



SECTION A-A

- 1. TIN PER MIL-T-10727 OR TIN LEAD 0.00254 [.000100] MIN THK.
- 2. GOLD PER MIL-G-45204, TYPE II, 0.00076 [.000030] MIN THK OVER NICKEL PER QQ-N-290 0.00028 [.000011] MIN THK ON CONTACT AREA.
- 3. GOLD FLASH PER MIL-G-45204, TYPE II, 0.13µm [.000005] MIN THK. OVER NICKEL PLATE PER QQ-N-290 0.51µm-1.52µm [.000020-.000060] EXT THK.
- 4. RECOMMENDED HOLE SIZE, PLATED OR UNPLATED:
 MACHINE INSERTION: 1.32 ^{+0.03}/_{-0.05} [.052 ^{+0.001}/_{-0.002}]
 HAND INSERTION: 1.32 ^{+0.10}/_{-0.00} [.052 ^{+0.004}/_{-0.000}]
- 5. APPLICATION TOOL PART NUMBER:
 MACHINE NO. 682127-3
 INSERTION HEAD NO. 682039-2
- 6. TO INSURE PROPER SPRING TENSION DO NOT EXCEED A 0.10 [.004] DIFFERENCE IN PIN DIA WHEN CHANGING TO A SMALLER PIN.
- 7. BOTTOM PLUG KNOCKOUT TOOL PART NUMBER 69729 WITH TIP PART NUMBER 69728.
- 8. OBSOLETE PARTS: OBSOLETE CIS STREAMLINING PER D.RENAUD/D.SINISI

8	OBSOLETE	CLOSED	0.36-0.66 [.014-.026]	TIN 1	TIN 1	50863-8
	OBSOLETE	KNOCKOUT		GOLD 3	GOLD 2	50863-7
OBSOLETE	OPEN	TIN 1		50863-6		
OBSOLETE	CLOSED	TIN 1		50863-5		
OBSOLETE	KNOCKOUT	GOLD 3		50863-4		
OBSOLETE	OPEN	TIN 1		50863-3		
				GOLD 2	50863-1	
				TIN 1	50863	
				GOLD 3		
	BOTTOM TYPE	RECOMMENDED PIN DIA 6	EYELET	SPRING	PART NO	

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN R. TALLEY 4-8-91	STE TE Connectivity	
DIMENSIONS: mm[INCHES]		CHK S. ROBERTSON 8-22-91		
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD R. MILLER 8-5-91	NAME	
0 PLC ± -	1 PLC ± -	PRODUCT SPEC	MINIATURE SPRING SOCKET ASSEMBLY SERIES 2	
2 PLC ± -	3 PLC ± 0.20 [.008]	APPLICATION SPEC	SIZE	CAGE CODE
4 PLC ± -	ANGLES ± -	WEIGHT	A2	00779
MATERIAL SPRING: BeCu, QQ-C-533	FINISH SEE TABLE	CUSTOMER DRAWING	DRAWING NO	RESTRICTED TO
EYELET: Cu, QQ-C-576		SCALE 20:1	G-50863	SHEET 1 OF 1
				REV Z4