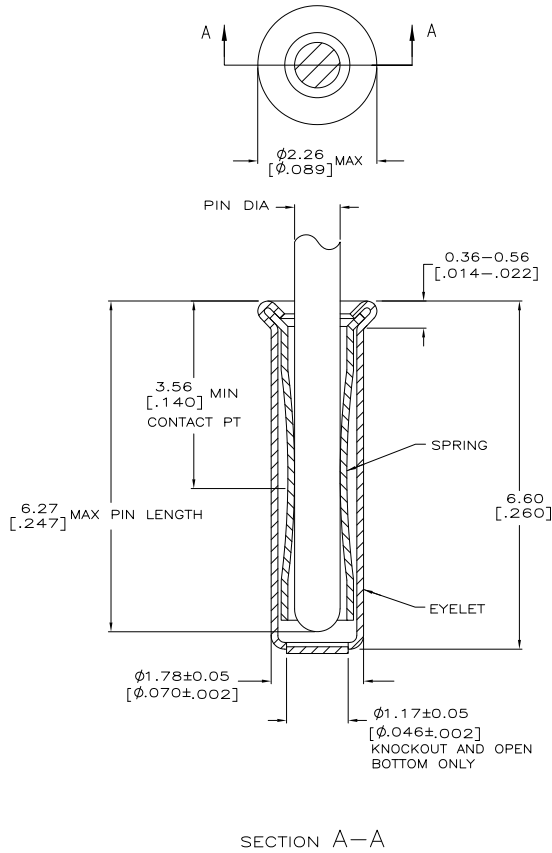


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LOC	REV	DATE	DESCRIPTION	BY	APPD
GP	00				
	A1	11MAR11	REVISED PER ECO-11-004835	RK	HMR



- △ TIN PLATE PER ASTM-B-545 .00254 [.000100] MINIMUM THICK.
- △ NICKEL UNDERPLATE ALL OVER, MATING SURFACE PLATED TO MEET PERFORMANCE REQUIREMENTS OF TE CONNECTIVITY PRODUCT SPECIFICATION 108-14008.
- 3. RECOMMENDED HOLE SIZE, PLATED OR UNPLATED:
 MACHINE INSERTION: 1.83 $\begin{matrix} +0.10 \\ -0.08 \end{matrix}$ [.072 $\begin{matrix} +.004 \\ -.003 \end{matrix}$]
 HAND INSERTION: 1.83 $\begin{matrix} +0.10 \\ -0.00 \end{matrix}$ [.072 $\begin{matrix} +.004 \\ -.000 \end{matrix}$]
- 4. APPLICATION TOOL PART NUMBER:
 MACHINE NO. 682127-5
 INSERTION HEAD NO. 682039-4
- △ TO INSURE PROPER SPRING TENSION DO NOT EXCEED A 0.05 [.002] DIFFERENCE IN PIN DIA WHEN CHANGING TO A SMALLER PIN.
- 6. BOTTOM PLUG KNOCKOUT TOOL PART NUMBER 69729 WITH TIP PART NUMBER 69728-2.
- △ MATERIAL: SPRING: BERYLLIUM COPPER QQ-C-533
 EYELET: COPPER, QQ-C-576

CLOSED KNOCKOUT	RECOMMENDED PIN DIA	EYELET FINISH	SPRING FINISH	PART NO
OPEN	0.86-1.04 [.034-.041]	TIN △	TIN △	5050865-8
CLOSED		GOLD △	GOLD △	5050865-7
CLOSED KNOCKOUT				5050865-6
OPEN				5050865-5
CLOSED				5050865-3
OPEN				5050865-1

THIS DRAWING IS A CONTROLLED DOCUMENT.		DATE: 20APR2009	BY: J. HAVENER	APPD: J. HAVENER	DATE: 25JUL2009
DIMENSIONS: mm (INCHES)		DESIGNED BY: J. ALGORTA	DESIGNED BY: J. HAVENER	DESIGNED BY: J. HAVENER	DESIGNED BY: J. HAVENER
TOLERANCES UNLESS OTHERWISE SPECIFIED		PRODUCT SPEC: 108-14008	APPLICATION SPEC: 114-13152	WEIGHT: -	SIZE: A2
MATERIAL: △		FINISH: SEE TABLE	SCALE: 20:1	SHEET: 1 of 1	REV: A1