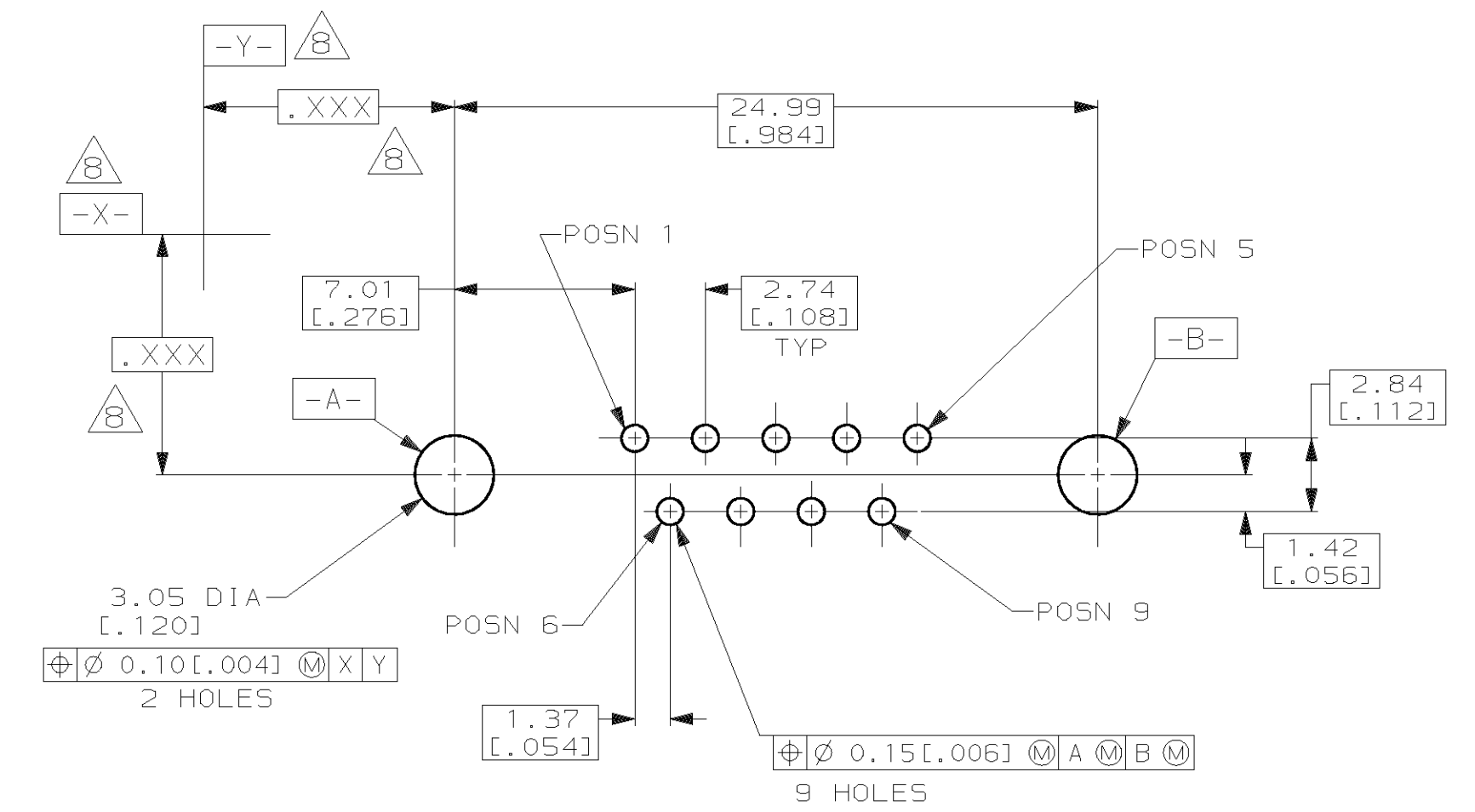
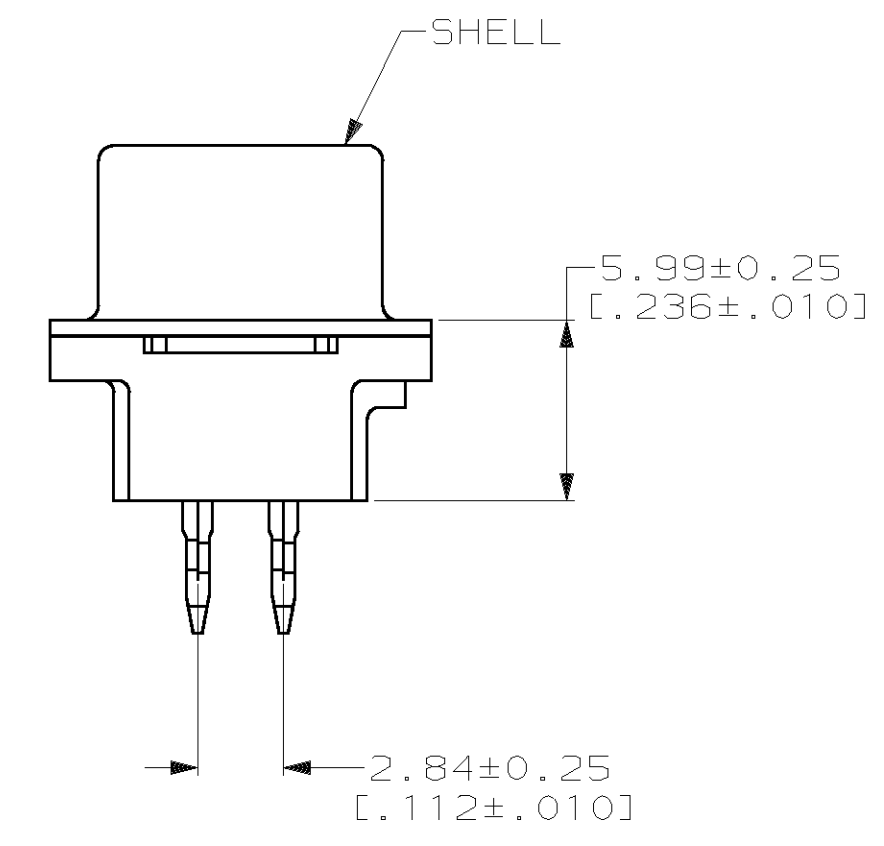
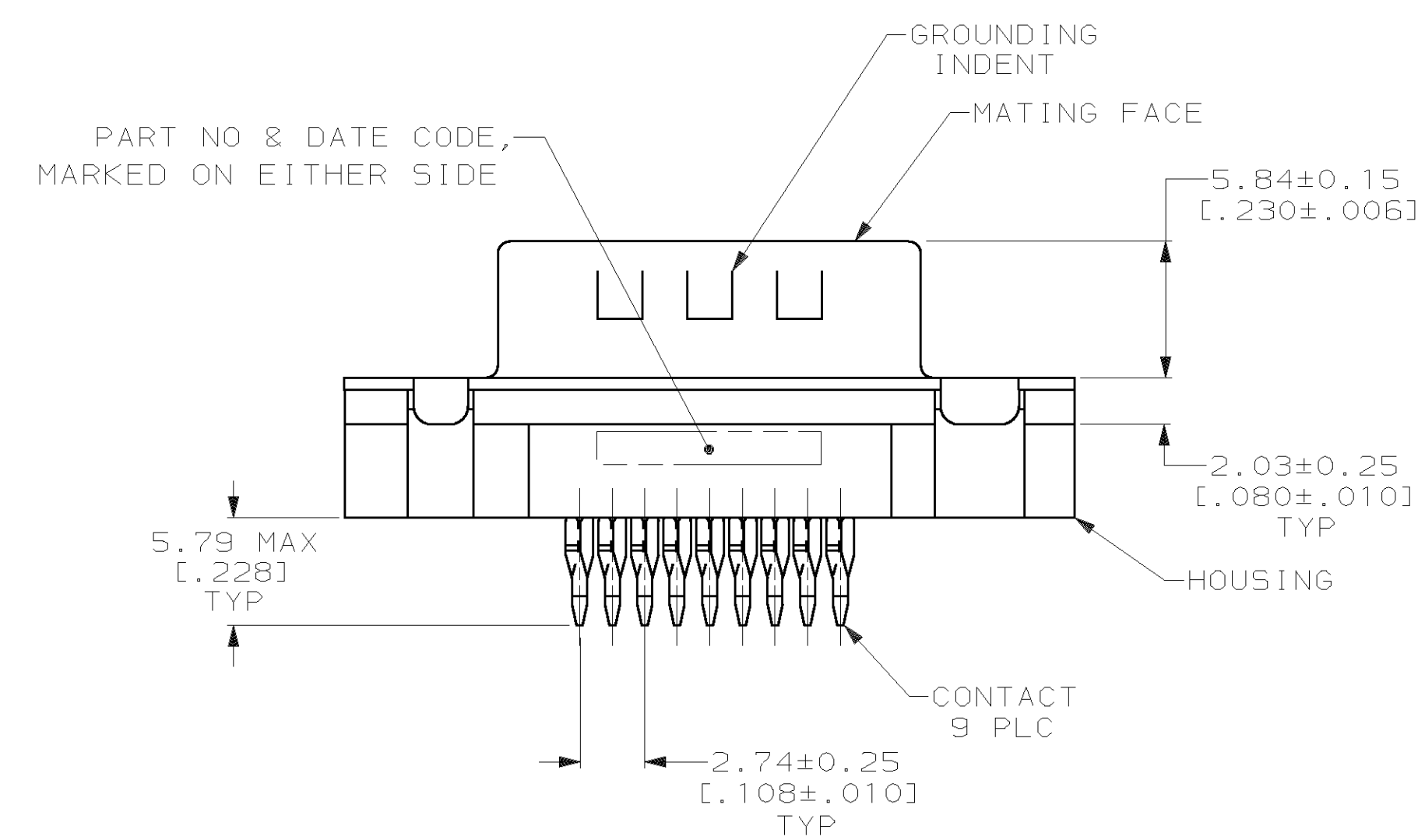
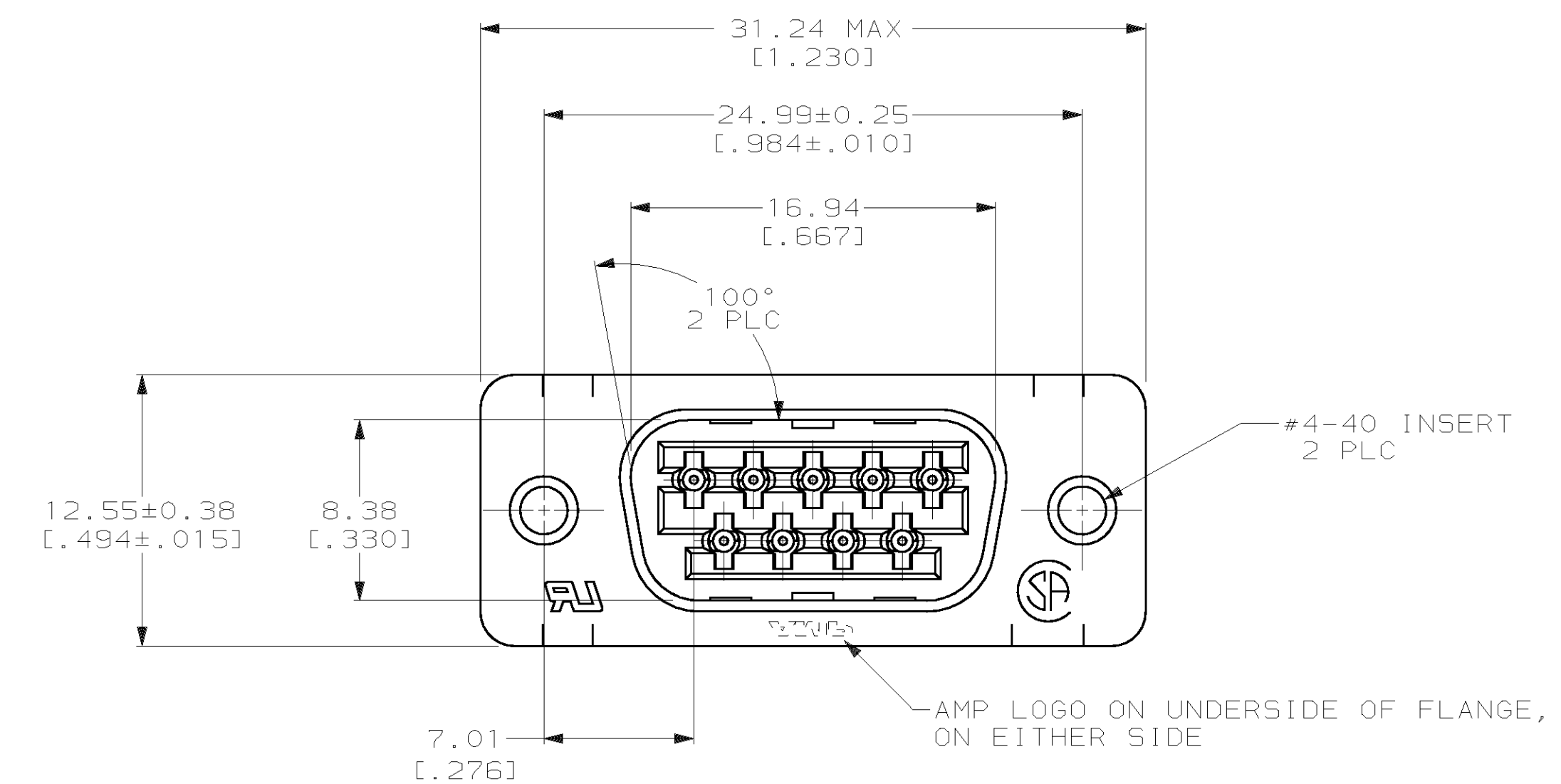


LOC	DIST	P	F	ZONE	LTR	DESCRIPTION	DATE	APPD
BD	77							
						0 RLSE PER NPR 4667, WAS 93-4913-1	3-24-93	-
						A REVISED PER EC 0020-1556-93	01/26/94	MP
						B REV PER EC 0320-288-97	08 SEP 97	A0
						C REV PER EC 0640-448-98	01 MAR 99	RT



RECOMMENDED PC BOARD LAYOUT ①
