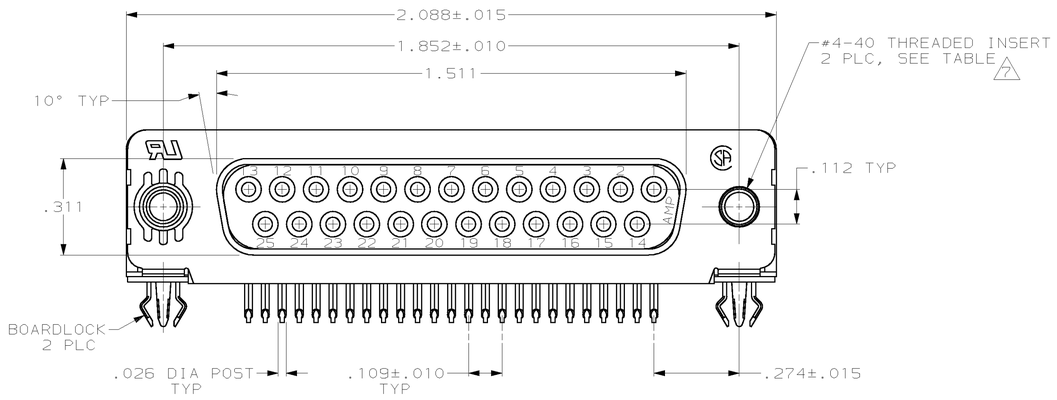
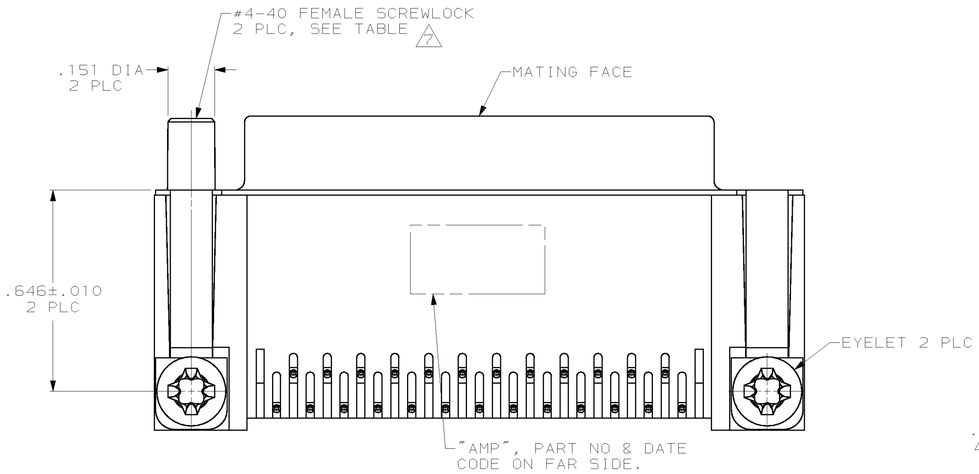
THIS DRAWING IS UNPUBLISHED. RELEASED FOR PUBLICATION ,19 .
© COPYRIGHT 19 BY AMP INCORPORATED. ALL RIGHTS RESERVED.

