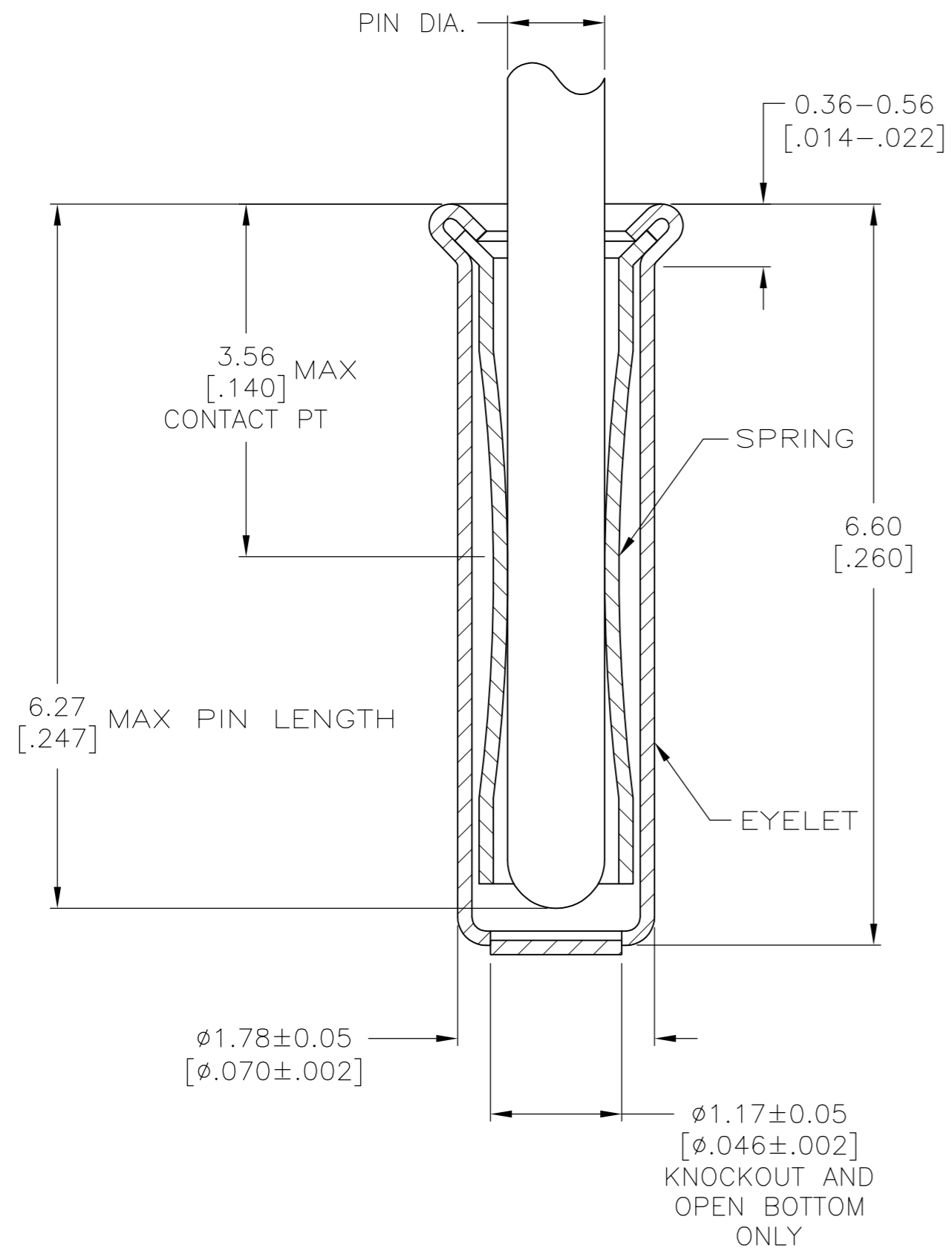
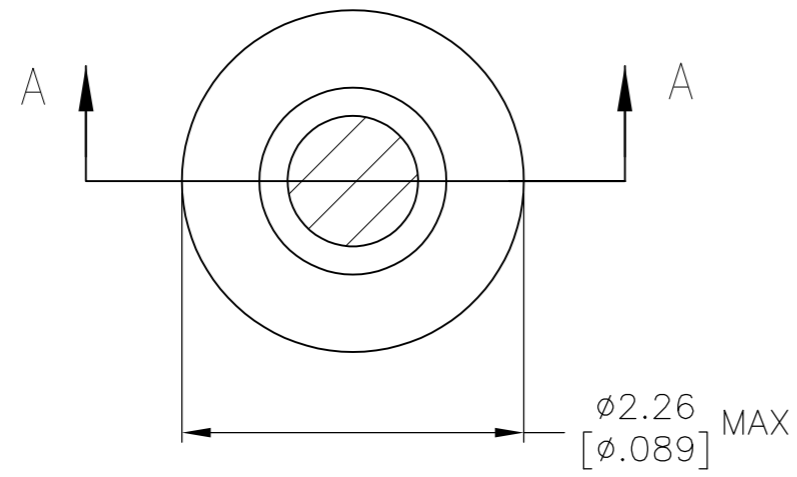