 CONNECTOR SIDE OF BOARD

- ① RECOMMENDATIONS FOR 2.36 [0.093] MIN THICK PC BOARD:
 - A. HOLE DIAMETER AFTER DRILLING = 1.151±0.025 [0.0453±.0010].
 - B. HOLE DIAMETER AFTER TIN-LEAD PLATING = 0.94 [0.037]-1.09 [0.043].
 - C. HOLE DIAMETER AFTER REFLOW = 0.91 [0.036]-1.09 [0.043].
 - D. PC BOARD PLATING TO BE 0.76µm [0.000300] MIN TIN-LEAD OVER 0.05±0.03 [0.002±.001] COPPER.
- ② NYLON, UL 94V-0 RATED, BLACK.
- ③ COPPER ALLOY PER ASTM B122.
- ④ CARBON STEEL PER ASTM A109.
- ⑤ GOLD PLATING PER MIL-G-45204; NICKEL PLATING PER QQ-N-290; TIN PLATING PER MIL-T-10727; COPPER PLATING PER MIL-C-14550.
- ⑥ 5.08µm [0.000200] MIN TIN OVER 2.54µm [0.000100] MIN COPPER.
- ⑦ 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.
- ⑧ DATUMS AND BASIC DIMENSIONS ESTABLISHED BY CUSTOMER.

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 3-24-93 W.G.LENKER	AMP AMP Incorporated Harrisburg, PA 17105-3508		
CHK 4-5-93 R.STONE		APPD 4-6-93 M.PERCHERKE			
MATERIAL HOUSING: ② CONTACTS: ③		APPD 4-6-93 W.PARKER	NAME		
SHELL: ④ INSERTS: BRASS		PRODUCT SPEC 108-40014	PLUG ASSEMBLY, SIZE 1, 9 POSITION, MEDIUM PROFILE, ACTION PIN™, AMPLIMITE™ HD-20		
FINISH ⑤		APPLICATION SPEC 114-40026	SIZE D	CAGE CODE 00779	DRAWING NO C=786830
SHELL: ⑥ CONTACTS: ⑦		WEIGHT -	SCALE 4:1	SHEET 1 OF 1	