



RECOMMENDED PC BOARD MOUNTING DIMENSIONS
 CONNECTOR SIDE OF PC BOARD

- △ RECOMMENDATIONS FOR 2.36 [.093] TO 3.18 [.125] THICK PC BOARD:
 - A. HOLE DIAMETER AFTER DRILLING = 1.15±0.03 [.045±0.01].
 - B. HOLE DIAMETER AFTER TIN-LEAD PLATING = 0.94 [.037] - 1.09 [.043].
 - C. HOLE DIAMETER AFTER REFLOW = 0.91 [.036] - 1.09 [.043].
 - D. PC BOARD PLATING TO BE 7.62µm [.000300] MIN TIN-LEAD OVER 0.05±0.03 [.002±0.01] COPPER.
- △ MOLDED PARTS: NYLON OR POLYESTER, UL 94V-0 RATED, BLACK.
- △ CONTACTS: COPPER ALLOY.
- △ SHELL: CARBON STEEL.
- △ INSERTS: BRASS.
- △ SCREWLOCK: ZINC.
- △ OBSOLETE PART NUMBER.
- △ GOLD FLASH FOR A LENGTH OF 3.81 [.150] MIN FROM MATING END, 2.54µm [.000100] MIN TIN OR TIN-LEAD FOR A LENGTH OF 5.79 [.228] MIN FROM OPPOSITE END, BOTH OVER 1.27µm [.000050] MIN NICKEL.
- △ GOLD PLATED FOR A LENGTH OF 3.81 [.150] MIN FROM MATING END, 0.76µm [.000030] MIN GOLD IN MATED AREA. 2.54µm [.000100] MIN TIN OR TIN-LEAD FOR A LENGTH OF 5.79 [.228] MIN FROM OPPOSITE END, BOTH OVER 1.27µm [.000050] MIN NICKEL.
- △ SHELL: 5.08µm [.000200] MIN TIN-LEAD OVER 2.54µm [.000100] MIN COPPER.
- △ DATUMS AND BASIC DIMENSIONS ESTABLISHED BY CUSTOMER.

SEE DETAIL L	△	△	748146-6
SEE DETAIL L	△	△	748146-5
SEE DETAIL K	△	△	748146-4
SEE DETAIL K	△	△	748146-3
AS SHOWN	△	△	748146-2
AS SHOWN	△	△	748146-1
SUPERSEDED BY 748146-2			
MOUNTING TYPE	CONTACT FINISH	PART NUMBER	

THIS DRAWING IS A CONTROLLED DOCUMENT.		DIN L/SIPE 04/23/92	Tyco Electronics Corporation Harrisburg, PA 17105-3608
DIMENSIONS: mm [INCHES]		CHK R.STONE 4-24-92	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD -	NAME
0 PLC ± - 1 PLC ± - 2 PLC ± 0.13 [.005] 3 PLC ± - 4 PLC ± - ANGLES ± -		PRODUCT SPEC 108-40025	PLUG ASSEMBLY, SIZE 3, 25 POSITION, ACTION PIN, W/FRONT METAL SHELL, .093/.125 PCB, AMPLIMITE
MATERIAL FINISH		APPLICATION SPEC 114-40023	SIZE 114-40023
CONTACTS: SEE TABLE		WEIGHT -	SCALE 4:1
		CUSTOMER DRAWING	SHEET 1 OF 1 REV M