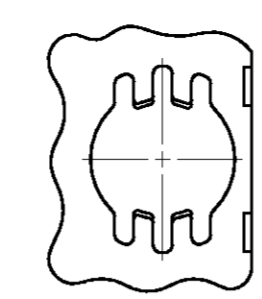
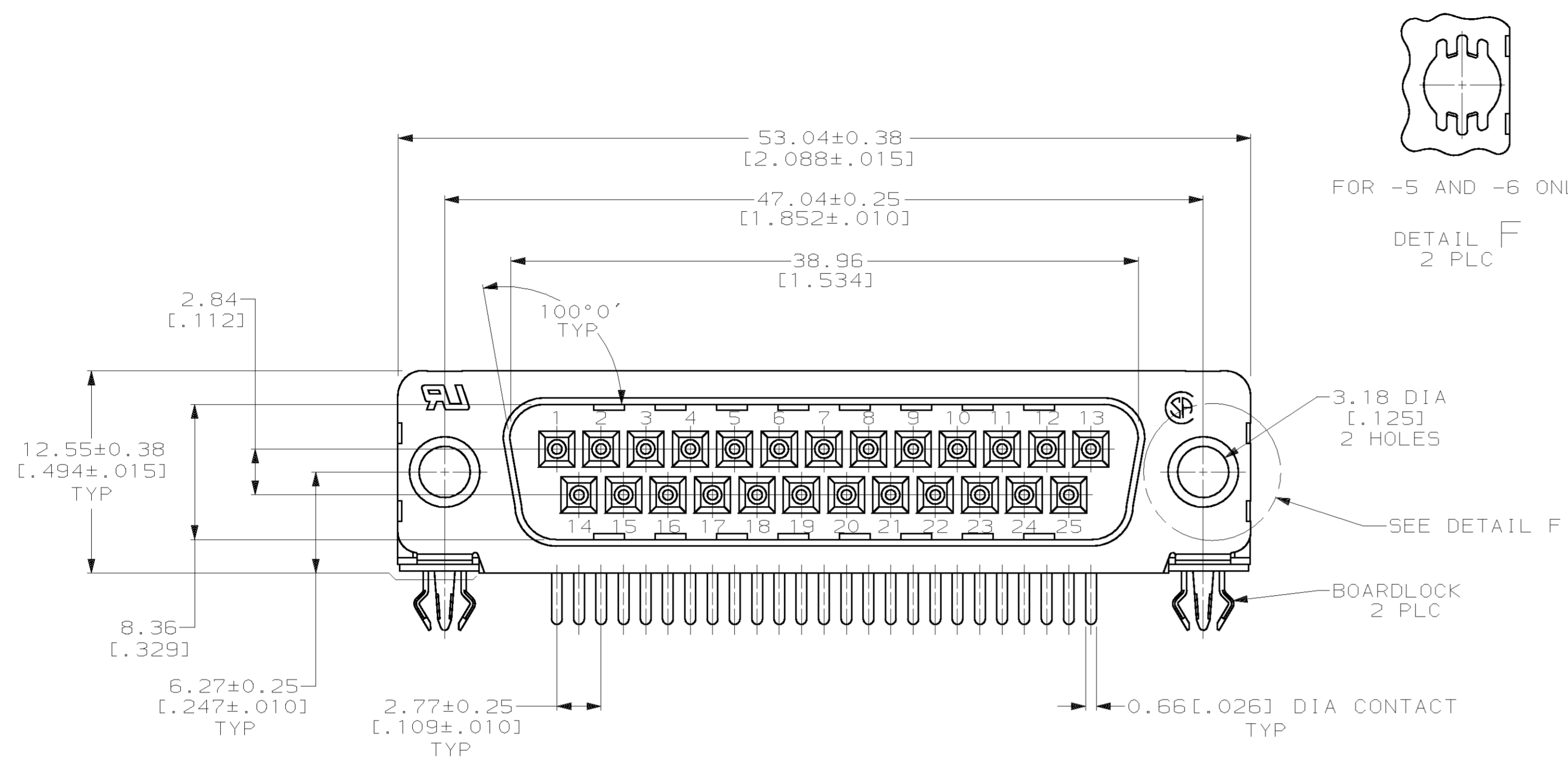
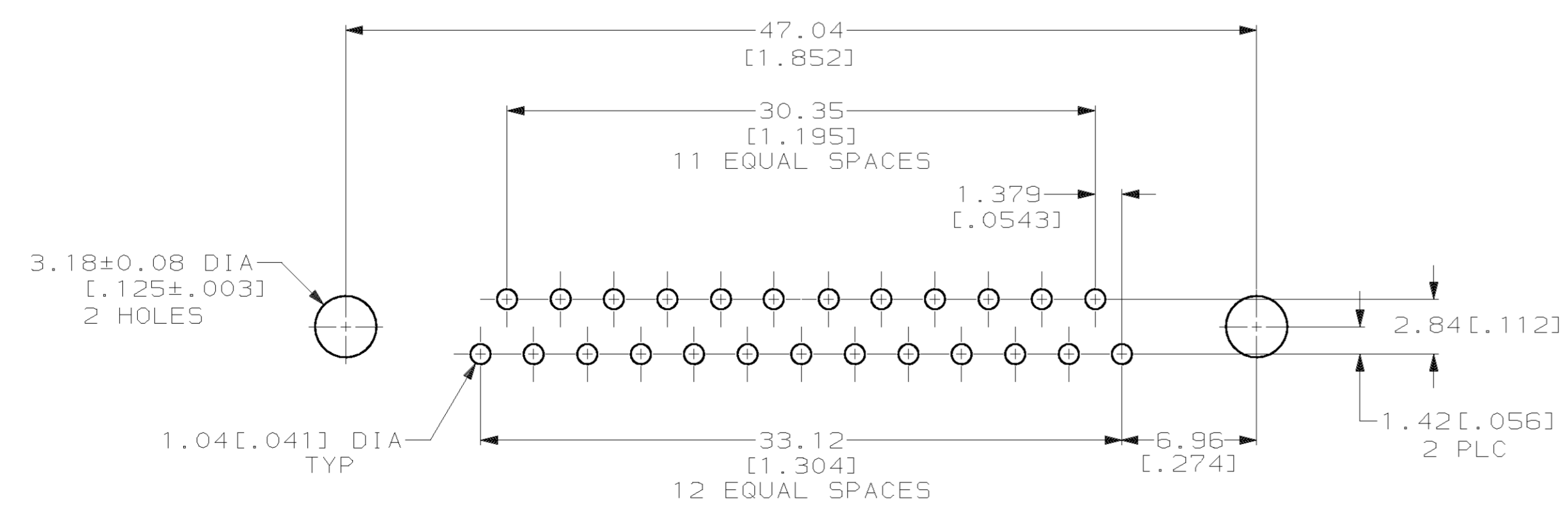
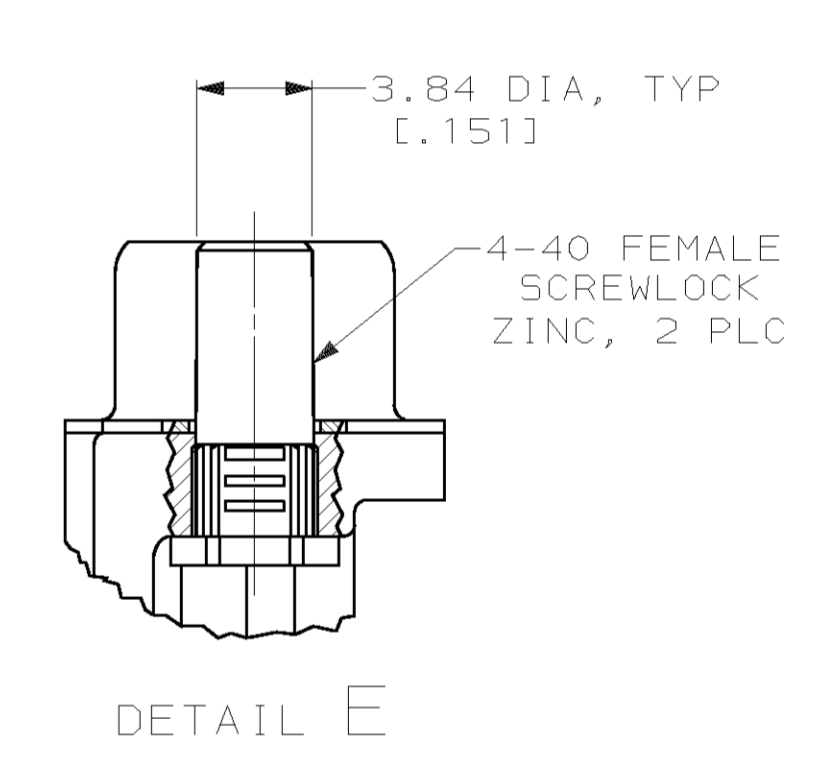
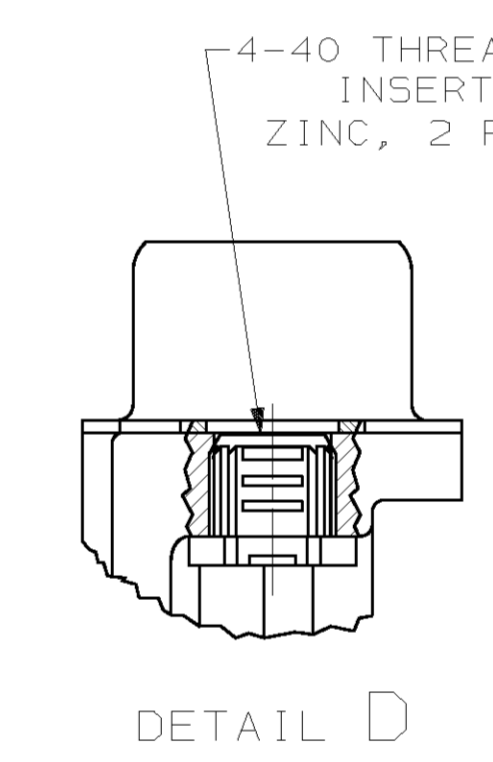
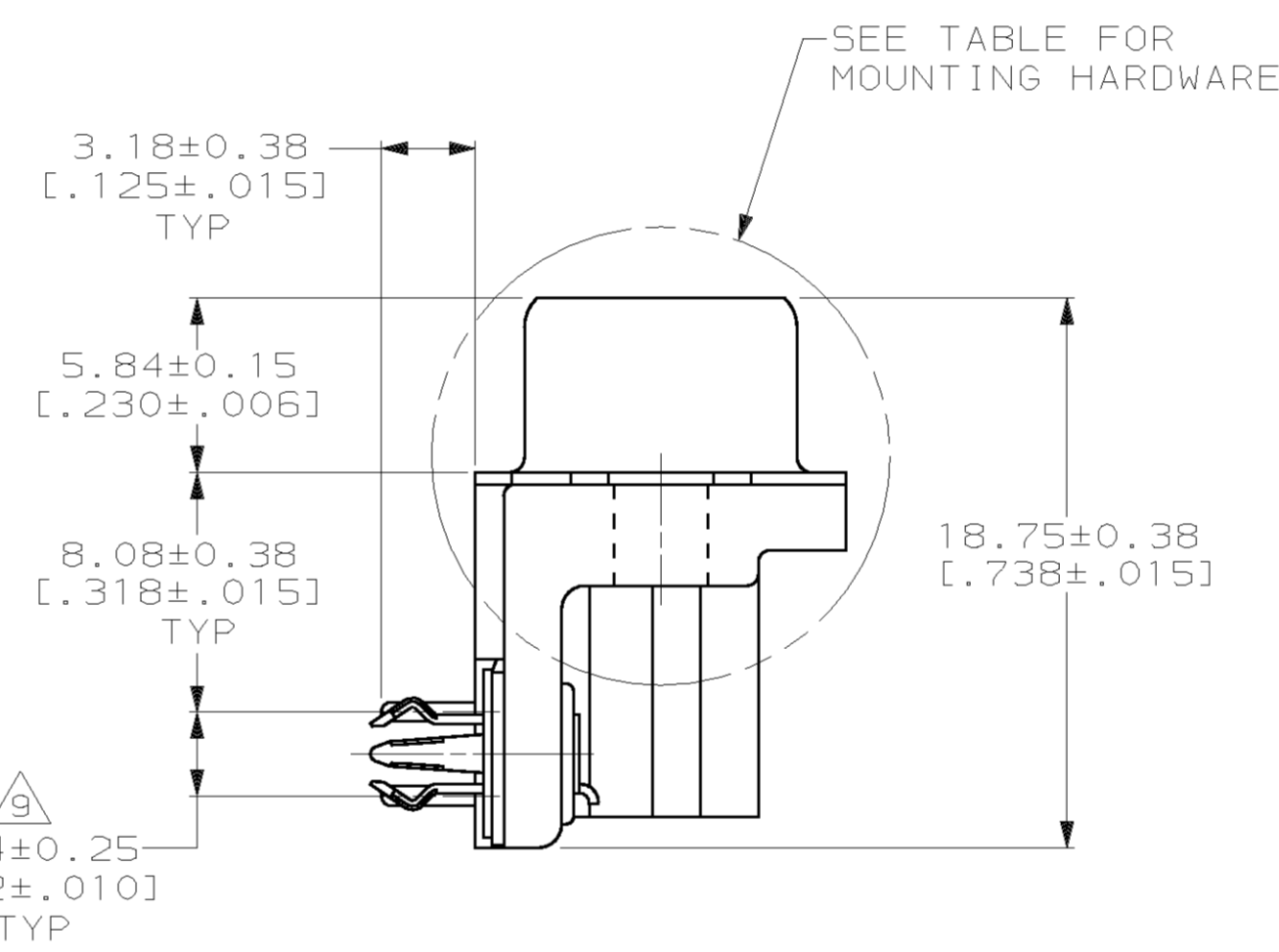
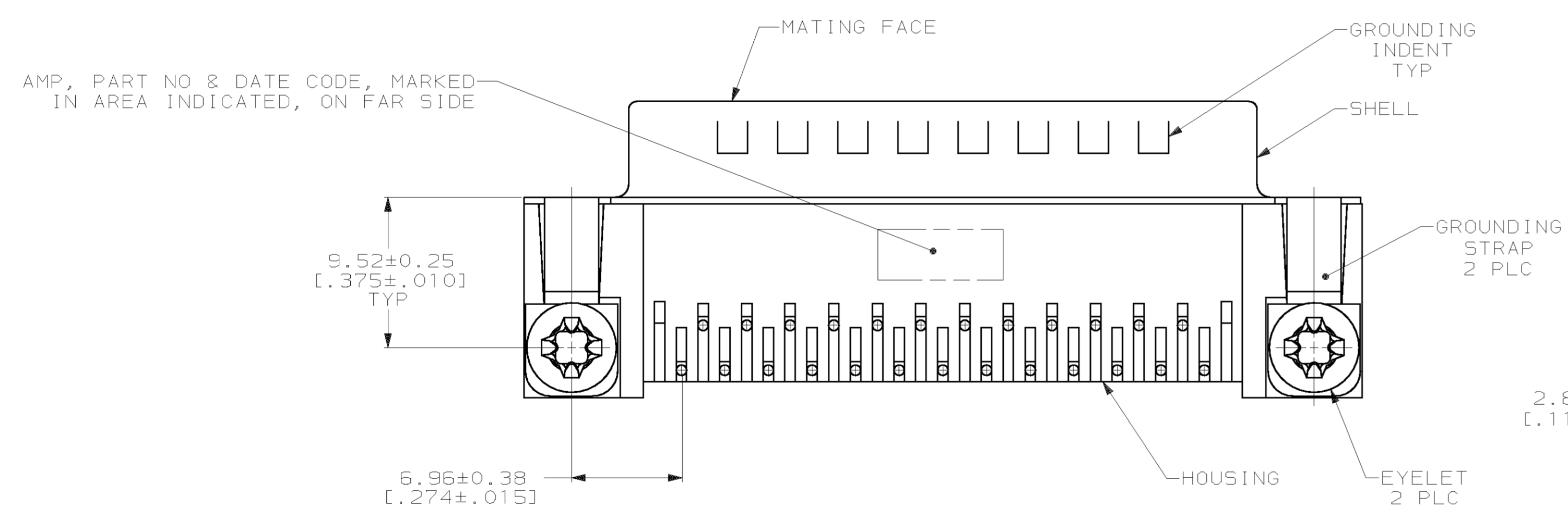


LOC		DIST		P		F		ZONE		LTR		REVISIONS			
GP	00											DESCRIPTION	DATE	APPD	
												N	REVISED PER EC 0513-0176-03	28MAY03	JG



