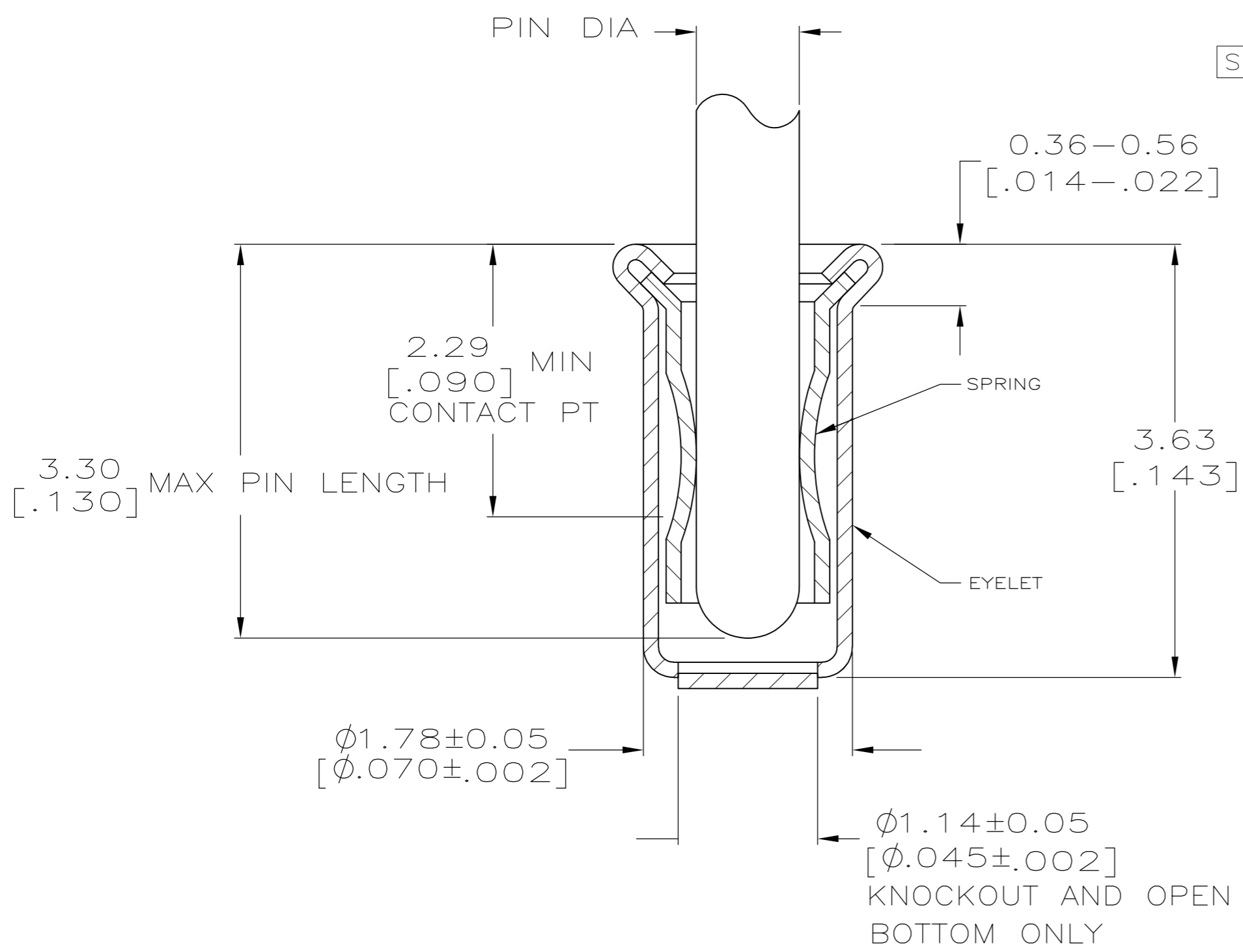
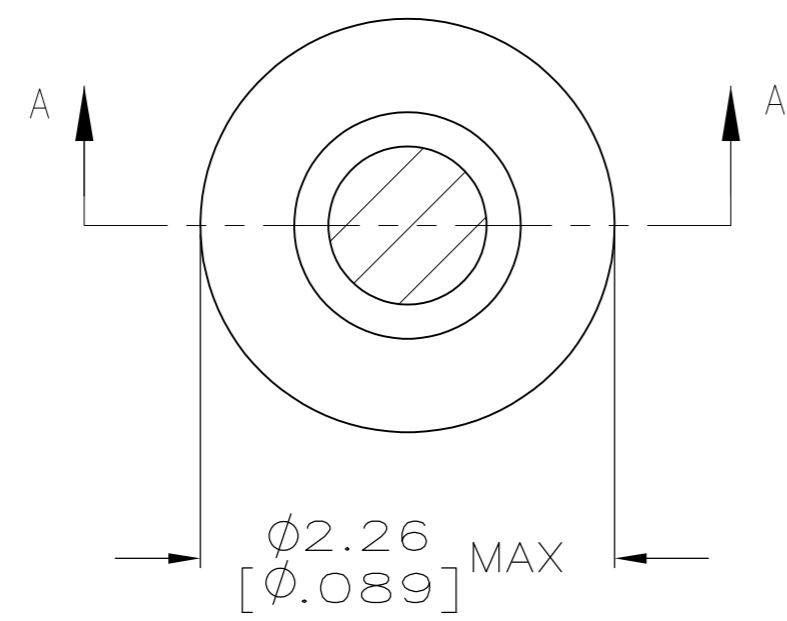


