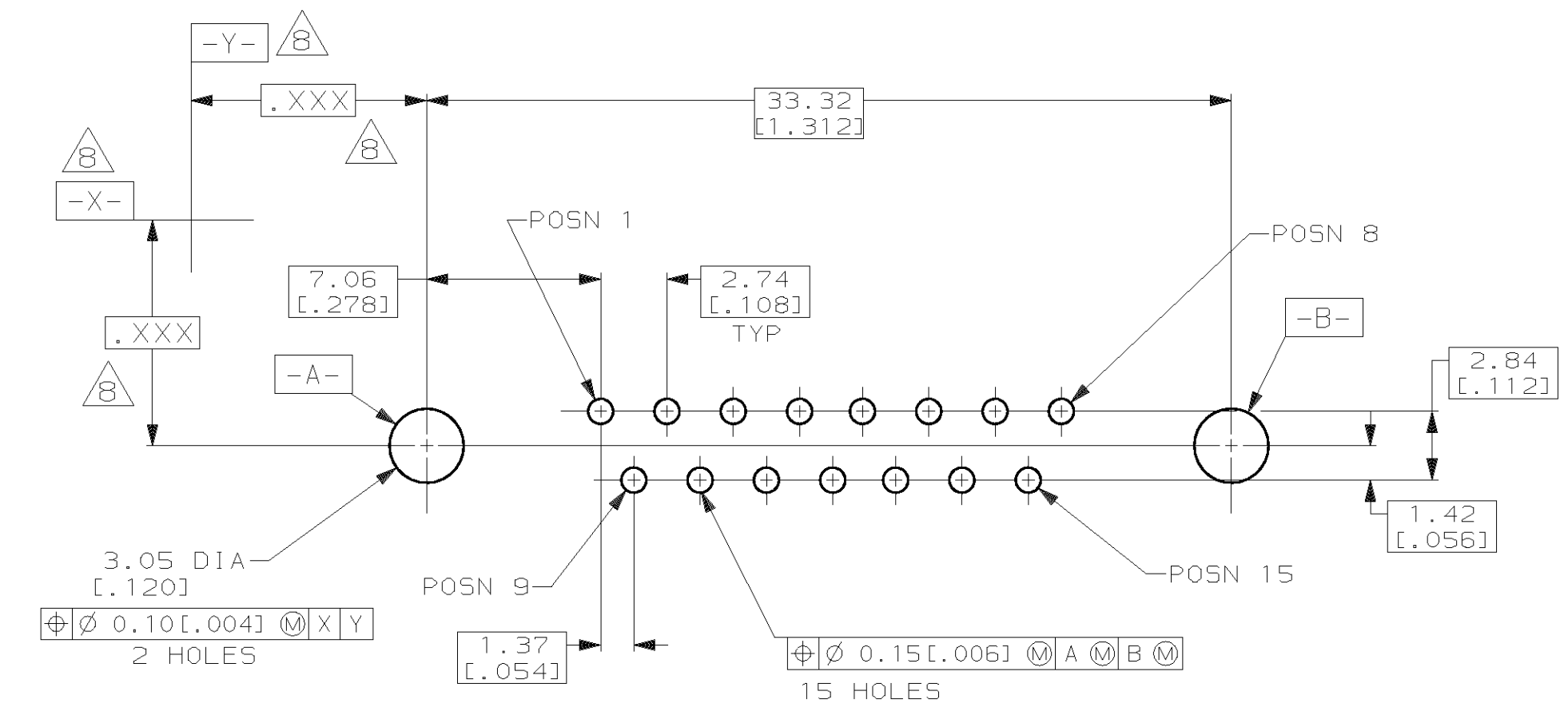
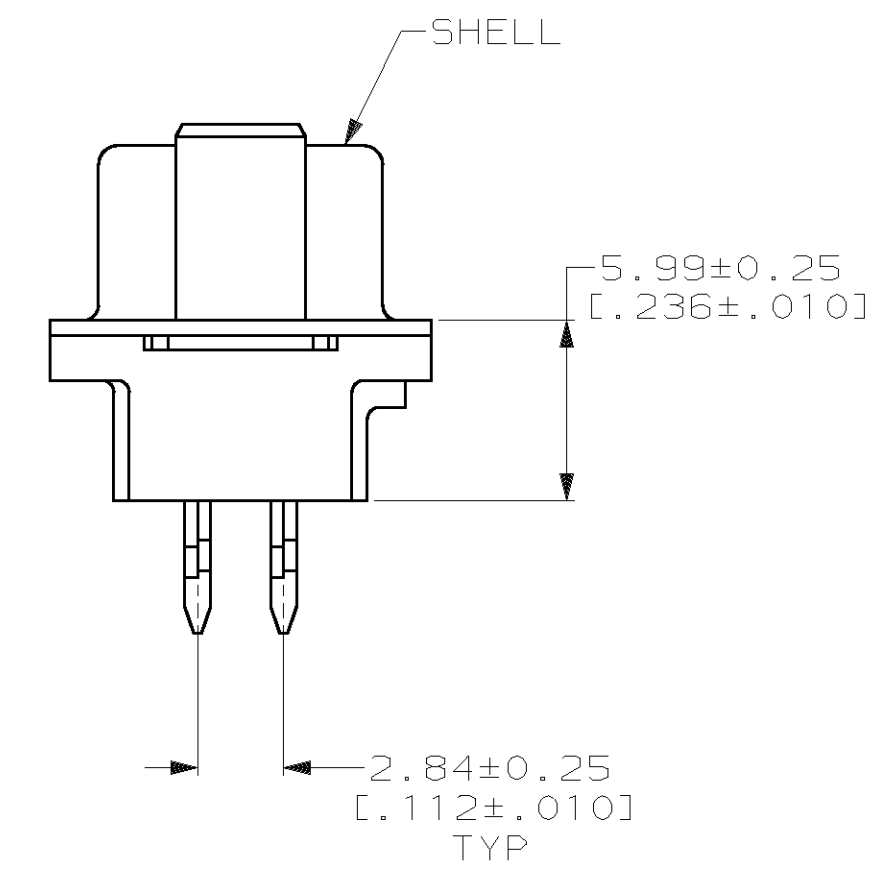
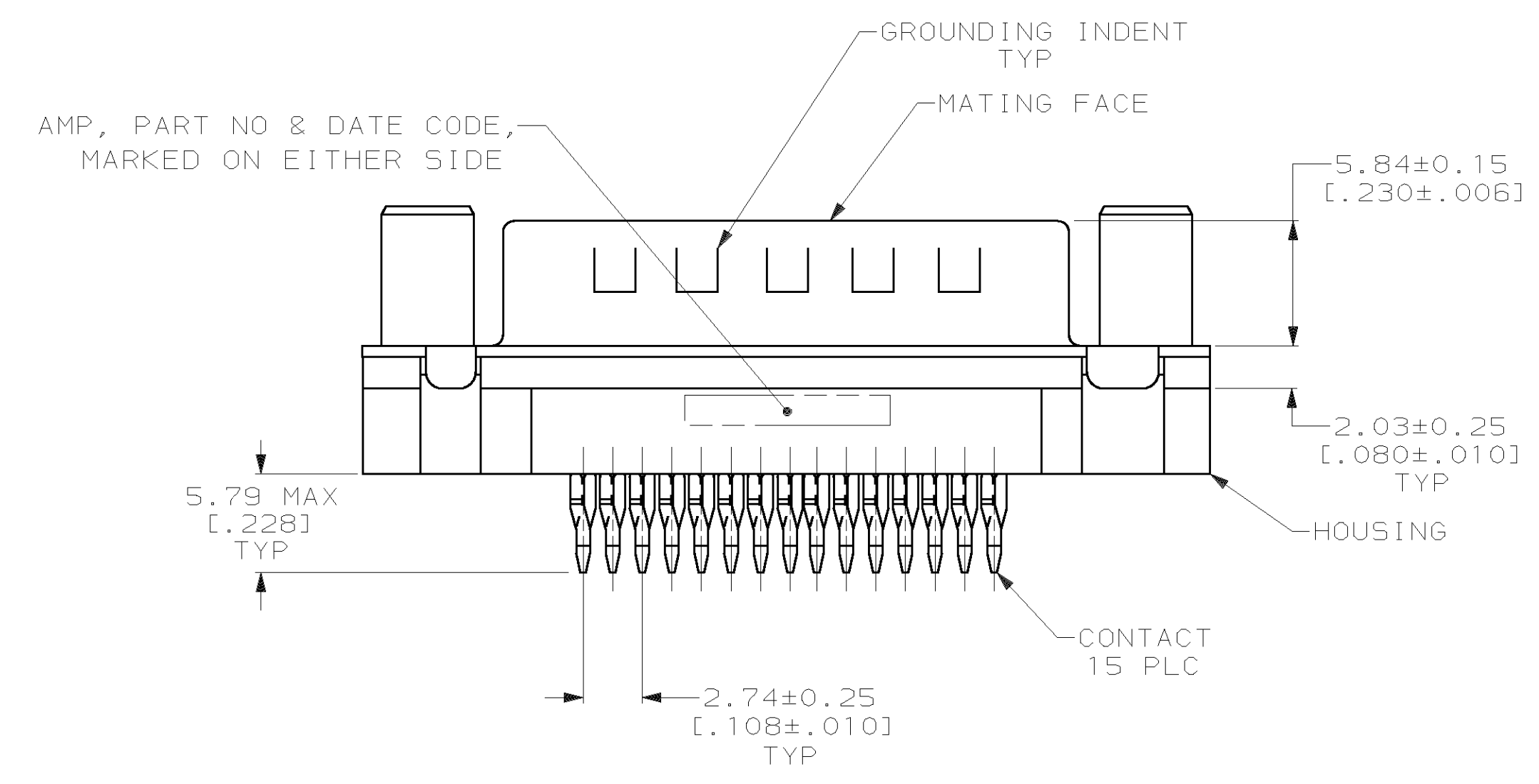
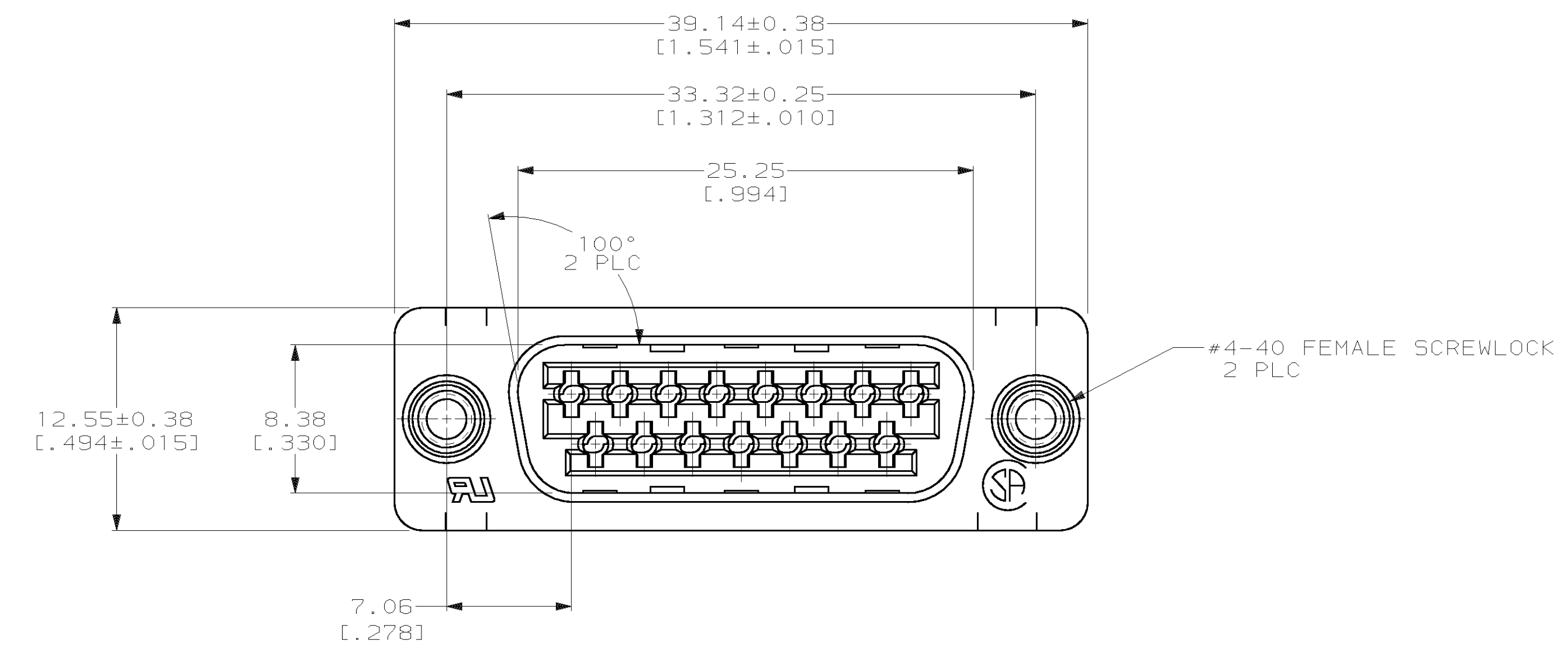


LOC		DIST		REV		ZONE		LTR		REVISIONS		DATE	APPD
BD	77									0	RLSE -1 NPR 5160, WAS 94-4913-7-1	07/29/94	-
										A	REV PER EC 0640-448-98	01 MAR 99	RT



- △ 1 RECOMMENDATIONS FOR 2.36 [0.093] MIN THICK PC BOARD:
