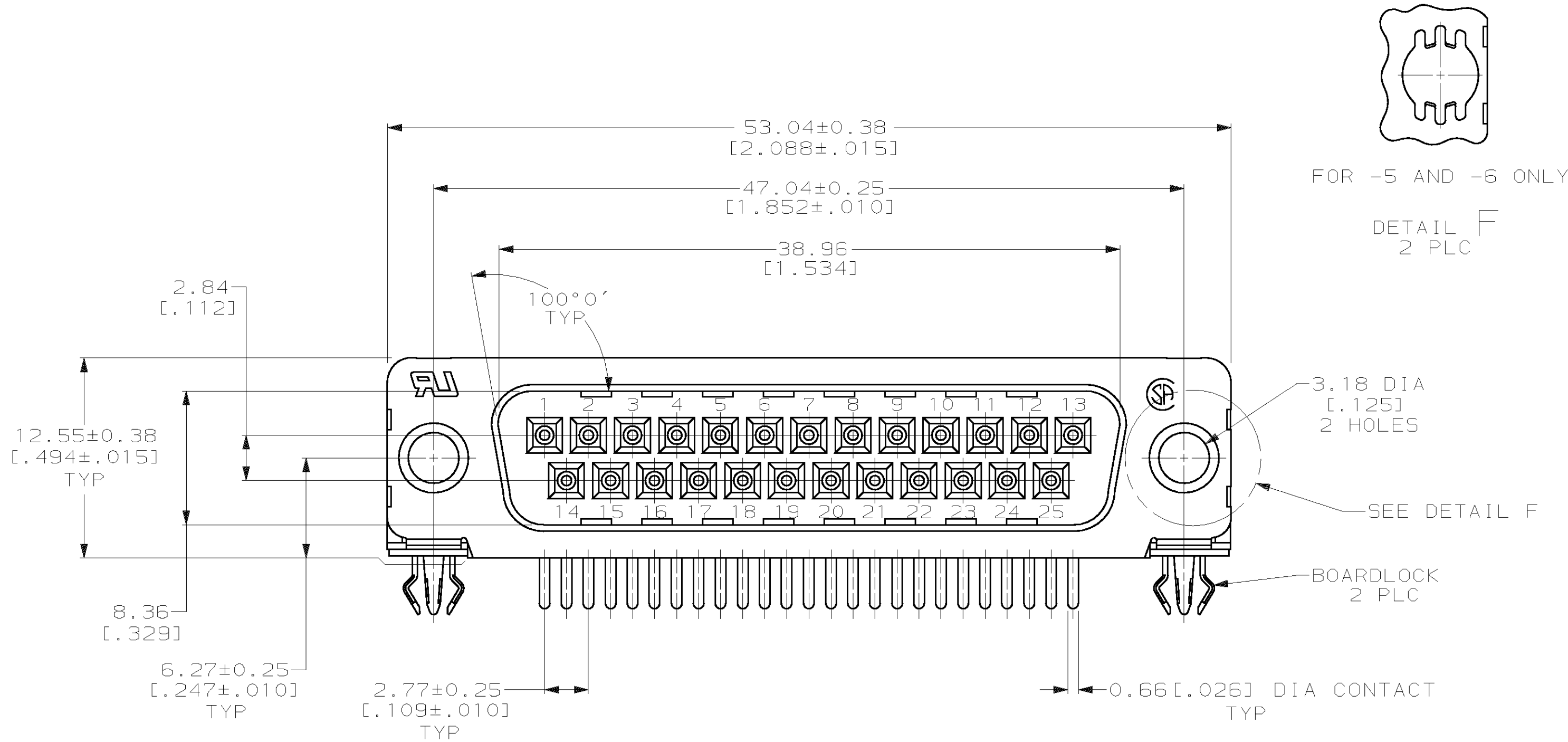
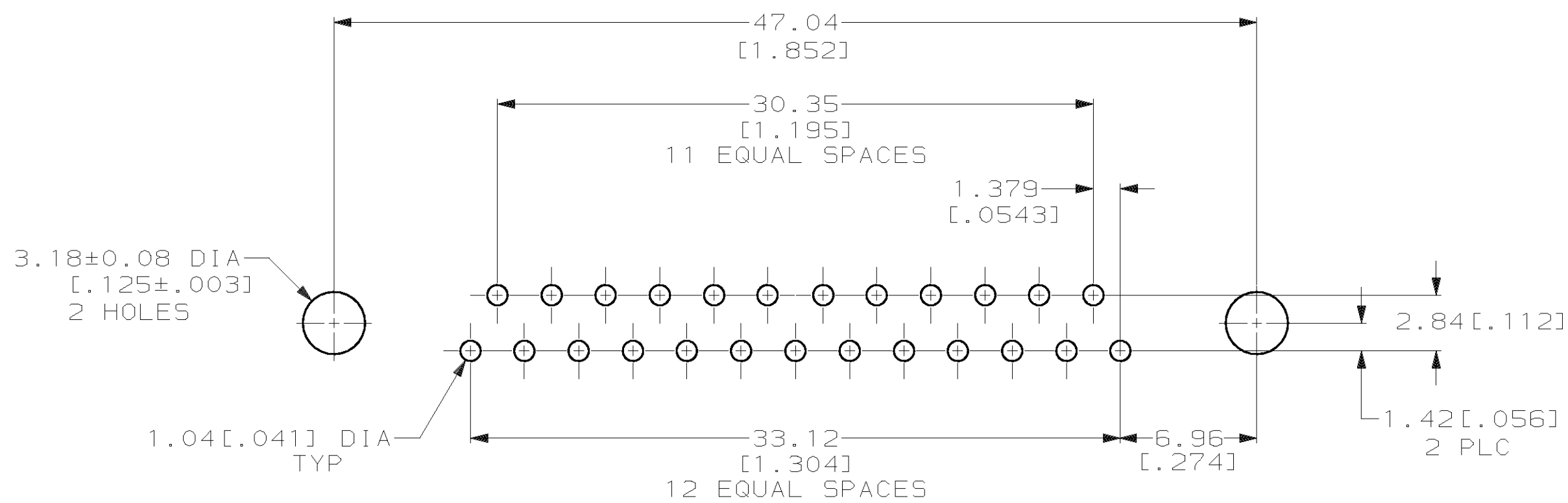
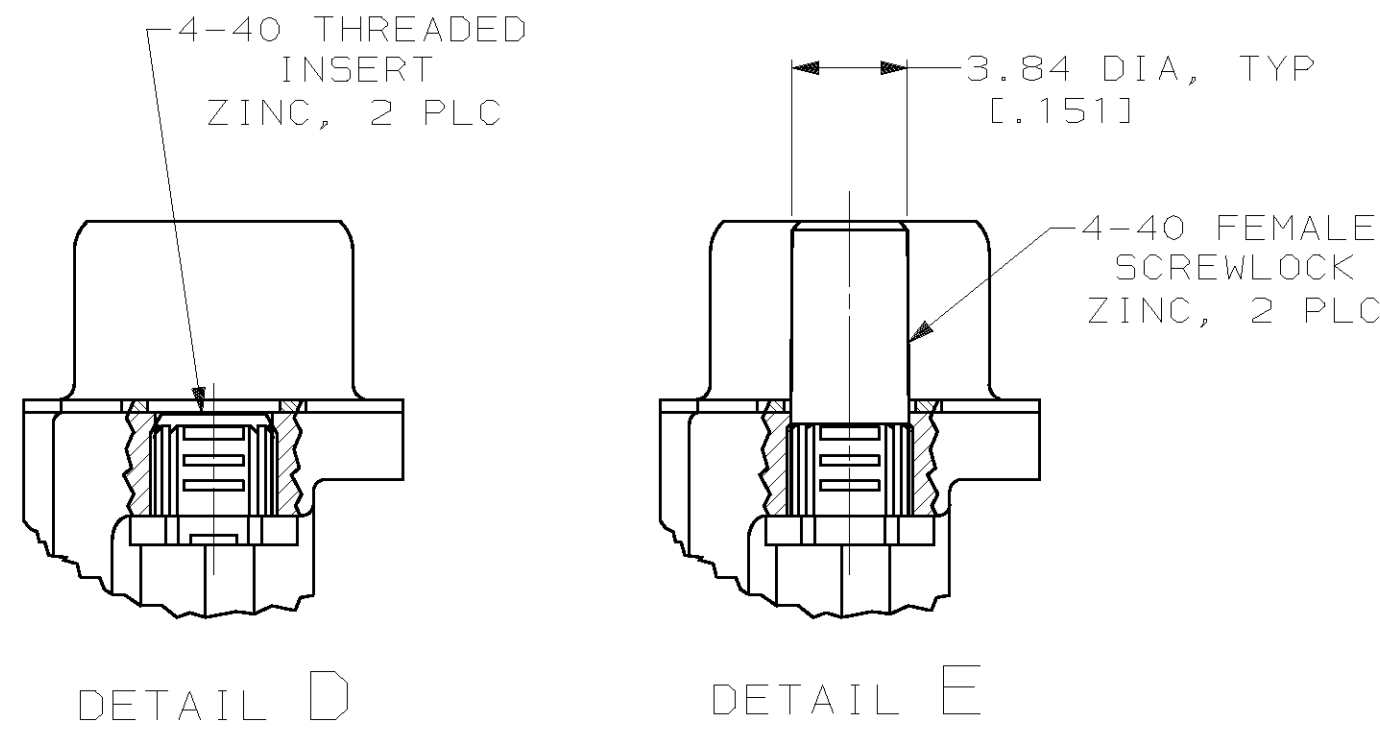
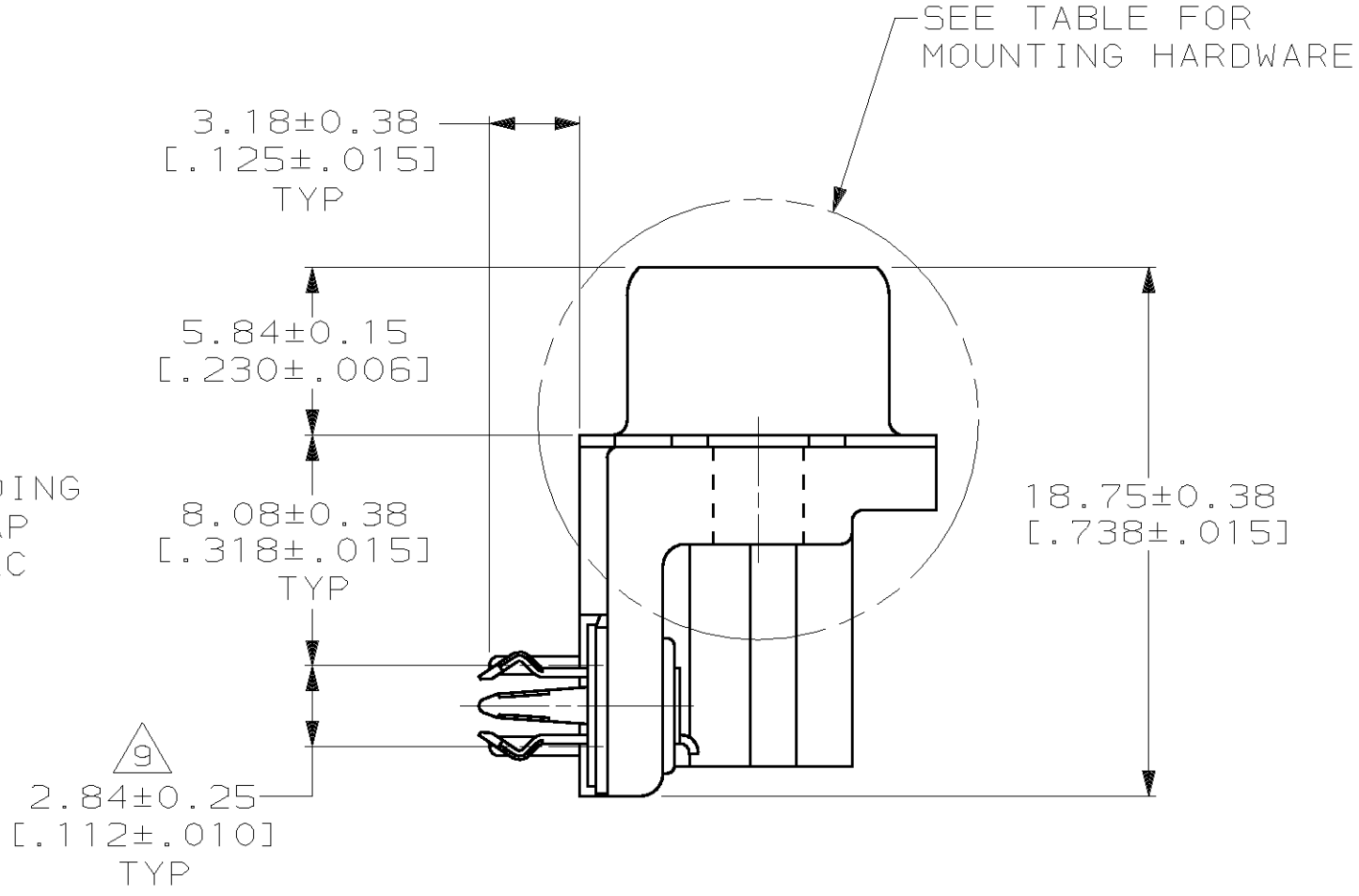
