



- 1 NYLON OR POLYESTER, FLAME RETARDANT, UL 94V-0 RATED, GLASS FILLED, BLACK.
- 2 BRASS PER MIL-C-50.
- 3 CARBON STEEL PER ASTM A109.
- 4 EYELETS: BRASS; BOARDLOCKS: COPPER ALLOY.
- 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 2.54μm [0.000100] MIN TIN OVER 1.27μm [0.000050] MIN COPPER.
- 7 EYELETS: 5.08μm [0.000200] MIN TIN OVER COPPER FLASH. BOARDLOCKS: 5.08μm [0.000200] MIN TIN-LEAD OVER 1.27μm [0.000050] MIN NICKEL.
- 8 GOLD FLASH FOR A LENGTH OF 3.81 [0.150] MIN FROM MATING END, 2.54μm [0.000100] MIN TIN OR TIN-LEAD FOR A LENGTH OF 3.56 [0.140] MIN FROM OPPOSITE END, BOTH OVER 1.27μm [0.000050] MIN NICKEL.
- 9 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 OR TIN-LEAD FOR A LENGTH OF 3.56 [0.140] MIN FROM OPPOSITE END, BOTH OVER 1.27μm [0.000050] MIN NICKEL.
- 10 DIMENSION APPLIES FROM CENTER OF CONTACTS.

	SEE DETAIL E	9	747827-6
OBSOLETE	SEE DETAIL E	8	747827-5
	SEE DETAIL D	9	747827-4
SUPSD BY 747827-4	SEE DETAIL D	8	747827-3
OBSOLETE	-	9	747827-2
OBSOLETE	-	8	747827-1
	MOUNTING HARDWARE	CONTACT FINISH	PART NUMBER

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: mm [INCHES]	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DATE: 05 OCT 89	BY: W.G. LENKER
0 PLC ±	1 PLC ±0.13 [0.005]	DATE: 05 FEB 90	CHK: R. STONE
2 PLC ±	3 PLC ±	DATE: 06 FEB 90	APVD: M.D. GALLOWAY
4 PLC ±	ANGLES: ±2°	NAME: PLUG ASSEMBLY, SIZE 1, 9 POSITION, RIGHT ANGLE, FRONT METAL SHELL, .590 SERIES, BOARDLOCKS, AMPLIMITE® HD-20	PRODUCT SPEC: 108-40025
MATERIAL: HOUSING, SHELL, HARDWARE	FINISH: CONTACTS, SEE TABLE; SHELL, HARDWARE; INSERT, CLEAR CHROMATE; SCREWLOCKS, CLEAR CHROMATE	SIZE: 114-40010	APPLICATION SPEC: 114-40010
		SCALE: 4:1	WEIGHT: -
		SHEET: 1 OF 1	REV: N

AMP Incorporated  
Harrisburg, PA 17105-3608

Customer Drawing