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 [0.000100] MIN TIN OVER 1.27µm [0.000050] MIN COPPER. EYELETS: 5.08µm [0.000200] 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 [0.140] MIN FROM OPPOSITE END, BOTH OVER 1.27µm [0.000050] 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 [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 DIMENSION APPLIES FROM CENTER OF CONTACTS.
- 10 5.08µm [0.000200] MIN TIN-LEAD OVER 1.27µm [0.000050] MIN NICKEL.
- 11 5.08µm [0.000200] MIN TIN OVER 1.27µm [0.000050] 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
SEE DETAIL E	10	8	6-747842-7
SEE DETAIL E	10	8	747842-6
SEE DETAIL D	10	8	747842-5
	10	8	747842-4
	10	8	747842-3
	10	8	747842-2
	10	8	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 [0.005] 3 PLC DEC ± - ANGLES ± 2°0'	DR 10-5-89 W.G.LENKER	AMP INCORPORATED Harrisburg, Pa. 17105	
MATERIAL HOUSING: 1 SHELL: 2 HARDWARE: 4 FINISH: 6	CHK 2-5-90 R. STONE		
	APPD 2-6-90 M.D.GALLOWAY	NAME	
	APPD 2-6-90 C. RÖHDE	PLUG ASSEMBLY, SIZE 3, 25 POSITION, RIGHT ANGLE, FRONT METAL SHELL, .318 SERIES, BOARDLOCKS, AMPLIMITE® HD-20	
	PRODUCT SPEC 108-40025	SIZE D	CAGE CODE 00779
	APPLICATION SPEC 114-40010	DRAWING NO	747842
	WEIGHT	SCALE 4:1	SHEET 1 OF 1