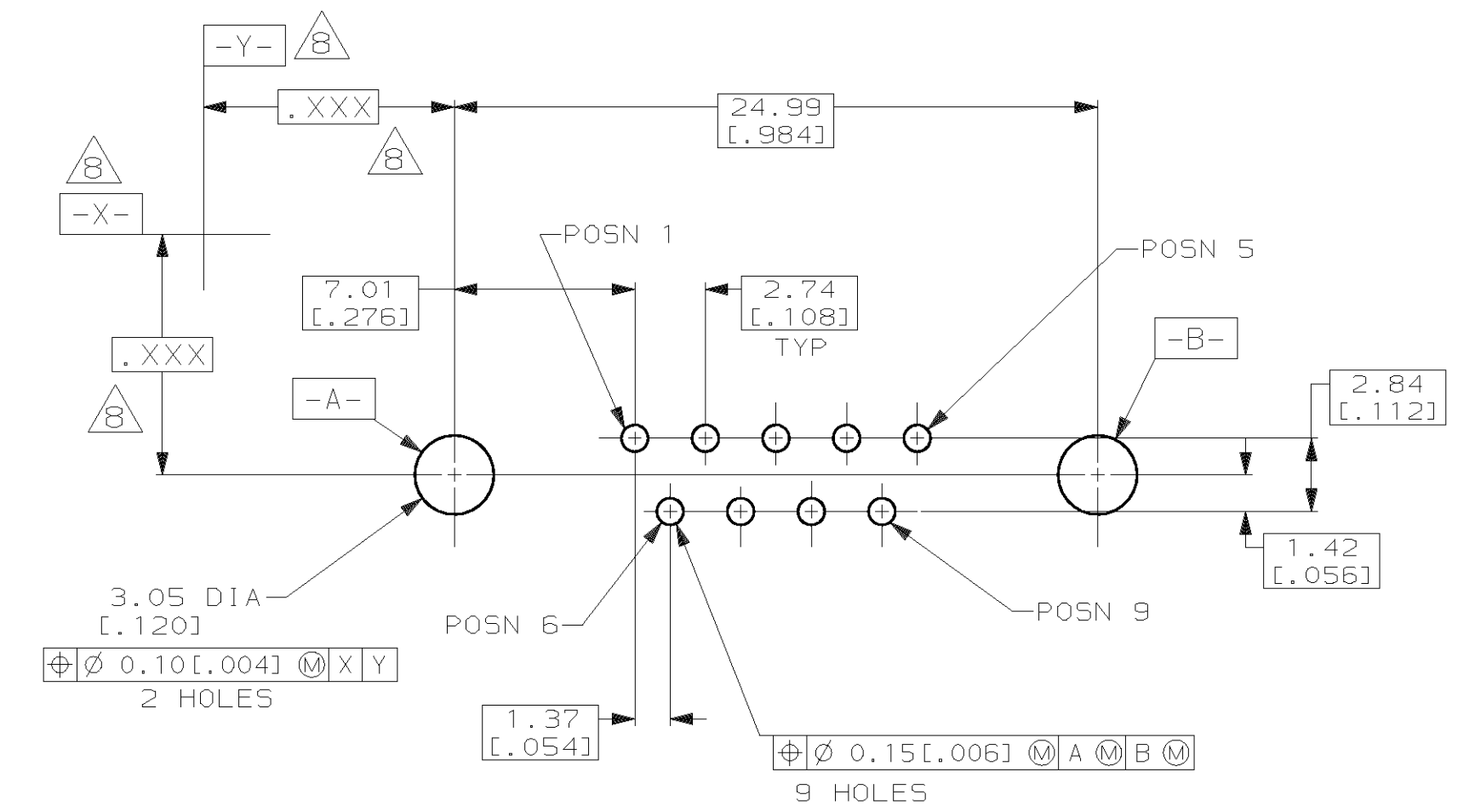
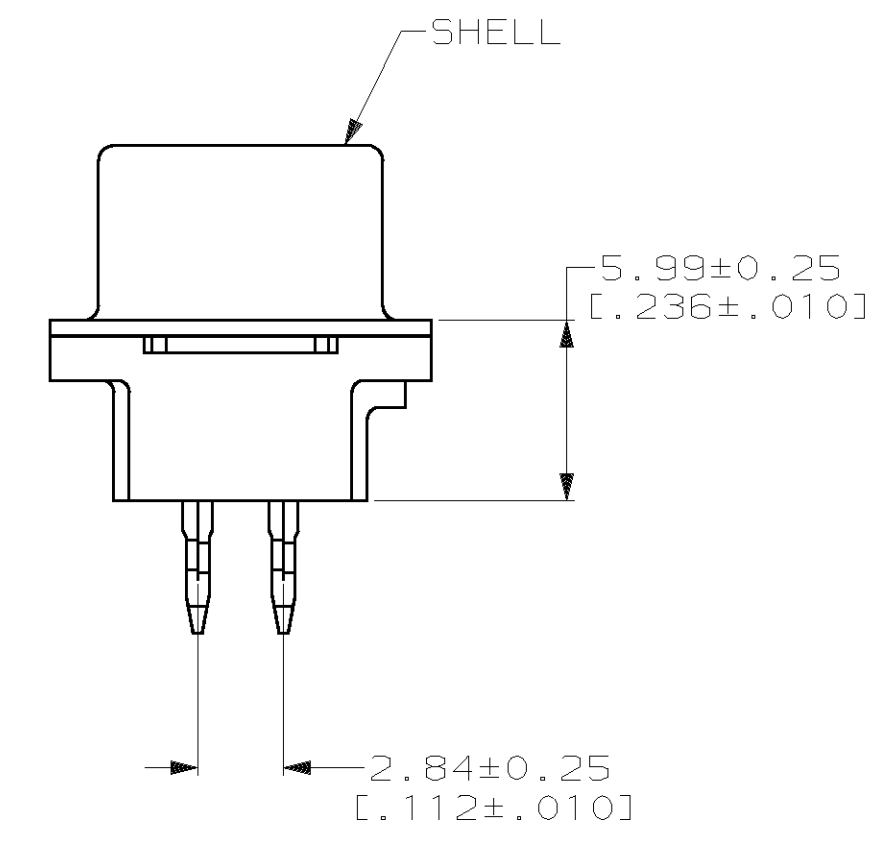
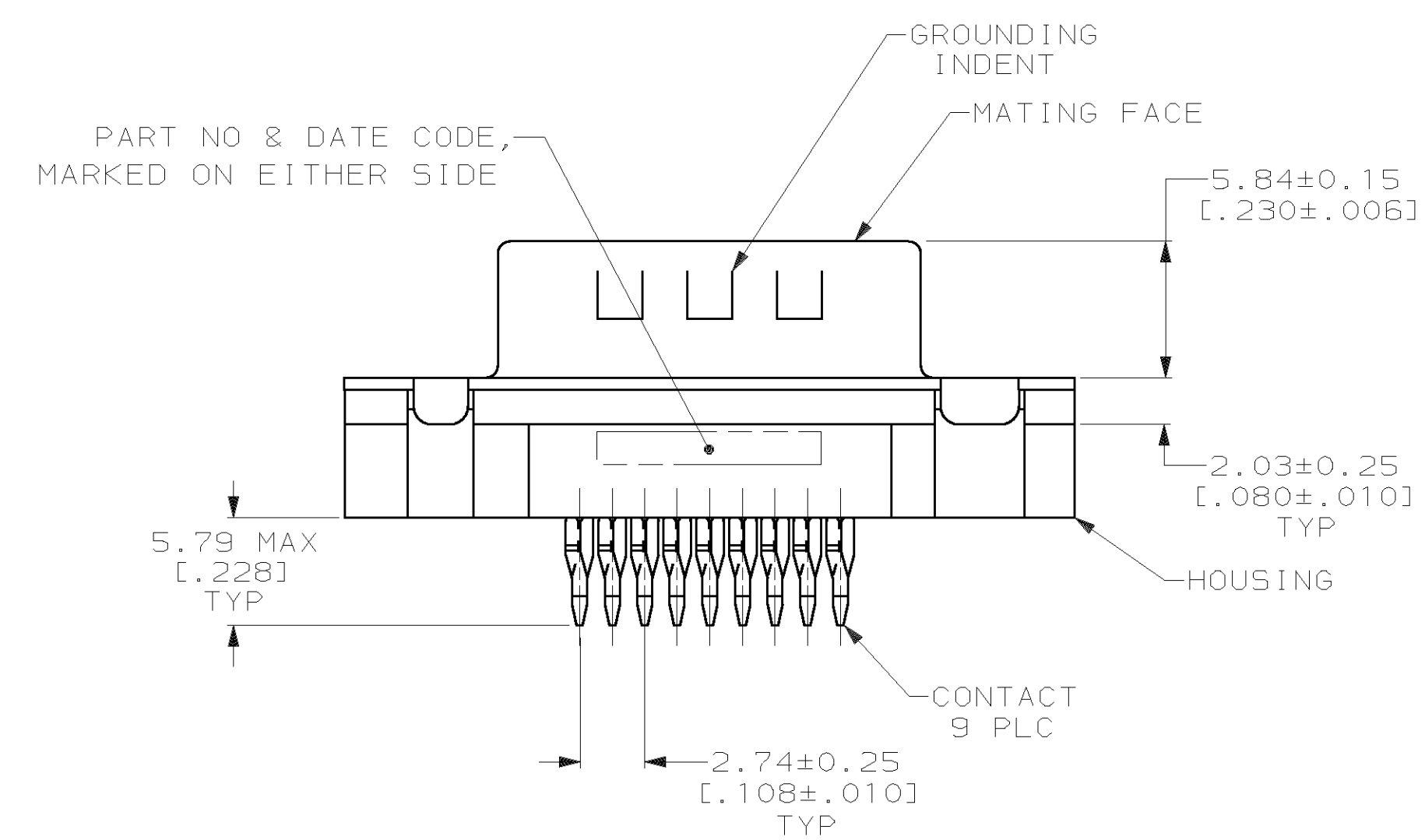
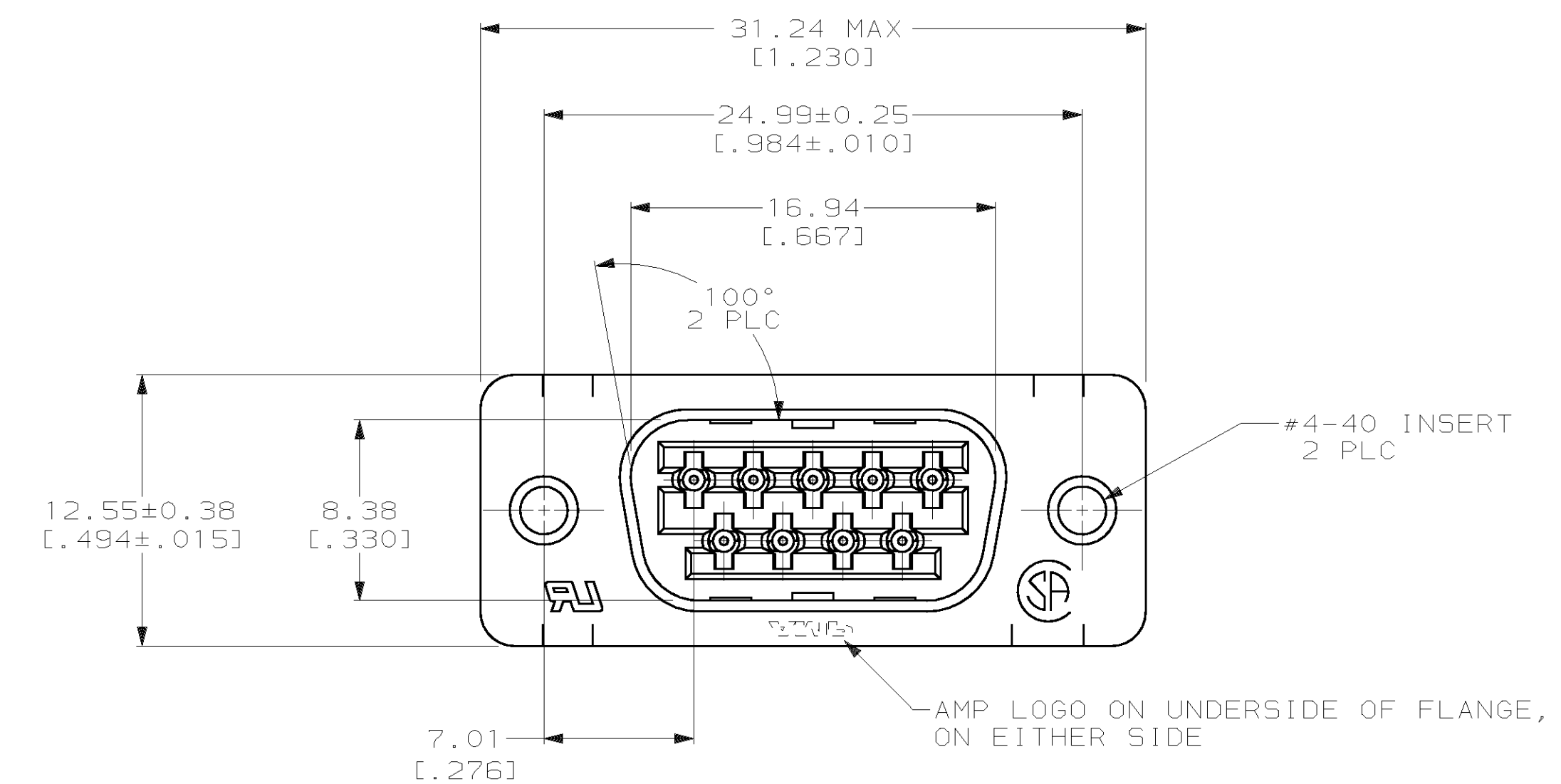


LOC	DIST	P	F	ZONE	LTR	DESCRIPTION	DATE	APPD
BD	77							
						0 RLSE PER NPR 4667, WAS 93-4913-1	3-24-93	-
						A REVISED PER EC 0020-1556-93	01/26/94	MP
						B REV PER EC 0320-288-97	08 SEP 97	A0