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LOC		DIST		REVISIONS			
P	LTR	DESCRIPTION		DATE	DWN	APVD	
		AK1		REVISED PER ECO-11-004835	11MAR11	RK HMR	

- 1. TIN PER MIL-T-10727 OR TIN LEAD 0.00254 [.000100] MIN THK.
- 2. NICKEL UNDERPLATE ALL OVER, MATING SURFACE PLATED TO MEET PERFORMANCE REQUIREMENTS OF TE CONNECTIVITY 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. TIN PER MIL-T-10727 OR TIN LEAD 0.00381 [.000150] MIN THK.
- 5. RECOMMENDED HOLE SIZE, PLATED OR UNPLATED:
 MACHINE INSERTION: 1.83 ^{+0.10}/_{-0.08} [.072 ^{+0.004}/_{-0.003}]
 HAND INSERTION: 1.83 ^{+0.10}/_{-0.00} [.072 ^{+0.004}/_{-0.000}]
- 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. MATERIAL: SPRING: BERYLLIUM COPPER (QQ-C-533)
 EYELET: COPPER (QQ-C-576)



SECTION A-A

FINISH	RECOMMENDED PIN DIA	FINISH	FINISH	PART NO
TIN 1	0.71-0.84 [.028-.033]	GOLD 2	GOLD 2	4-332070-4
	0.94-1.02 [.037-.040]			4-332070-3
TIN 1	0.94-1.02 [.037-.040]	GOLD 2	TIN 1	3-332070-9
				3-332070-5
TIN 1	0.76-0.84 [.030-.033]	GOLD 2	TIN 1	3-332070-4
				3-332070-3
TIN 1	0.94-1.02 [.037-.040]	GOLD 2	TIN 1	3-332070-0
				2-332070-9
TIN 1	0.86-0.94 [.034-.037]	GOLD 2	TIN 1	2-332070-8
				2-332070-7
TIN 1	0.76-0.84 [.030-.033]	GOLD 2	TIN 1	2-332070-6
				2-332070-5
TIN 1	0.94-1.02 [.037-.040]	GOLD 2	TIN 1	2-332070-4
				2-332070-3
TIN 1	0.86-0.94 [.034-.037]	GOLD 2	TIN 1	2-332070-2
				2-332070-1
TIN 1	0.76-0.84 [.030-.033]	GOLD 2	TIN 1	2-332070-0
				1-332070-9
GOLD 3	0.94-1.02 [.037-.040]	GOLD 2	GOLD 2	1-332070-8
				1-332070-7
GOLD 3	0.94-1.02 [.037-.040]	GOLD 2	GOLD 2	1-332070-4
				1-332070-3
GOLD 3	0.86-0.94 [.034-.037]	GOLD 2	GOLD 2	1-332070-3
				1-332070-2
GOLD 3	0.94-1.02 [.037-.040]	GOLD 2	GOLD 2	1-332070-2
				1-332070-1
GOLD 3	0.86-0.94 [.034-.037]	GOLD 2	GOLD 2	1-332070-1
				1-332070-0
GOLD 3	0.76-0.84 [.030-.033]	GOLD 2	GOLD 2	332070

THIS DRAWING IS A CONTROLLED DOCUMENT.

DIMENSIONS: mm [INCHES]	TOLERANCES UNLESS OTHERWISE SPECIFIED:	DWN R. TALLEY 4-5-91	TE Connectivity
0 PLC ± -	1 PLC ± -	CHK R. MILLER 8-5-91	
2 PLC ± -	3 PLC ± 0.20 [.008]	APVD S. ROBERTSON 8-22-91	MINIATURE SPRING SOCKET ASSEMBLY, SERIES 4
4 PLC ± -	ANGLES ± -	PRODUCT SPEC	
MATERIAL	FINISH	APPLICATION SPEC	SIZE CAGE CODE DRAWING NO RESTRICTED TO
	SEE TABLE	WEIGHT	A2 00779 C=332070
		CUSTOMER DRAWING	SCALE 20:1 SHEET 1 OF 1 REV AK1