  - A. HOLE DIAMETER AFTER DRILLING = 1.151 ± 0.025 [0.0453 ± 0.0010].
  - 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 0.76 μm [0.000300] MIN TIN-LEAD OVER 0.05 ± 0.03 [0.002 ± 0.001] 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 5.08 μm [0.000200] MIN TIN OVER 2.54 μm [0.000100] MIN COPPER.
- △ 7 GOLD PLATED FOR A LENGTH OF 3.81 [0.150] MIN FROM MATING END, 0.76 μm [0.000030] MIN GOLD IN MATED AREA. 2.54 μm [0.000100] MIN TIN-LEAD FOR A LENGTH OF 5.79 [0.228] MIN FROM OPPOSITE END, BOTH OVER 1.27 μm [0.000050] MIN NICKEL.
- △ 8 DATUMS AND BASIC DIMENSIONS ESTABLISHED BY CUSTOMER.

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 07/29/94 D.GELTZ	AMP Incorporated Harrisburg, PA 17105-3508	
CHK 08/04/94 R.STONE		APPD 08/05/94 M.PERCHERKE		
MATERIAL		APPD 08/17/94 W.PARKER	NAME	
HOUSING: △ 2	CONTACTS: △ 3	PRODUCT SPEC	PLUG ASSEMBLY, SIZE 2, 15 POSITION, MEDIUM PROFILE, ACTION PIN™, AMPLIMITE™ HD-20	
SHELL: △ 4	SCREWLOCKS: ZINC	108-40014		
FINISH △ 5		APPLICATION SPEC	SIZE	CAGE CODE
SHELL: △ 6	CONTACTS: △ 7	114-40026	D	00779
WEIGHT -			DRAWING NO	
			C=787177	
		SCALE 4:1	SHEET 1 OF 1	

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.