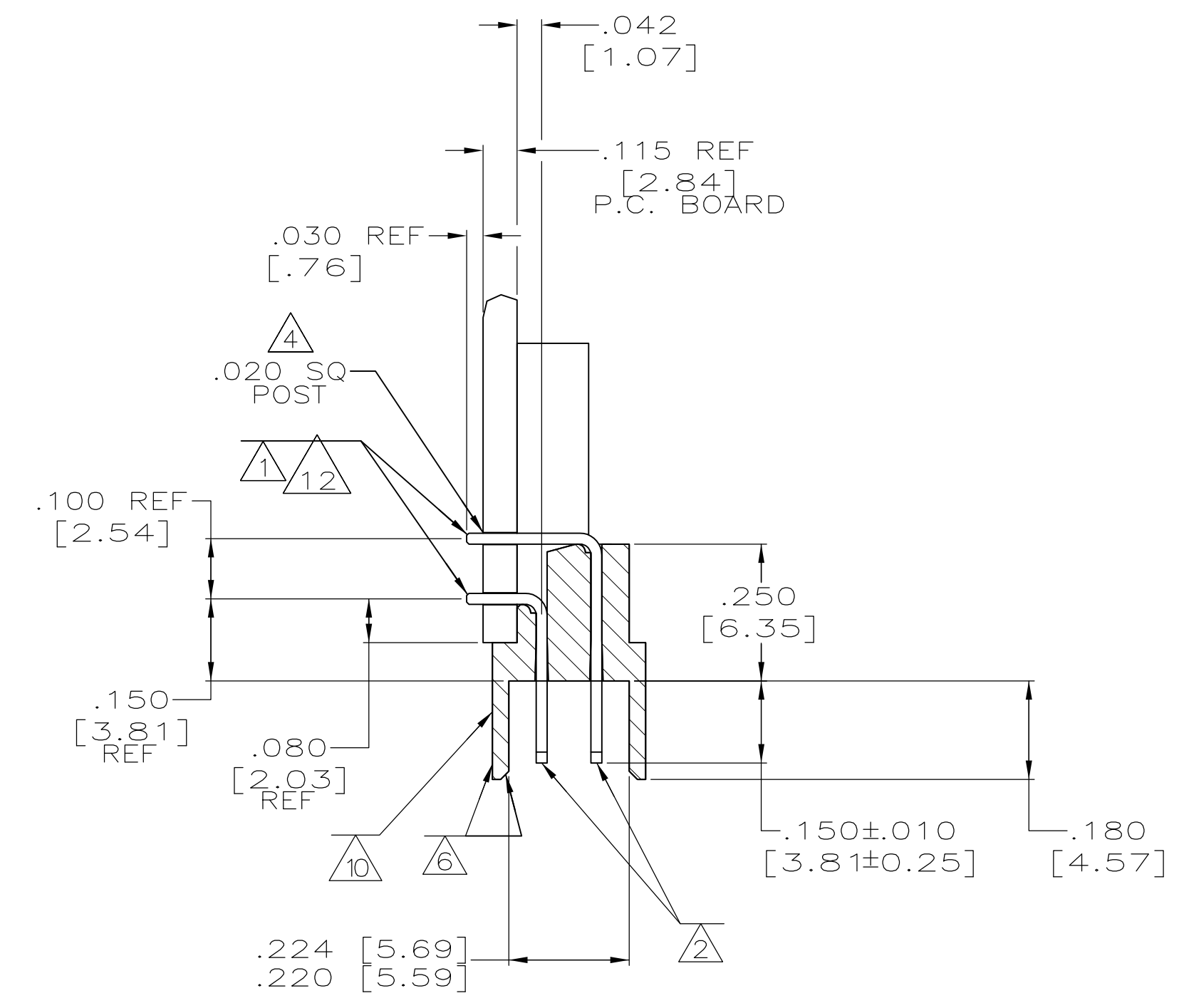
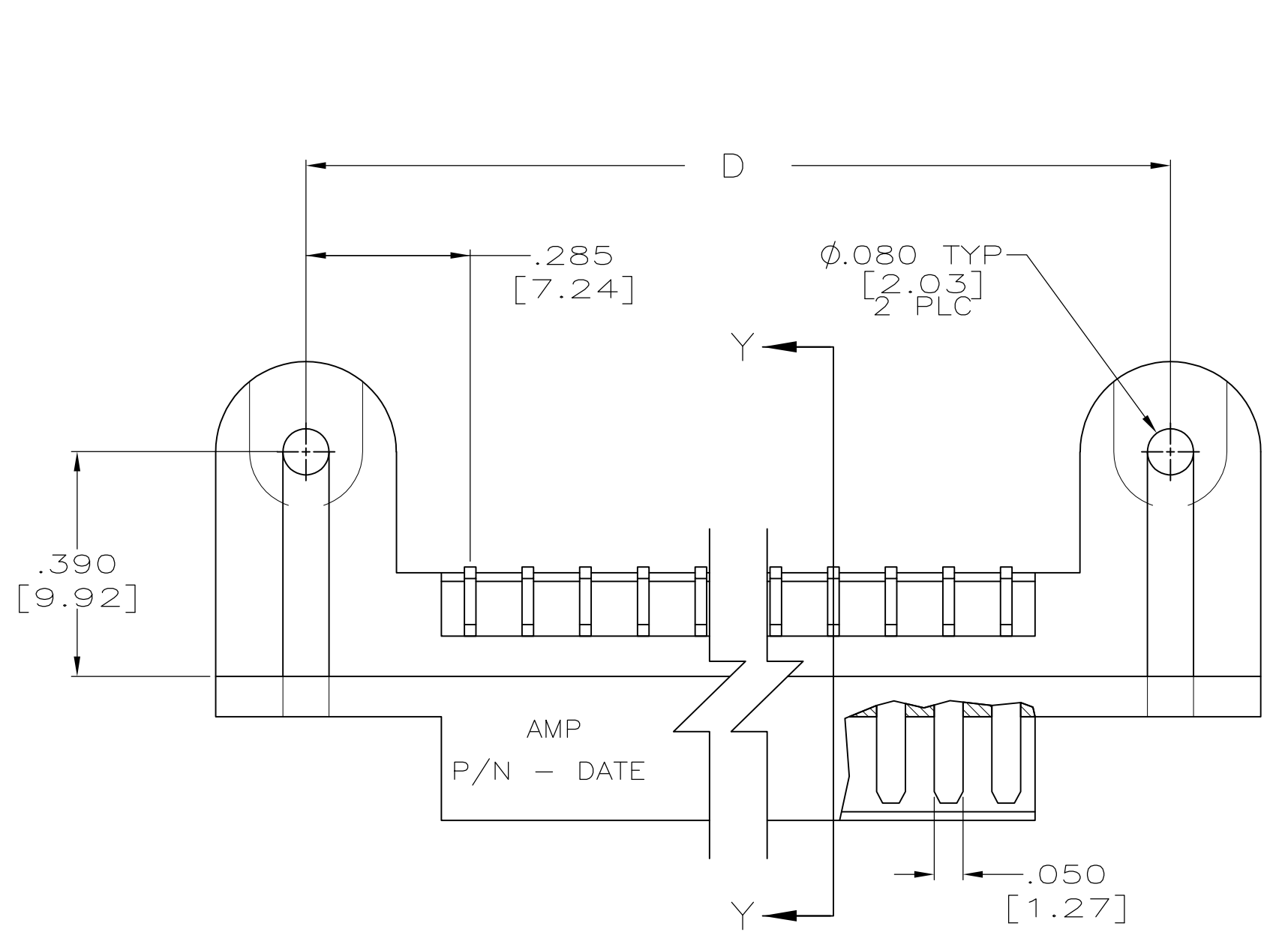
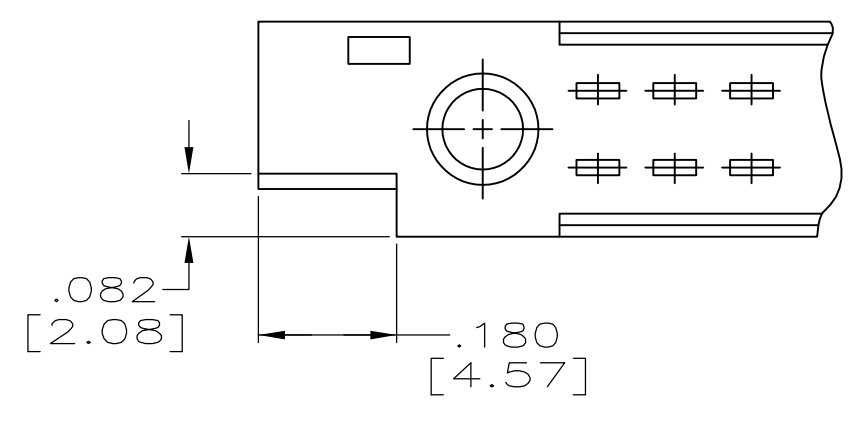
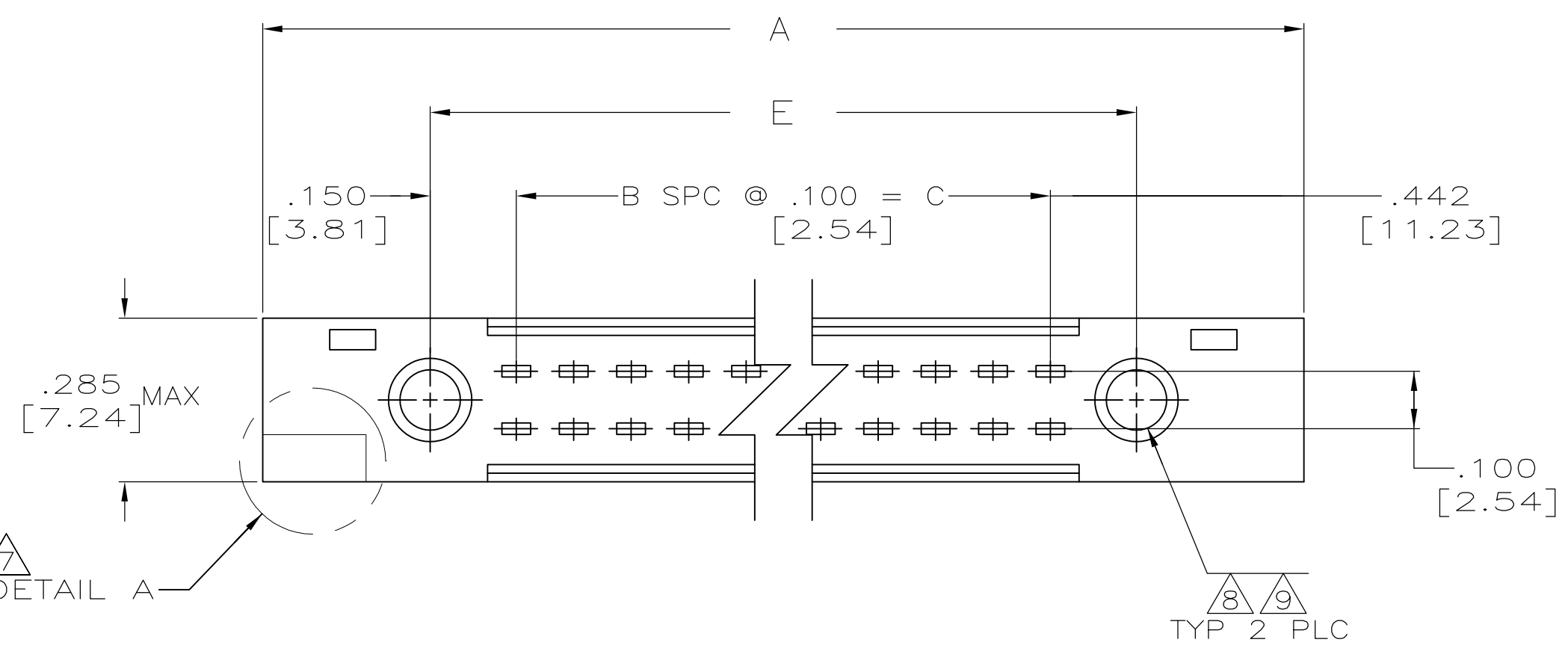


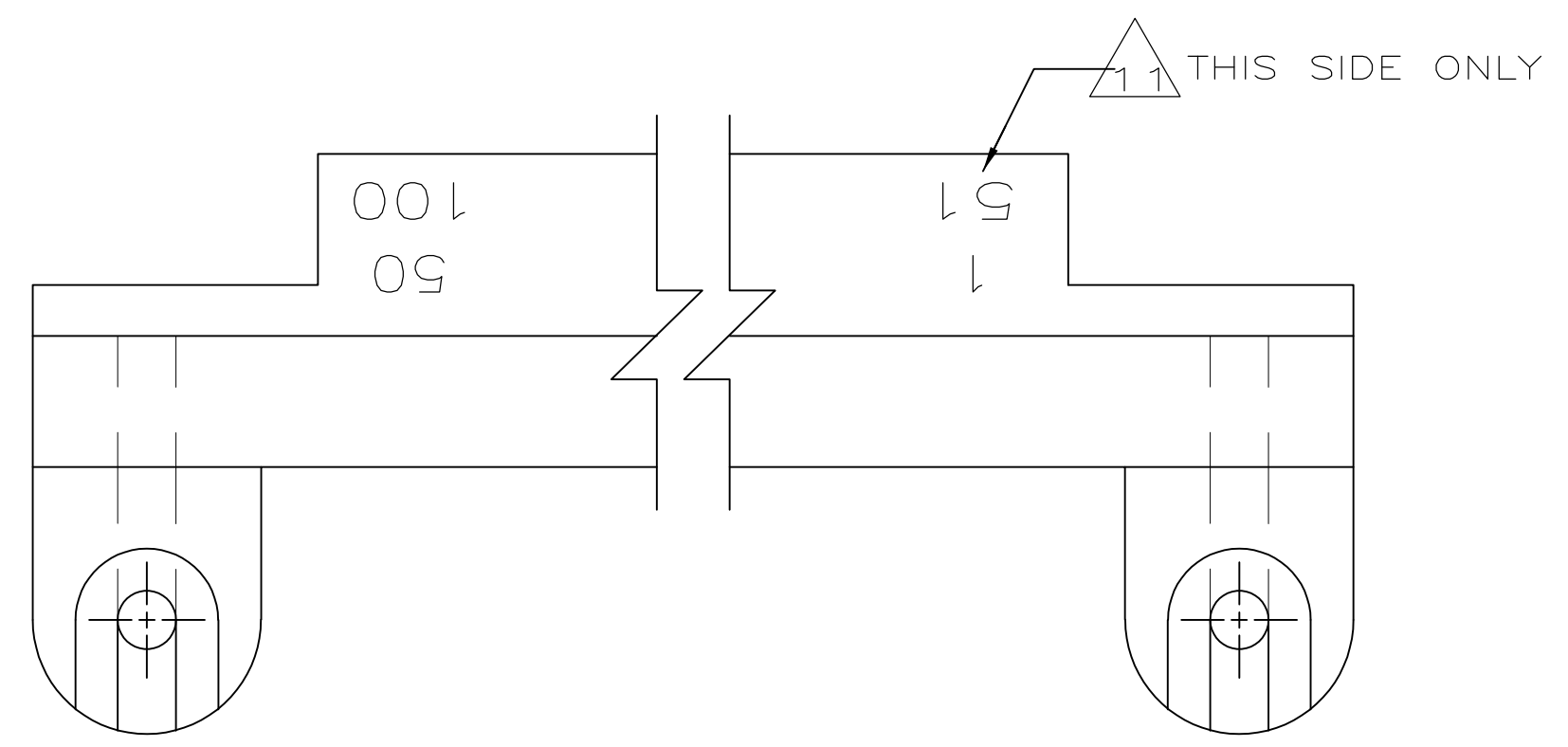
LOC		DIST		REVISIONS			
P	LTR	DESCRIPTION	DATE	DN	APVD		
G	REV PER ECO-11-024750		20DEC11	PY	DE		



SECTION Y-Y



DETAIL A



- 1 GOLD PLATING PER MIL-G-45204, .000010 MIN THK OVER NICKEL PLATING PER QQ-N-290 .000100 MIN THK.
- 2 GOLD PLATING PER MIL-G-45204, .000050 MIN THK OVER NICKEL PLATING PER QQ-N-290 .000100 MIN THK.
- 3 HOUSING MATERIAL: GLASS FILLED POLYETHERIMIDE CONTACT MATERIAL: PHOS BRONZE PER QQ-B-750, TEMPER 2
- 4 PLATED HOLE SIZE OF .029±.002 DIA WILL PROVIDE AN INTERFERENCE FIT SUITABLE FOR AUTOMATIC SOLDER OPERATIONS. FOR HAND SOLDER, THE A HOLE AS SPECIFIED PER AMP SPEC 106-14018 OR 106-14019 AS APPLICABLE IS RECOMMENDED.