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LOC	DIST	REVISIONS					
GP	00	P	LTR	DESCRIPTION	DATE	DWN	APVD
		AG1		REVISED PER ECO-10-020379	08OCT10	DH	DB



SECTION A-A

1. TIN PER MIL-T-10727 OR TIN LEAD .000254 [.000100] MIN THK.
2. NICKEL UNDERPLATE ALL OVER, MATING SURFACE PLATED TO MEET PERFORMANCE REQUIREMENTS OF TYCO PRODUCT SPECIFICATION 108-14008.
3. GOLD FLASH PER MIL-G-45204, TYPE II, 0.13µm [.000005] MIN THK. OVER NICKEL PLATE PER QQ-N-290 0.51µm-1.52µm [.000020-.000060] EXT THK.
4. GOLD PER MIL-G-45204, TYPE II, 0.00127 [.000050] MIN THK.
5. RECOMMENDED HOLE SIZE, PLATED OR UNPLATED:  
 MACHINE INSERTION: 1.83 <sup>+0.10</sup>/<sub>-0.08</sub> [.072 <sup>+0.004</sup>/<sub>-0.003</sub>]  
 HAND INSERTION: 1.83 <sup>+0.10</sup>/<sub>-0.00</sub> [.072 <sup>+0.004</sup>/<sub>-0.000</sub>]
6. APPLICATION TOOL PART NUMBER:  
 MACHINE NO. 682127-5  
 INSERTION HEAD NO. 682039-4
7. TO INSURE PROPER SPRING TENSION DO NOT EXCEED A 0.05 [.002] DIFFERENCE IN PIN DIA WHEN CHANGING TO A SMALLER PIN.
8. BOTTOM PLUG KNOCKOUT TOOL PART NUMBER 69729 WITH TIP PART NUMBER 69728-2.
9. TIN PER ASTM B 545, .000254 [.000100] MIN THK.
10. MATERIAL: SPRING: BERYLLIUM COPPER QQ-C-533  
 EYELET: COPPER, QQ-C-576
11. GOLD PER MIL-G-45204 TYPE II, 0.00076 [.000030] MIN THK OVER NICKEL PER QQ-N-290 0.00028 [.000011] MIN THK OF CONTACT AREA.

	KNOCKOUT		TIN 9	TIN 9	6-50865-7
	OPEN		GOLD 4	GOLD 11	6-50865-6
			GOLD 4	GOLD 2	1-50865-2
					1-50865-1
SUPSD BY 50865-5					1-50865-0
OBSOLETE	CLOSED				50865-8
OBSOLETE	KNOCKOUT	0.86-1.04 [.034-.041]	TIN 1	TIN 1	50865-7
	OPEN				50865-6
	CLOSED				50865-5
OBSOLETE	OPEN		GOLD 3	GOLD 2	50865-4
OBSOLETE			TIN 1		50865-3
	KNOCKOUT		GOLD 3		50865-2
OBSOLETE			TIN 1		50865-1
	CLOSED		GOLD 3		50865
NOTES	BOTTOM TYPE	RECOMMENDED PIN DIA. 7	EYELET	SPRING	PART NO
			FINISH		

THIS DRAWING IS A CONTROLLED DOCUMENT. DWN 4-5-91 R. TALLEY

DIMENSIONS: mm [INCHES] TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC	± -
1 PLC	± -
2 PLC	± -
3 PLC	± 0.20 [.008]
4 PLC	± -
ANGLES	± -

MATERIAL: FINISH: 10

APVD: -  
 PRODUCT SPEC: -  
 APPLICATION SPEC: -  
 WEIGHT: -

**Tyco Electronics** Tyco Electronics Corporation  
 Harrisburg, Pa 17105-3608

NAME: MINIATURE SPRING SOCKET ASSEMBLY  
 SERIES 4

SIZE: A2 CAGE CODE: 00779 DRAWING NO: C=50865 RESTRICTED TO: -

CUSTOMER DRAWING SCALE: 1:1 SHEET: 1 OF 1 REV: AG1