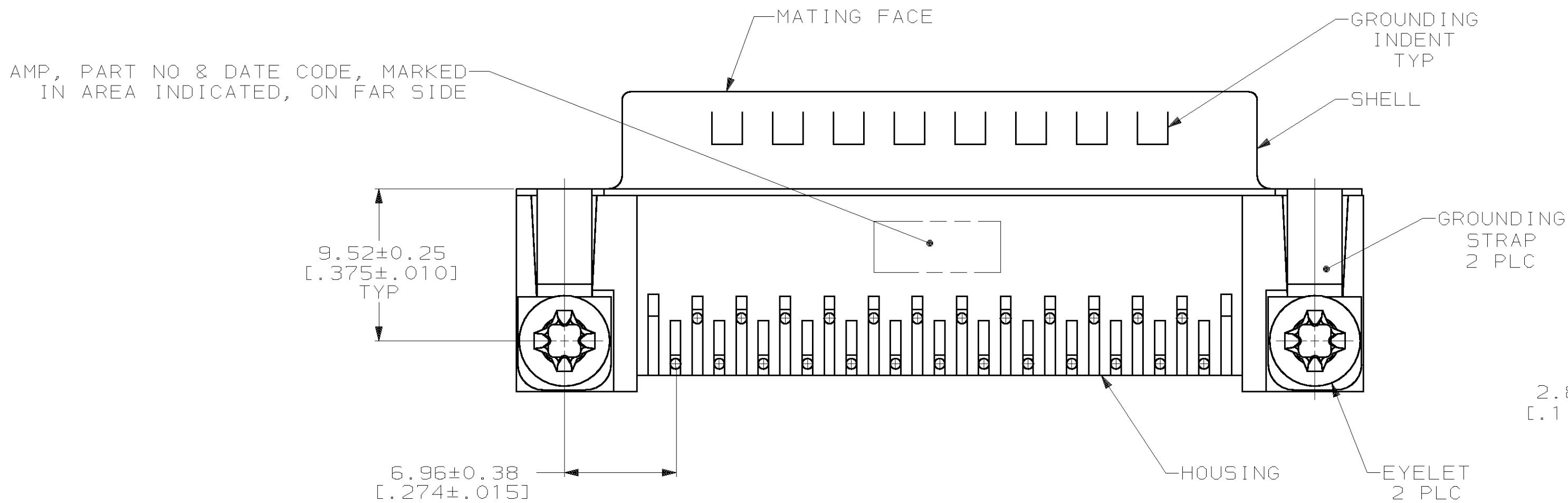


LOC	DIST	P	F	ZONE	LTR	REVISIONS		
						DESCRIPTION	DATE	APPD
GP	00				N	REVISED PER EC 0513-0176-03	28MAY03	JG



FOR -5 AND -6 ONLY
DETAIL F
2 PLC

- 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 SHELL: 2.54µm[.000100] MIN TIN OVER 1.27µm[.000050] MIN COPPER. EYELETS: 5.08µm[.000200] MIN TIN OVER COPPER FLASH. CONTACTS: SEE TABLE. BOARDLOCKS: SEE TABLE. INSERTS: CLEAR CHROMATE. SCREWLOCKS: CLEAR CHROMATE.