						C REV PER EC 0640-448-98	01 MAR 99	RT



RECOMMENDED PC BOARD LAYOUT ①
 CONNECTOR SIDE OF BOARD

- ① RECOMMENDATIONS FOR 2.36 [.093] MIN THICK PC BOARD:
 - A. HOLE DIAMETER AFTER DRILLING = 1.151±0.025 [.0453±.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 0.76µm [.000300] MIN TIN-LEAD OVER 0.05±0.03 [.002±.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 5.08µm [.000200] MIN TIN OVER 2.54µm [.000100] MIN COPPER.
- ⑦ GOLD PLATED FOR A LENGTH OF 3.81 [.150] MIN FROM MATING END, 0.76µm [.000030] MIN GOLD IN MATED AREA. 2.54µm [.000100] MIN TIN-LEAD FOR A LENGTH OF 5.79 [.228] MIN FROM OPPOSITE END, BOTH OVER 1.27µm [.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 ± - ANGLES ± 2°		DR 3-24-93 W.G.LENKER	AMP AMP Incorporated Harrisburg, PA 17105-3508		
CHK 4-5-93 R.STONE		NAME			
APPD 4-6-93 M.PERCHERKE		PRODUCT SPEC	PLUG ASSEMBLY, SIZE 1, 9 POSITION, MEDIUM PROFILE, ACTION PIN™, AMPLIMITE™ HD-20		
APPD 4-6-93 W.PARKER		APPLICATION SPEC	SIZE	CAGE CODE	DRAWING NO
SHELL: ④ INSERTS: BRASS		114-40026	D	00779	C=786830
FINISH ⑤		WEIGHT	SCALE	SHEET	
SHELL: ⑥ CONTACTS: ⑦		-	4:1	1 OF 1	

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.