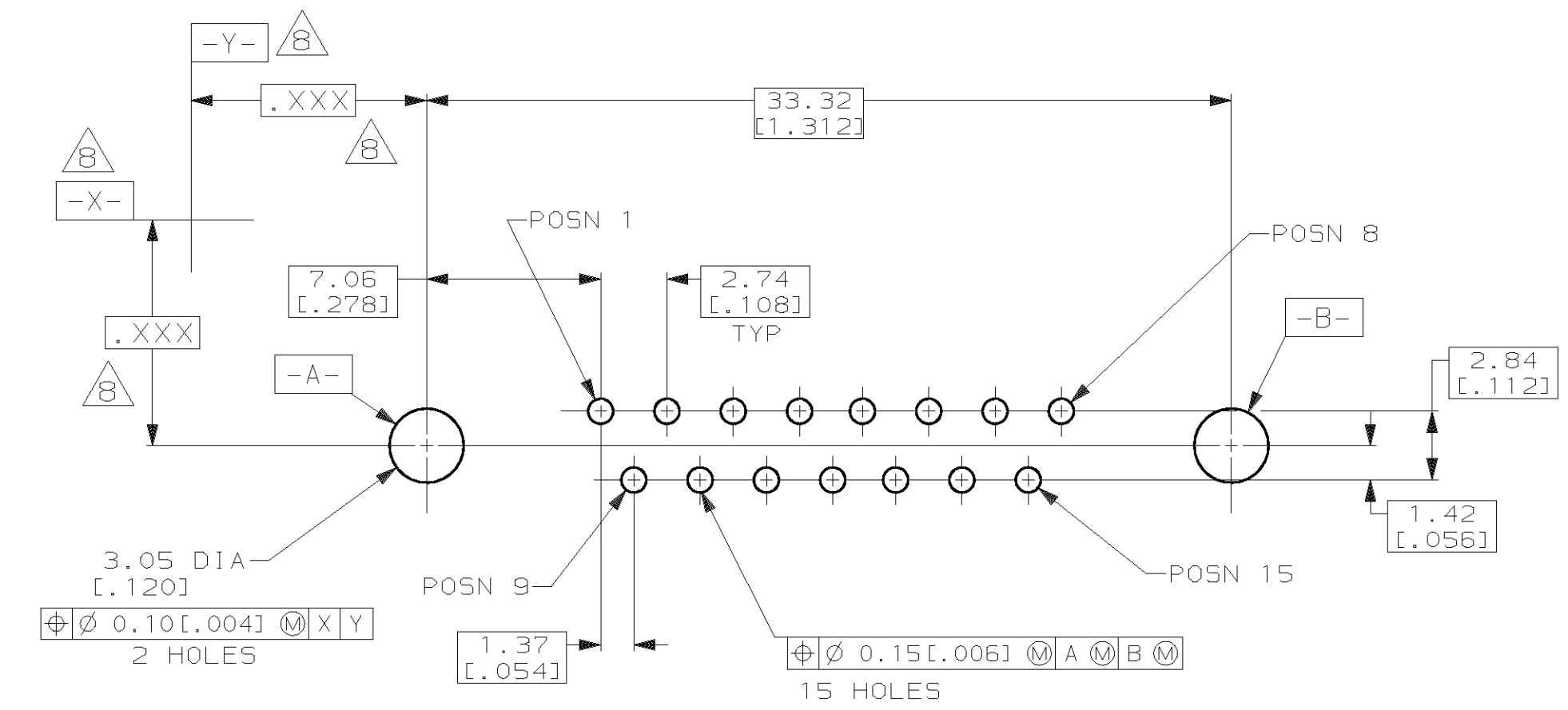
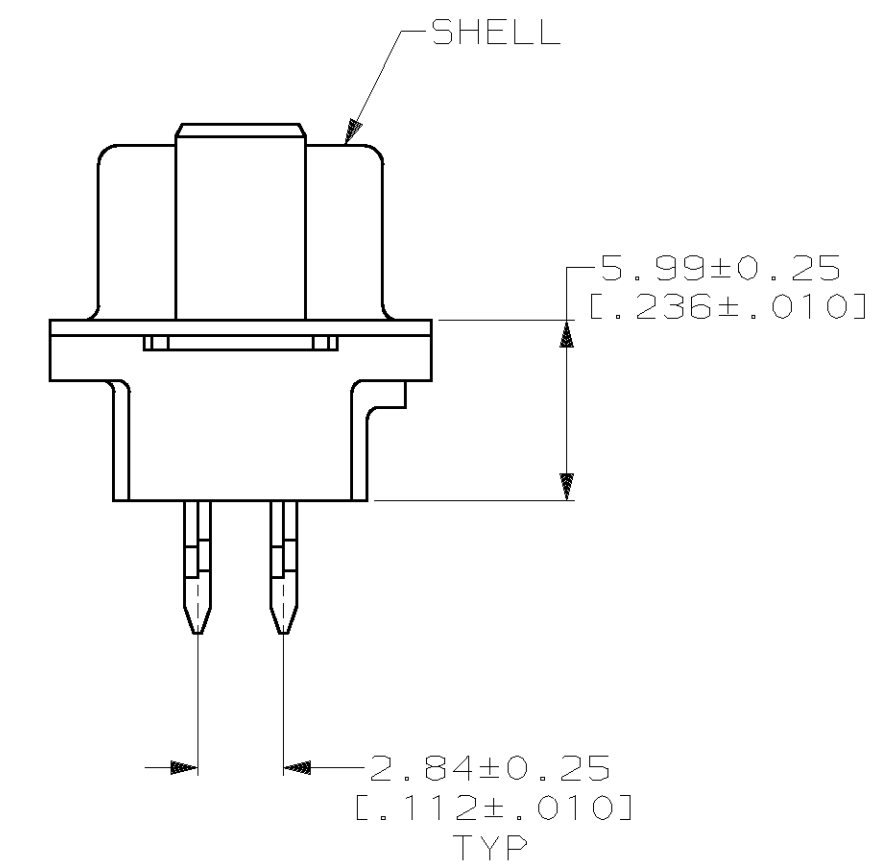
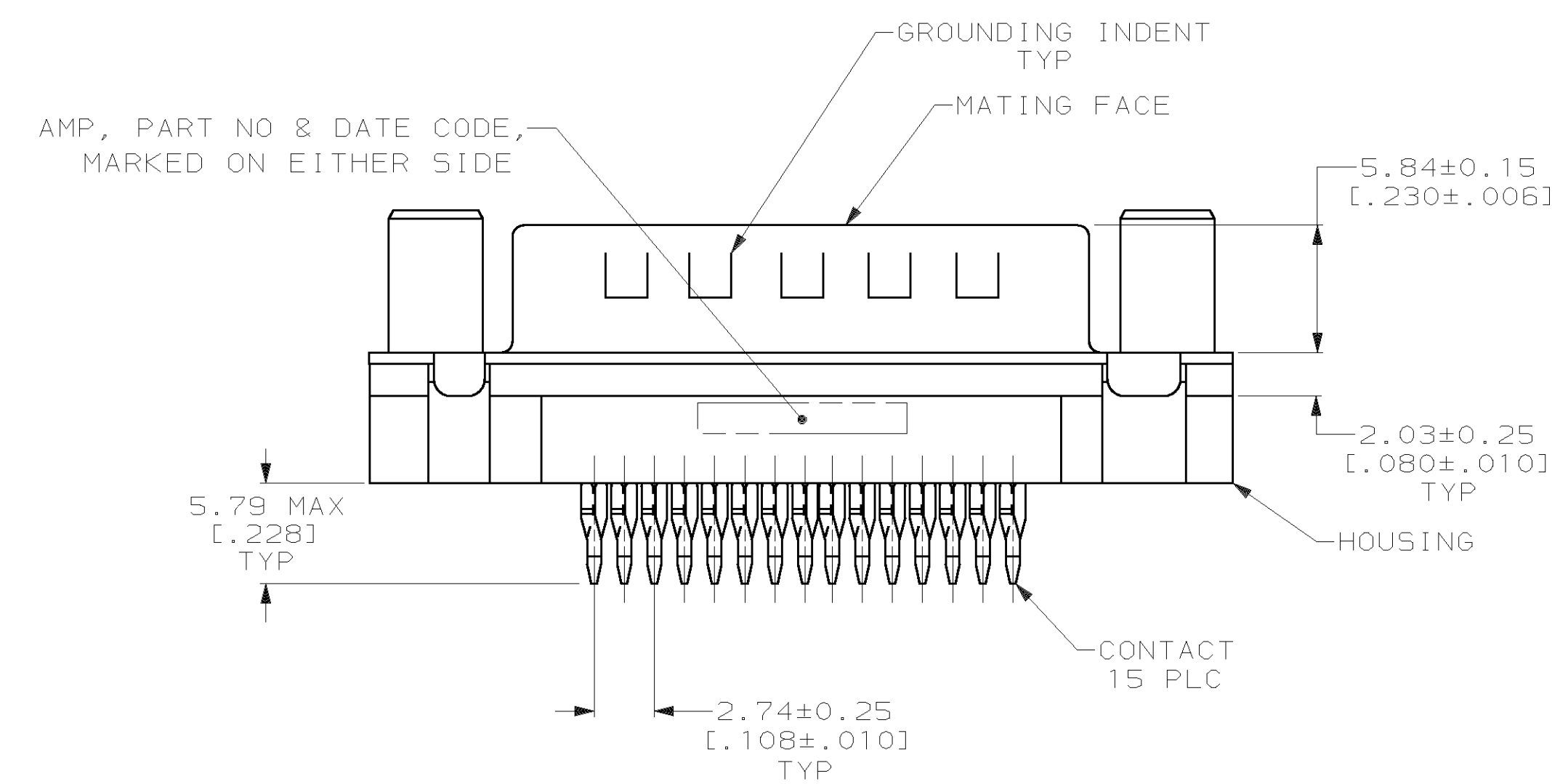
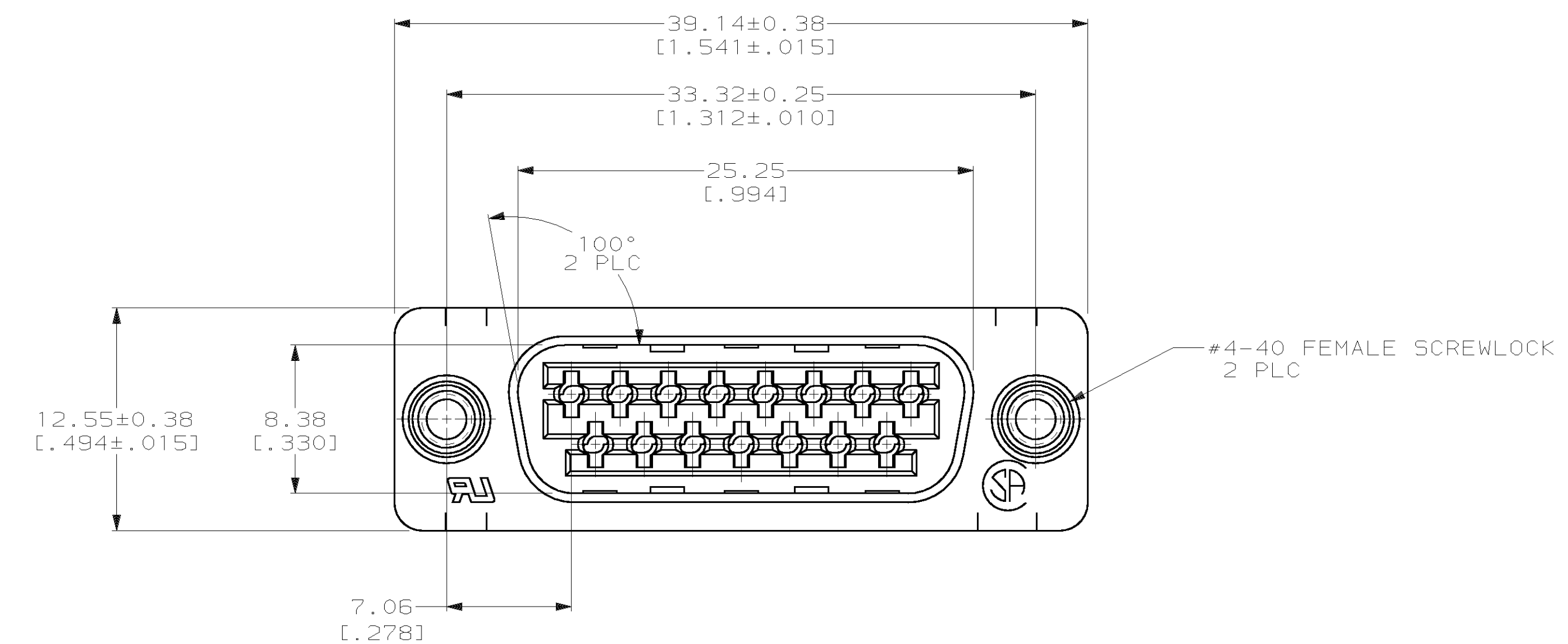


LOC		DIST		REV		ZONE		LTR		REVISIONS		DATE	APPD
BD	77	P	F							DESCRIPTION			
										0	RLSE -1 NPR 5160, WAS 94-4913-7-1	07/29/94	-
										A	REV PER EC 0640-448-98	01 MAR 99	RT



- 1 RECOMMENDATIONS FOR 2.36 [.093] MIN THICK PC BOARD:
