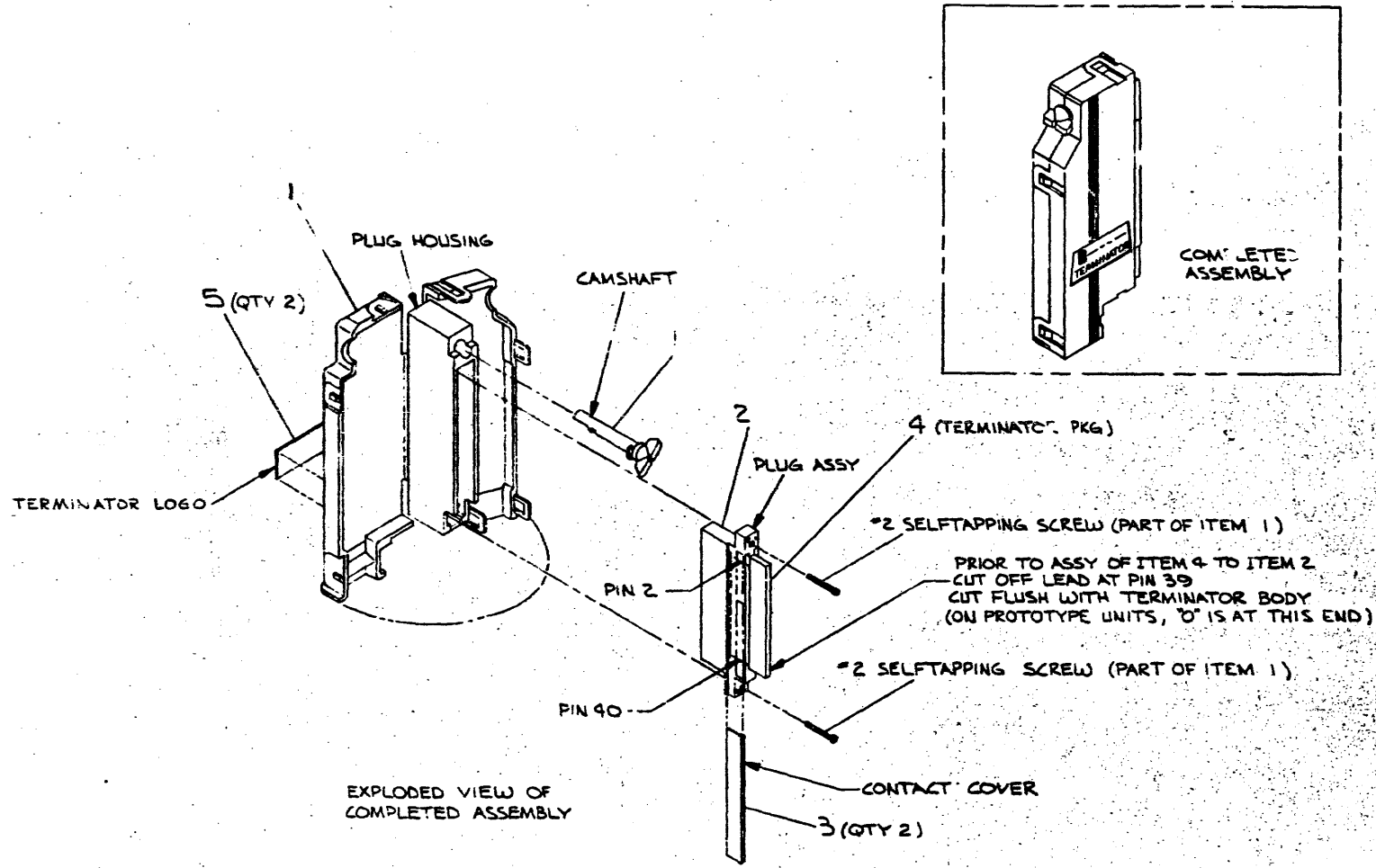
WIRE TABLE							
WIRE NO.	FROM CONNECTOR PLUG	PLUG PIN NO.	BASIC WIRE COLOR	WITH TRACER COLOR	TO CONNECTOR PLUG	PLUG PIN NO.	REMARKS
1							TWISTED PAIR
1A							
2	P1	3	RED	---	P2	3	
2A		4	WHT	RED		4	
3		5	RED	---		5	
3A		6	WHT	GRN		6	
4		7	RED	---		7	
4A		8	WHT	ORN		8	
5							
5A							
6		11	RED	---		11	
6A		12	WHT	YEL		12	
7							
7A							
8		15	RED	---		15	
8A		16	WHT	BLK/RED		16	
9							
9A							
10		19	RED	---		19	
10A		20	WHT	BLK/ORN		20	
11		21	RED	---		21	
11A		22	WHT	BLK/BLU		22	
12							
12A							
13		25	RED	---		25	
13A		26	WHT	BLK/BRN		26	
14							
14A							
15		29	RED	---		29	
15A		30	WHT	GRN/RED		30	
16							
16A							
17		33	RED	---		33	
17A		34	WHT	GRN/BLU		34	
18		35	RED	---		35	
18A		36	WHT	GRN/YEL		36	
19		37	RED	---		37	TWISTED PAIR
19A		38	WHT	GRN/BRN		38	
20		39	YEL	---		39	
20A		---	WHT	---		---	
21	P1	SEE 21B	WHT	---	P2	SEE 21B	SHIELD DRAIN
21A							CENTER DRAIN WIRE
21B	P1	40	WHT	---	P2	40	GND WIRE

CUT WIRE NO. 20A, OFF AT JACKET (SEE NOTE 3)  
JUMP SHIELD & CENTER DRAIN TOGETHER PER DETAIL-C & TERMINATE WHT WIRE (21B) IN PIN 40.



POSITION OF CABLE (ITEM 2) TO PLUG (ITEM 2) BEFORE TERMINATING CABLE LEADS TO PLUG.

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2	LOGO, TERMINATOR	A-DC-7116678-0-0	3
1	TERMINATOR PKG	1313242-00	4
2	COVER, CONTACT	1211591-11	3
1	PLUG ASSY	1211591-07	2
1	CONTACT PLUG W/SCREW & CAMSHAFT KIT	1211591-34	1

DESCRIPTION		QTY	PART NO.	ITEM NO.
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES				
TOLERANCE DIMENSION RANGE (INCHES)				
DIMENSION	CLASSIFICATION	FRAC	DEC	ANG
	PRECISION	1.000	0.002	0.005
SURFACE FINISH	PRECISION	0.001	0.002	0.005
	PREFERRED	0.001	0.002	0.005

	DIRECT: <i>[Signature]</i> CHECKED: <i>[Signature]</i> ENG'D: <i>[Signature]</i> PROJ. ENGR: <i>[Signature]</i> PROJ. DATE: <i>6/6/76</i>	FIRST USED ON: <b>PK06</b> TITLE: <b>TERMINATOR ASSY</b>
DO NOT SCALE DIMS MATERIAL: <b>E-1A-RK611-0-0</b> FINISH: <b>SEE PARTS LIST</b>	NEXT HIGHER ASSY: SCALE: NONE SHEET: 1 OF 1	SIZE: <b>D</b> CODE: <b>TA7012293-0-0 A</b> NUMBER: <b>1</b> REV.

REV. NO.	REV. DATE	BY
1	7/23/76	W. DUNHAM