- 5. MOUNTING HARDWARE; SCREW, BIND HD MACHINE (1-72 UNF X .250) NUT, HEX MACHINE SCREW (1-72 UNF).
- 6 THIS SURFACE MUST BE PROTECTED FROM DIRECT CONTACT WITH THE SOLDER WAVE. A SHIELD MACHINED FROM REINFORCED PHENOLIC HAS PROVEN SATISFACTORY DURING PROTOTYPE WORK CONDUCTED BY AMP INC. DUE TO THE VARIETY OF APPLICATIONS, AMP RECOMMENDS EXPERIMENTATION BY THE CUSTOMER TO DETERMINE THE MOST PRACTICAL METHOD OF PROTECTION FOR SPECIFIC APPLICATIONS.
- 7 CUTOUT ON BOTH ENDS OF HOUSING IS APPLICABLE ON -3 & -5 ONLY.
- 8 THESE MOUNTING HOLES ARE MADE TO ACCEPT PARTS MADE TO THE REQUIREMENTS OF MIL-C-28754/24A AMP PART NUMBER 117139, 117140, 117141. THESE COMPONENTS MUST BE BONDED TO THE HEADERS. A NONCONDUCTIVE EPOXY IS RECOMMENDED BY AMP, BUT A CYANOACRYLATE TYPE ADHESIVE MAY BE ACCEPTABLE FOR MOST CUSTOMER APPLICATIONS.
- 9 WHEN KEYING PINS MEETING THE REQUIREMENTS OF MIL-C-28754/24A ARE INSTALLED, THE MATING RECEPTACLE PANEL IS TO HAVE A CLEARANCE HOLE OF .158 DIA TO PERMIT COMPLETE ENGAGEMENT OF THE HEADER. (REF PART NUMBER 116975 RECEPTACLE)
- 10 STAMP AMP PART NUMBER AND DATE CODE PER MIL-STD-202, METHOD 215.
- 11 STAMP IDENTIFICATION NUMBERS FOR END CONTACTS PER MIL-STD-202, METHOD 215. (SEE TABLE)
- 12 CONTACT TAILS PLATED WITH .000150 TO .000200 THK TIN-LEAD (93/7).

IDENT NUMBERS	PLATING	E	D	C	B	A	NO OF POS	PART NUMBER
OBSOLETE	41 40 50 80	12	4.200 [106.68]	4.470 [113.54]	3.900 [99.06]	39	4.784 [121.51]	40 228235-6
OBSOLETE	51 50 100 100	12	5.200 [132.08]	5.470 [138.94]	4.900 [124.46]	49	5.784 [146.91]	50 228235-5
OBSOLETE	1 55 41 40 80 80	12	5.700 [144.78]	5.970 [151.64]	5.400 [137.16]	54	6.284 [159.61]	55 228235-4
OBSOLETE	51 50 100 100	12	4.200 [106.68]	4.470 [113.54]	3.900 [99.06]	39	4.784 [121.51]	40 228235-3
OBSOLETE	31 30 80 80	12	5.200 [132.08]	5.470 [138.94]	4.900 [124.46]	49	5.784 [146.91]	50 228235-2
OBSOLETE	31 30 80 80	12	3.200 [81.28]	3.470 [88.14]	2.900 [73.66]	29	3.784 [96.11]	30 228235-1

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC	± .005
1 PLC	± .005
2 PLC	± .005
3 PLC	± .005 [0.20]
4 PLC	± .005
ANGLES	± .1°

MATERIAL: 3 FINISH: -

THIS DRAWING IS A CONTROLLED DOCUMENT. DIN P. YEAGER 13APR2009. CHK J. WEAVER 14APR09. APVD J. WEAVER 14APR09. NAME: ECONOMATE II CONNECTOR ASSY BLADE, HEADER, .100 X .100. SIZE: A1. CAGE CODE: 00779. DRAWING NO: 228235. WEIGHT: -. RESTRICTED TO: -. CUSTOMER DRAWING. SCALE: 2:1. SHEET: 1 OF 1. REV: G.