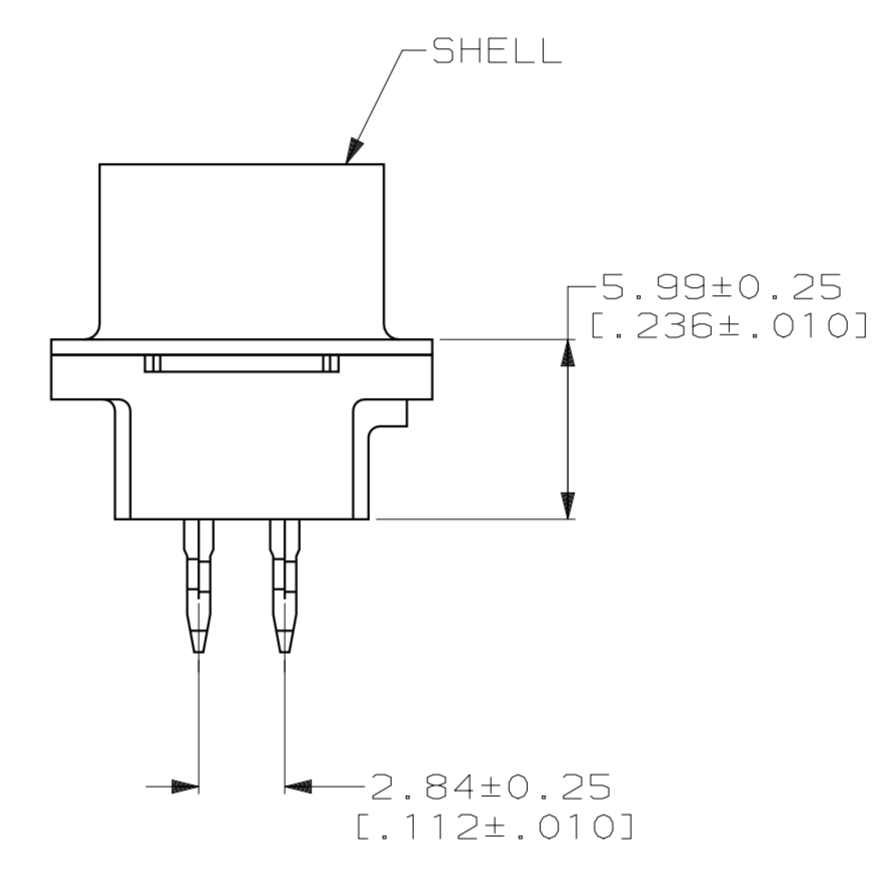
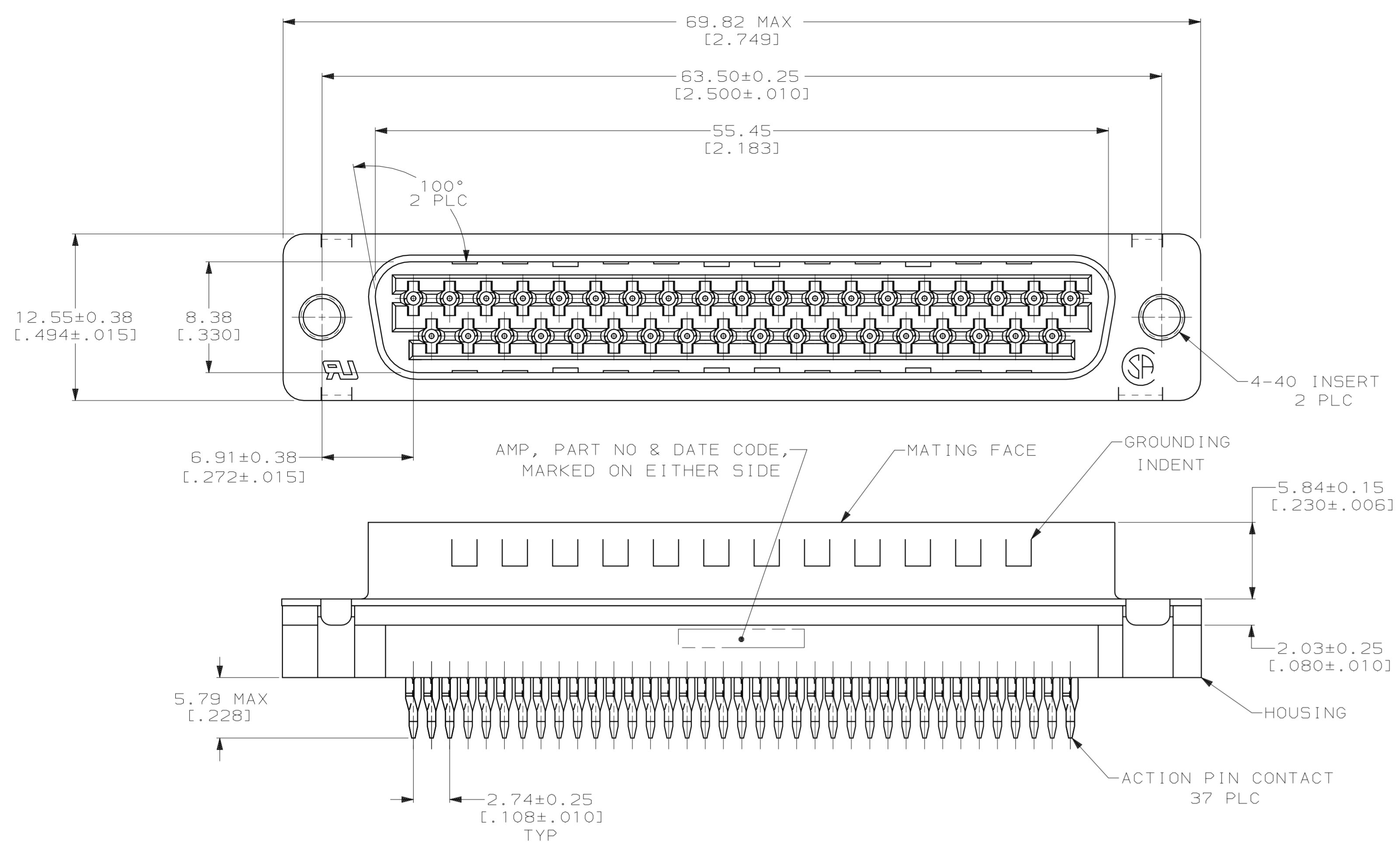
