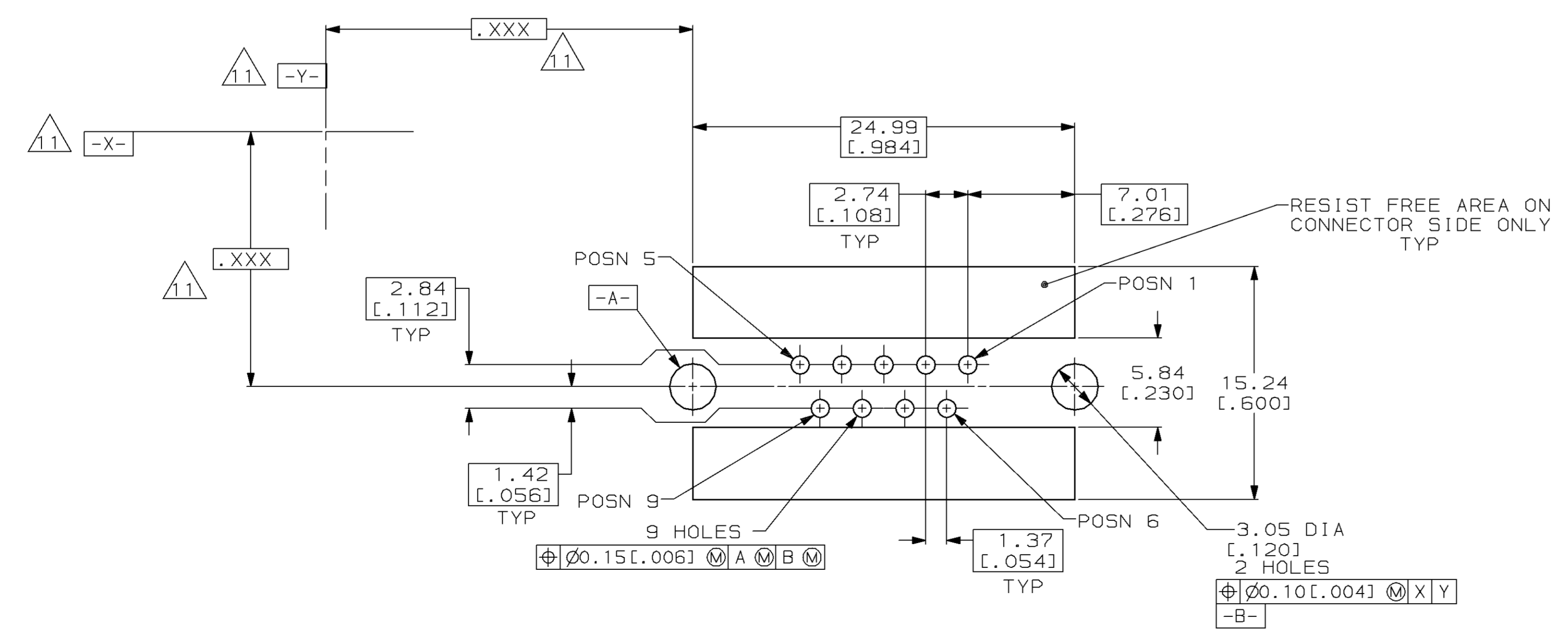
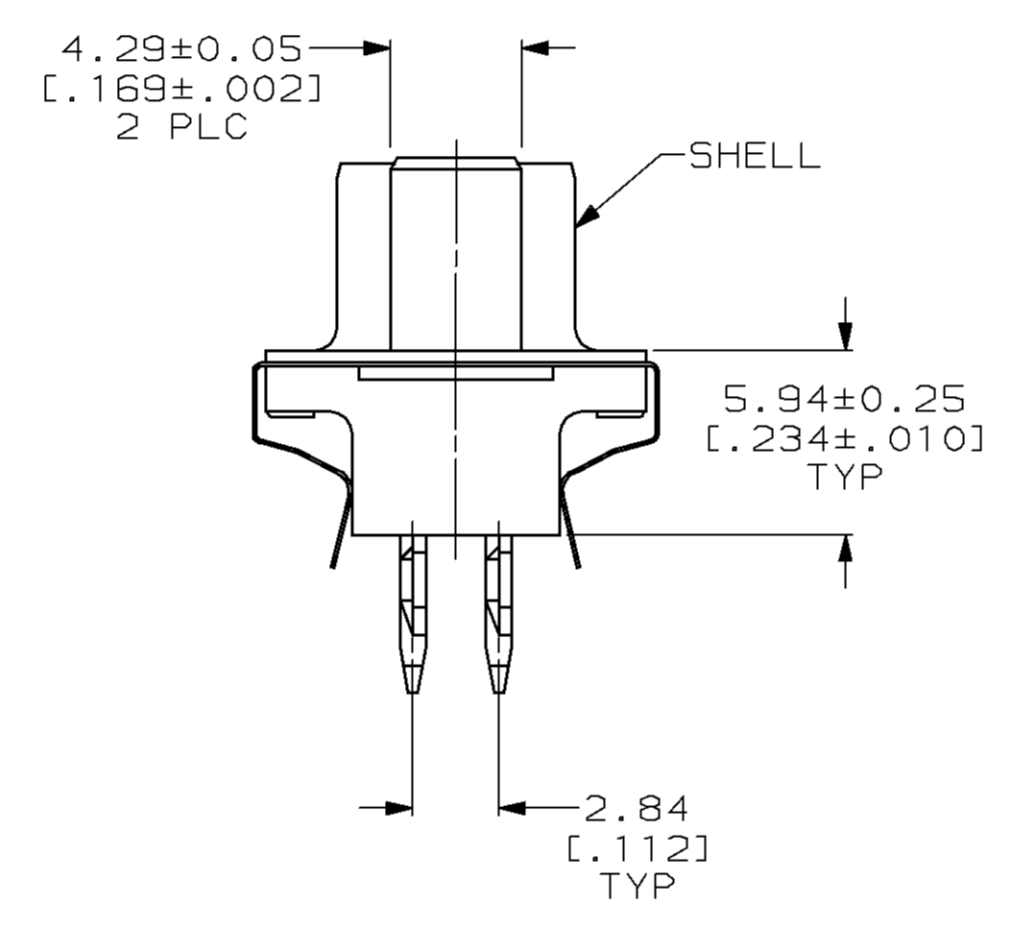
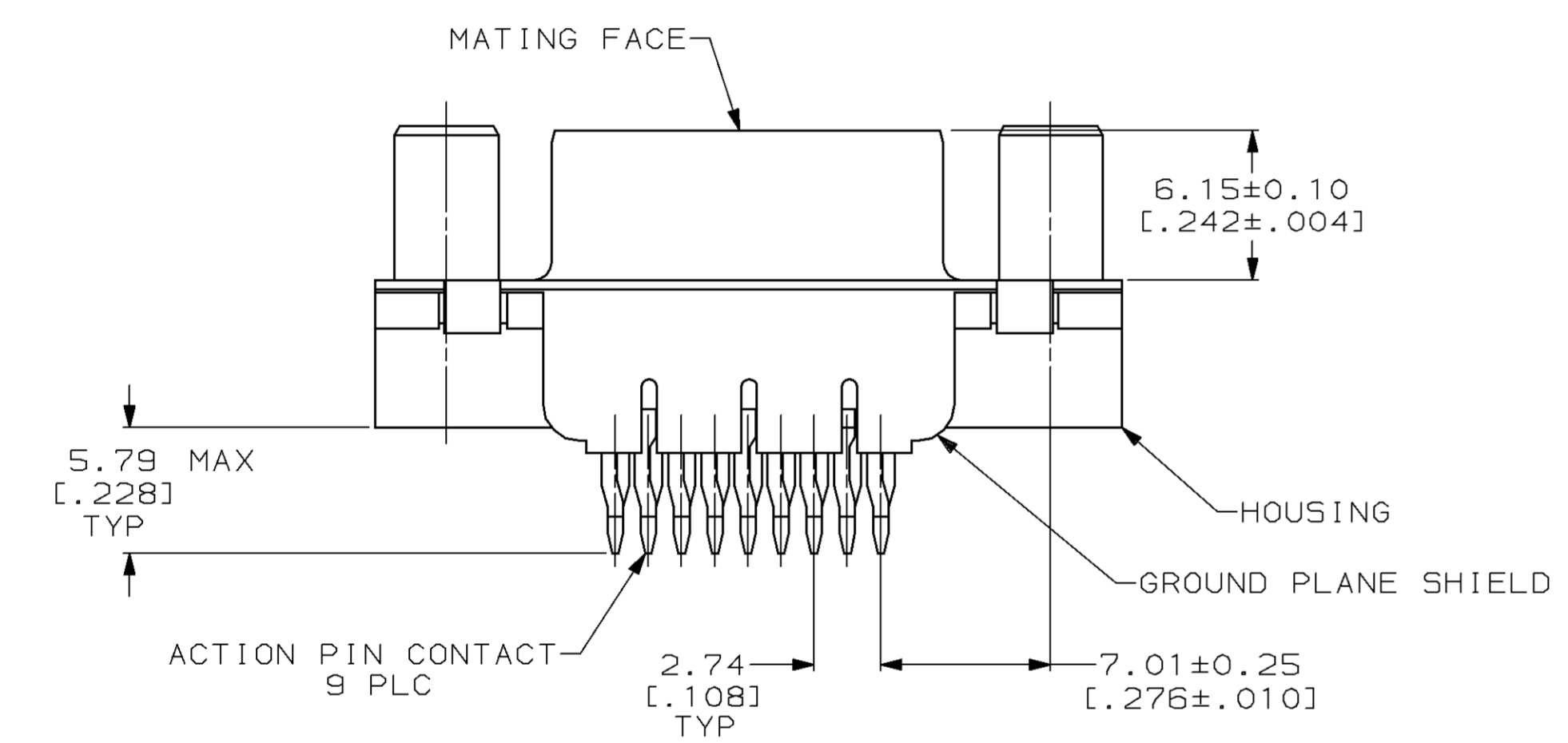
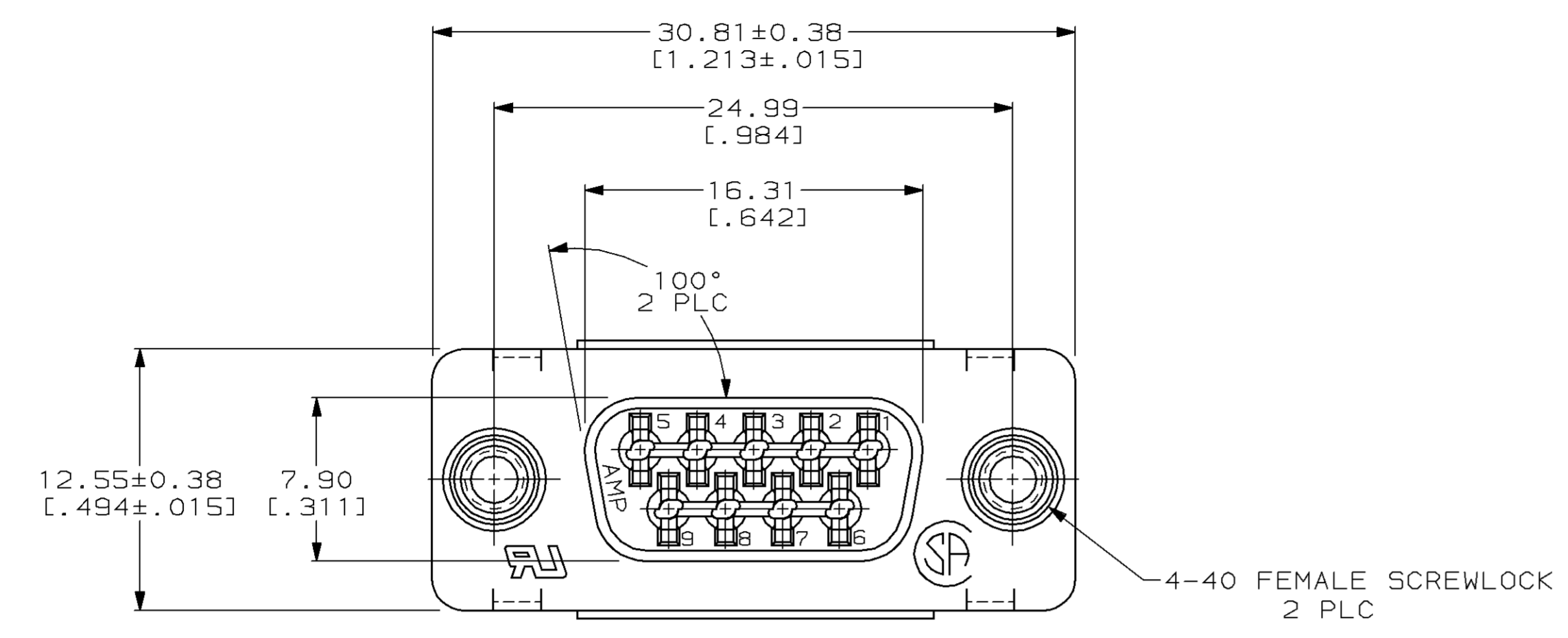


LOC		REVIS		REVISIONS				
BD	77	P	F	ZONE	LTR	DESCRIPTION	DATE	APPD
				0		RLSE NPR 3670, WAS 91-4913-8	08/10/91	-
				A		REV PER EC 0020-1353-93	01/28/94	MP



RECOMMENDED PC BOARD MOUNTING DIMENSIONS
 CONNECTOR SIDE OF BOARD

- 1. RECOMMENDATIONS FOR 2.36 [.093] MIN THICK PC BOARD:
 - A. HOLE DIAMETER AFTER DRILLING = 1.15±0.03 [.045±.001].
 - 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 0.76μm [.000300] MIN TIN-LEAD OVER 0.05±0.03 [.002±.001] COPPER.
- 2. NYLON OR POLYESTER, UL 94V-0 RATED, BLACK.
- 3. COPPER ALLOY PER ASTM B 122.
- 4. CARBON STEEL PER ASTM A 109.
- 5. ZINC.
- 6. GOLD PLATING PER MIL-G-45204, NICKEL PLATING PER QQ-N-290, TIN PLATING PER MIL-T-10727, COPPER PLATING PER MIL-C-14550.
 - 7. 1.27μm [.000050] MIN TIN OVER 0.13μm [.000005] MIN NICKEL STRIKE.
 - 8. 5.08μm [.000200] MIN TIN-LEAD OVER 2.54μm [.000100] MIN COPPER.
 - 9. 0.76μm [.000030] MIN GOLD FOR A LENGTH OF 1.02 [.040] MIN FROM MATING END, 2.54μm [.000100] MIN TIN OR TIN-LEAD FOR A LENGTH OF 5.79 [.228] MIN FROM OPPOSITE END, BOTH OVER 1.27μm [.000050] MIN NICKEL.
- 10. STAINLESS STEEL PER QQ-S-766.
- 11. DATUMS AND BASIC DIMENSIONS ESTABLISHED BY CUSTOMERS.

DO NOT SCALE PRINT. UNLESS SPECIFIED DIMENSIONS IN mm [INCHES] TOLERANCES ON:		DR 08/10/91 S.WELDON	AMP Incorporated Harrisburg, PA 17105-3608	
2 PLC DEC ± 0.13 [.005]		CHK 8-22-91 R.STONE		
3 PLC DEC ± -		APPD 2-22-91 M.PERCHERKE	NAME	
ANGLES ± 2°		APPD 8-22-91 J.ASSINI	RECEPTACLE ASSEMBLY, SIZE 1, 9 POSITION, ACTION PIN™, FRONT METAL SHELL AMPLIMITE™ HD-20	
MATERIAL		PRODUCT SPEC	108-40014	
HOUSING: 2 SCREWLOCKS: 5		APPLICATION SPEC	114-40026	
CONTACTS: 3 SHIELD: 10		SIZE	CAGE CODE	DRAWING NO
SHELL: 4		D	00779	750906
FINISH CONTACTS: 9 SHIELD: 1		SCALE	SHEET	
SHELL: 8		4:1	1 OF 1	