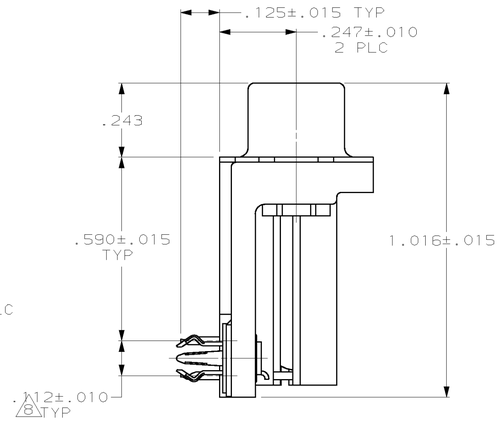
LOC	DIST
BD	77

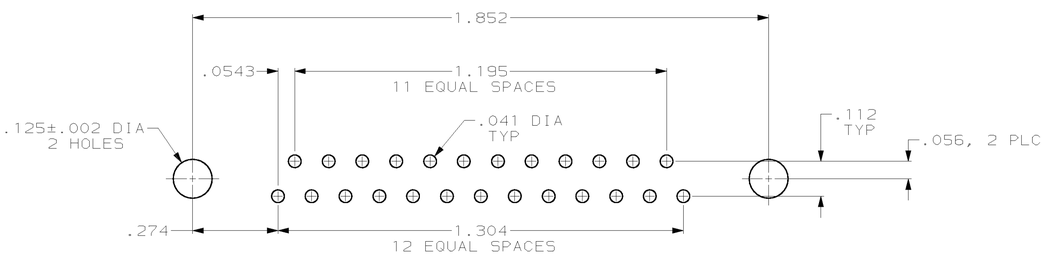
REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	T	REV PER EC 0G40-0285-99	15FEB00	DD	KB
	U	REV PER EC 0U1D-0142-00	08 MAY 00	DB	JK









RECOMMENDED P.C. BOARD MOUNTING DIMENSIONS

1. CONNECTOR MATES WITH ANY 25 POSN PLUG IN AMPLIMITE™ SERIES.

2. MOLDED PARTS: FLAME RETARDANT 94V-0 RATED THERMOPLASTIC, BLACK.
SHELL: STEEL PER ASTM A109
CONTACTS: PHOSPHOR BRONZE PER QQ-B-750
EYELETS: BRASS
SCREWLOCKS: ZINC
INSERTS: ZINC
BOARDLOCKS: COPPER ALLOY

3. SHELL: .000100 MIN TIN OR TIN-LEAD
CONTACTS: SEE TABLE
EYELETS: TIN
SCREWLOCKS: CLEAR CHROMATE
BOARDLOCKS: TIN-LEAD
INSERTS: CLEAR CHROMATE

4. GOLD PLATING PER MIL-G-45204, NICKEL PLATING PER QQ-N-290, TIN PLATING PER MIL-T-10727.

5. GOLD FLASH FOR A DISTANCE OF .100 MIN FROM MATING END, .000100-.000200 BRIGHT TIN OR BRIGHT TIN-LEAD ON TERMINATION END, ALL OVER .000050 NICKEL ON ENTIRE CONTACT.

6. .000030 GOLD FOR A DISTANCE OF .100 MIN FROM MATING END, .000100-.000200 BRIGHT TIN OR BRIGHT TIN-LEAD ON TERMINATION END, ALL OVER .000050 NICKEL ON ENTIRE CONTACT.

7. SCREWLOCKS & INSERTS WILL WITHSTAND 4 IN-LBS TORQUE & 20 LBS PULL OUT FORCE FROM MATING FACE SIDE.

8. DIMENSION APPLIES FROM CENTER OF CONTACTS.

	MOUNTING HARDWARE	CONTACT FINISH 4	PART NUMBER
	FEMALE SCREWLOCKS	6	747830-6
SUPSD BY 747830-6	FEMALE SCREWLOCKS	5	747830-5
	THREADED INSERTS	6	747830-4
SUPSD BY 747830-4	THREADED INSERTS	5	747830-3
OBSOLETE	.125 DIA HOLES	6	747830-2
OBSOLETE	.125 DIA HOLES	5	747830-1

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: INCHES

TOLERANCES UNLESS OTHERWISE SPECIFIED:
0 PLC ±-
1 PLC ±-
2 PLC ±-
3 PLC ±.005
4 PLC ±-
ANGLES ±2°

MATERIAL 2

FINISH 3

DWN W.G. LENKER 05-OCT-89
CHK R. STONE 05-FEB-90
APVD M.D. GALLOWAY 06-FEB-90
PRODUCT SPEC 108-40025
APPLICATION SPEC 114-40010
WEIGHT —

CUSTOMER DRAWING

AMP Incorporated
Harrisburg, PA 17105-3608

NAME RECEPTACLE ASSEMBLY, SIZE 3, 25 POSITION, RIGHT ANGLE, FRONT METAL SHELL, .590 SERIES, .026 DIA POSTS, BOARDLOCKS, AMPLIMITE™ HD-20

SIZE	CAGE CODE	DRAWING NO	RESTRICTED TO
A1	00779	C-747830	—

SCALE 4:1 SHEET 1 OF 1 REV U