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LOC

DIST

FT

64

REVISIONS

P	LTR	DESCRIPTION	DATE	DWN	APVD
	AL	REVISED PER ECO-12-000901	09MAY12	KH	AS

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, 0.13-2.5µm [.000005-.000100] 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
HAND INSERTION:1.83±0.10

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)

OBSOLETE	OPEN	0.71-0.84 [.028-.033]	TIN	1	GOLD	2	4-332070-4
		0.94-1.02 [.037-.040]			GOLD	2	4-332070-3
SUPSD BY 1-332070-9							3-332070-9
OBSOLETE	KNOCKOUT	0.94-1.02 [.037-.040]	TIN	1	GOLD	2	3-332070-5
OBSOLETE					TIN	1	3-332070-4
	KNOCKOUT	0.76-0.84 [.030-.033]					3-332070-3
OBSOLETE	OPEN	0.94-1.02 [.037-.040]			TIN	1	3-332070-0
OBSOLETE					GOLD	2	2-332070-9
OBSOLETE		0.86-0.94 [.034-.037]			TIN	1	2-332070-8
OBSOLETE					GOLD	2	2-332070-7
OBSOLETE		0.76-0.84 [.030-.033]			TIN	1	2-332070-6
OBSOLETE			TIN	1	GOLD	2	2-332070-5
	CLOSED	0.94-1.02 [.037-.040]			TIN	1	2-332070-4
		0.86-0.94 [.034-.037]			GOLD	2	2-332070-3
OBSOLETE		0.76-0.84 [.030-.033]			TIN	1	2-332070-2
	KNOCKOUT	0.94-1.02 [.037-.040]			GOLD	2	2-332070-1
	OPEN	0.94-1.02 [.037-.040]			TIN	1	2-332070-0
OBSOLETE		0.86-0.94 [.034-.037]			GOLD	2	1-332070-9
OBSOLETE	CLOSED	0.94-1.02 [.037-.040]			TIN	1	1-332070-8
		0.76-0.84 [.030-.033]					1-332070-7
							1-332070-4
							1-332070-3
			GOLD	3	GOLD	2	1-332070-2
							1-332070-1
							1-332070-0
							332070
	BOTTOM TYPE	RECOMMENDED PIN DIA	7	EYELET	SPRING	PART NO	

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	4-5-91	TE Connectivity	
		CHK	8-5-91		
		APVD	8-22-91		
		PRODUCT SPEC			
		APPLICATION SPEC			
		WEIGHT	-		
CUSTOMER DRAWING		SCALE		SHEET	REV
		20:1		1 OF 1	AL

3.30
[.130] MAX

PIN LENGTH

2.29
[.090] MIN

CONTACT PT

0.36-0.56
[.014-.022]

SPRING

3.63
[.143]

EYELET

Ø1.78±0.05
[Ø.070±.002]

Ø1.14±0.05
[Ø.045±.002]

KNOCKOUT AND OPEN
BOTTOM ONLY

PIN DIA

SECTION A-A

Ø2.26
[Ø.089] MAX

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OBSOLETE		0.86-0.94 [.034-.037]			TIN	1	2-332070-8
OBSOLETE					GOLD	2	2-332070-7
OBSOLETE		0.76-0.84 [.030-.033]			TIN	1	2-332070-6
OBSOLETE			TIN	1	GOLD	2	2-332070-5
	CLOSED	0.94-1.02 [.037-.040]			TIN	1	2-332070-4
		0.86-0.94 [.034-.037]			GOLD	2	2-332070-3
OBSOLETE		0.76-0.84 [.030-.033]			TIN	1	2-332070-2
	KNOCKOUT	0.94-1.02 [.037-.040]			GOLD	2	2-332070-1
	OPEN	0.94-1.02 [.037-.040]			TIN	1	2-332070-0
OBSOLETE		0.86-0.94 [.034-.037]			GOLD	2	1-332070-9
OBSOLETE	CLOSED	0.94-1.02 [.037-.040]			TIN	1	1-332070-8
		0.76-0.84 [.030-.033]					1-332070-7
							1-332070-4
							1-332070-3
			GOLD	3	GOLD	2	1-332070-2
							1-332070-1
							1-332070-0
							332070
	BOTTOM TYPE	RECOMMENDED PIN DIA	7	EYELET	SPRING	PART NO	

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		APPLICATION SPEC			
		WEIGHT	-		
CUSTOMER DRAWING		SCALE		SHEET	REV
		20:1		1 OF 1	AL

1471-9 (3/11)