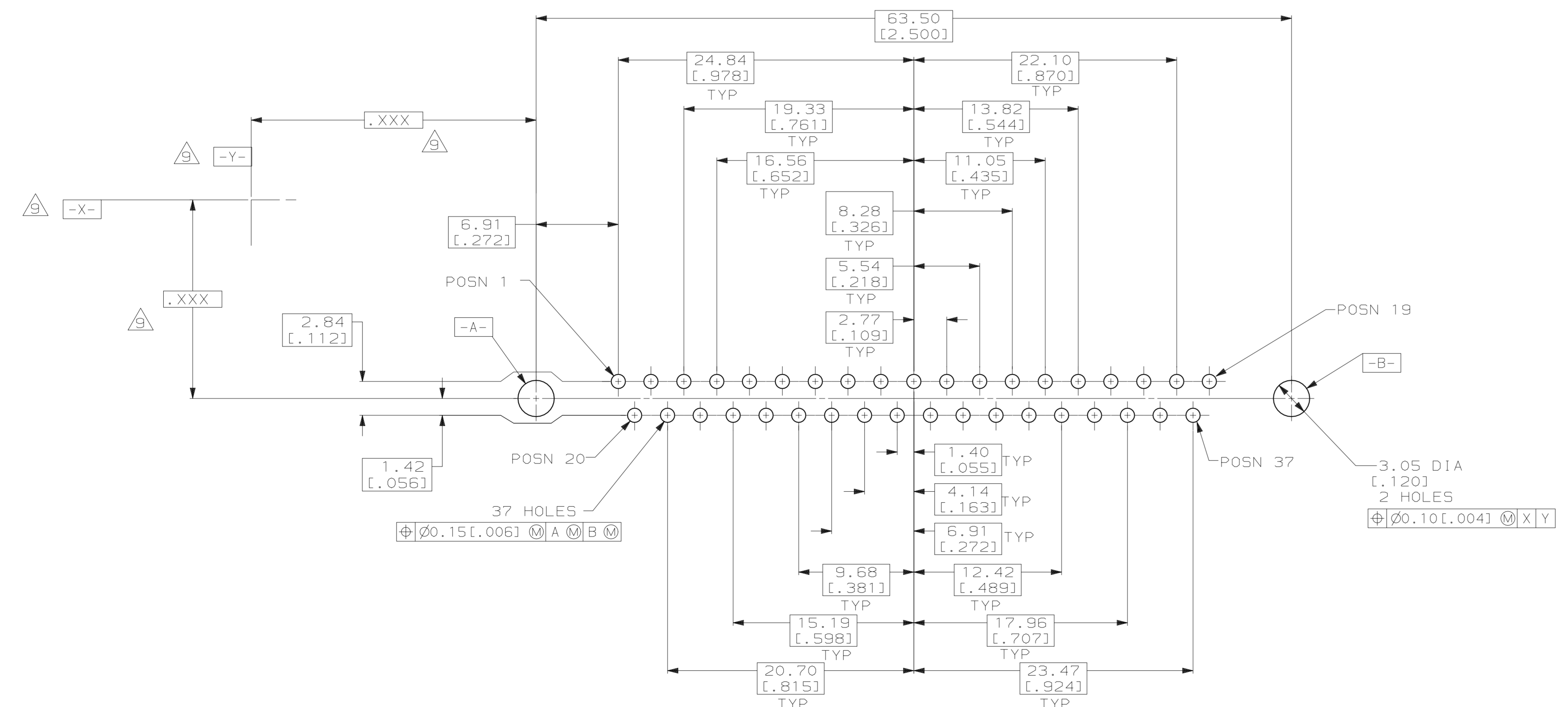