- 7 GOLD PLATED FOR LENGTH OF 3.81 [0.150] MIN FROM MATING END, GOLD FLASH IN MATED AREA, 2.54µm [0.000100] MIN TIN OR TIN-LEAD FOR A LENGTH OF 3.56[.140] MIN FROM OPPOSITE END, BOTH OVER 1.27µm[.000050] MIN NICKEL.
- 8 GOLD PLATED FOR LENGTH OF 3.81 [0.150] MIN FROM MATING END, 0.76µm [0.000030] MIN GOLD IN MATED AREA, 2.54µm[.000100] MIN TIN OR TIN-LEAD FOR A LENGTH OF 3.56[.140] MIN FROM OPPOSITE END, BOTH OVER 1.27µm[.000050] MIN NICKEL.
- 9 DIMENSION APPLIES FROM CENTER OF CONTACTS.
- 10 5.08µm[.000200] MIN TIN-LEAD OVER 1.27µm[.000050] MIN NICKEL.
- 11 5.08µm[.000200] MIN TIN OVER 1.27µm[.000050] MIN NICKEL.
- 12 SUPERSEDED BY 747842-2.



RECOMMENDED P.C. BOARD MOUNTING DIMENSIONS
P.C. BOARD THICKNESS: 1.57 [0.062]

SEE DETAIL E	11	8	6-747842-9
SEE DETAIL D	11	8	6-747842-8
		7	6-747842-7
SEE DETAIL E	10	8	747842-6
		7	747842-5
SEE DETAIL D	10	8	747842-4
		7	747842-3
		8	747842-2
	10	7	747842-1
MOUNTING HARDWARE	BOARDLOCK FINISH	CONTACT FINISH	PART NO

DO NOT SCALE PRINT. UNLESS SPECIFIED DIMENSIONS IN mm [INCHES] TOLERANCES: ON: 2 PLC DEC ± 0.13[.005] 3 PLC DEC ± - ANGLES ± 2°0'		DR 10-5-89 W.G.LENKER	AMP AMP INCORPORATED Harrisburg, Pa. 17105		
MATERIAL HOUSING: 1 CONTACTS: 2 SHELL: 3 HARDWARE: 4 FINISH: 6		CHK 2-5-90 R. STONE			
		APPD 2-6-90 M.D.GALLOWAY	NAME		
		APPD 2-6-90 C. ROHDE	PLUG ASSEMBLY, SIZE 3, 25 POSITION, RIGHT ANGLE, FRONT METAL SHELL, .318 SERIES, BOARDLOCKS, AMPLIMITE® HD-20		
		PRODUCT SPEC 108-40025			
		APPLICATION SPEC 114-40010	SIZE D	CAGE CODE 00779	DRAWING NO 747842
		WEIGHT -	SCALE 4:1	SHEET 1 OF 1	