 - A. HOLE DIAMETER AFTER DRILLING = 1.151 ± 0.025 [$.0453 \pm .0010$].
 - B. HOLE DIAMETER AFTER TIN-LEAD PLATING = 0.94 [$.037$]- 1.09 [$.043$].
 - C. HOLE DIAMETER AFTER REFLOW = 0.91 [$.036$]- 1.09 [$.043$].
 - D. PC BOARD PLATING TO BE $0.76 \mu\text{m}$ [$.000300$] MIN TIN-LEAD OVER 0.05 ± 0.03 [$.002 \pm .001$] 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 $5.08 \mu\text{m}$ [$.000200$] MIN TIN OVER $2.54 \mu\text{m}$ [$.000100$] MIN COPPER.
- 7 GOLD PLATED FOR A LENGTH OF 3.81 [$.150$] MIN FROM MATING END, $0.76 \mu\text{m}$ [$.000030$] MIN GOLD IN MATED AREA. $2.54 \mu\text{m}$ [$.000100$] MIN TIN-LEAD FOR A LENGTH OF 5.79 [$.228$] MIN FROM OPPOSITE END, BOTH OVER $1.27 \mu\text{m}$ [$.000050$] 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 \pm - ANGLES $\pm 2^\circ$		DR 07/29/94 D.GELTZ	AMP Incorporated Harrisburg, PA 17105-3508	
MATERIAL		CHK 08/04/94 R.STONE		
HOUSING: 2 CONTACTS: 3	SHELL: 4 SCREWLOCKS: ZINC	APPD 08/05/94 M.PERCHERKE	NAME	
FINISH 5	SHELL: 6 CONTACTS: 7	APPD 08/17/94 W.PARKER	PLUG ASSEMBLY, SIZE 2, 15 POSITION, MEDIUM PROFILE, ACTION PIN™, AMPLIMITE™ HD-20	
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.		PRODUCT SPEC 108-40014	APPLICATION SPEC 114-40026	WEIGHT -
		SIZE D	CAGE CODE 00779	DRAWING NO C-787177
		SCALE 4:1	SHEET 1 OF 1	