LOC		DIST		P		F		ZONE		LTR		REVISIONS		
BD	77											DESCRIPTION	DATE	APPD
												RLSE PER NPR 4341 WAS 92-4913-17	9-3-92	-
												REV PER EC 0020-24-94	03/30/94	MP
												REV PER EC 0320-288-97	08 SEP 97	A0
												REV PER EC 0640-448-98	01 MAR 99	RT



- RECOMMENDATIONS FOR 2.36 [0.093] MIN THICK PC BOARD:
- A. HOLE DIAMETER AFTER DRILLING = 1.14±0.03 [0.045±.001].
 - B. HOLE DIAMETER AFTER TIN-LEAD PLATING = 0.94-1.09 [0.037-.043].
 - C. HOLE DIAMETER AFTER REFLOW = 0.91-1.09 [0.036-.043].
 - D. PC BOARD PLATING TO BE 7.62μm [0.000300] MIN TIN-LEAD OVER 0.05±0.03 [0.002±.001] COPPER.
- 2 NYLON OR POLYESTER, UL 94V-0 RATED, GLASS FILLED, BLACK.
 - 3 COPPER ALLOY PER ASTM B 122.
 - 4 CARBON STEEL PER ASTM A 109.
 - 5 BRASS PER QQ-B-626.
 - 6 GOLD PLATING PER MIL-G-45204, NICKEL PLATING PER QQ-N-290, TIN PLATING PER MIL-T-10727, COPPER PLATING PER MIL-C-14550.
 - 7 5.08μm [0.000200] MIN TIN OR TIN-LEAD OVER 2.54μm [0.000100] MIN COPPER.
 - 8 GOLD PLATED FOR A LENGTH OF 3.81 [0.150] MIN FROM MATING END, 0.76μm [0.000030] MIN GOLD IN MATED AREA. 2.54μm [0.000100] MIN TIN-LEAD FOR A LENGTH OF 5.79 [0.228] MIN FROM OPPOSITE END, BOTH OVER 1.27μm [0.000050] MIN NICKEL.
 - 9 DATUMS AND BASIC DIMENSIONS ESTABLISHED BY CUSTOMERS.



RECOMMENDED PC BOARD MOUNTING DIMENSIONS
 CONNECTOR SIDE OF BOARD

THIS DRAWING IS A CONTROLLED DOCUMENT FOR AMP INCORPORATED. IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONTACTED FOR THE LATEST REVISION.

DO NOT SCALE PRINT. UNLESS SPECIFIED DIMENSIONS IN mm [INCHES] TOLERANCES ON: 2 PLC DEC ± 0.13 (0.005) 3 PLC DEC ± - ANGLES ± 2°		DR 9-3-92 H MOLL CHK 9-8-92 R STONE APPD 9-8-92 M PERCHERKE APPD 9-8-92 W PARKER	786534-1 PART NO	
MATERIAL HOUSING: 2 CONTACTS: 3 INSERTS: 5 FINISH: 6 CONTACTS: 8	SHELL: 4 SHELL: 7	PRODUCT SPEC 108-40014 APPLICATION SPEC -	AMP AMP Incorporated Harrisburg, PA 17105-3608	
NAME PLUG ASSEMBLY, SIZE 4, 37 POSITION, MEDIUM PROFILE, ACTION PIN™, FRONT METAL SHELL, AMPLIMITE™ HD-20			SIZE D	CAGE CODE 00779
DRAWING NO 786534			SCALE 4:1	SHEET 1 OF 1