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LOC	DIST	REVISIONS			
P	LTR	DESCRIPTION	DATE	DWN	APVD
FT	64	A1	REVISED PER ECO-11-004835	11MAR11	RK HMR

Top view showing a circular hole with a diameter of $\phi 2.26$ [0.089] MAX.

Section A-A view showing internal components: PIN DIA, SPRING, EYELET, and dimensions for contact point, pin length, and knockout diameters.

Dimensions:
 0.36-0.56 [.014-.022]
 2.29 [.090] MIN CONTACT PT
 3.30 [.130] MAX PIN LENGTH
 3.63 [.143]
 $\phi 1.78 \pm 0.05$ [$\phi 0.070 \pm 0.002$]
 $\phi 1.14 \pm 0.05$ [$\phi 0.045 \pm 0.002$] KNOCKOUT AND OPEN BOTTOM ONLY

SECTION A-A

1. TIN PLATE PER ASTM B 545 0.00254 [.000100] MIN THICK.
2. 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: $1.83^{+0.10}_{-0.08}$ [$.072^{+0.004}_{-0.003}$]
 - HAND INSERTION: $1.83^{+0.10}_{-0.00}$ [$.072^{+0.004}_{-0.000}$]
4. APPLICATION TOOL PART NUMBER: MACHINE NO. 682127-5
INSERTION HEAD NO. 682039-4
5. 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.
7. MATERIAL:
 SPRING: BERYLLIUM COPPER PER ASTM B 194
 EYELET: COPPER PER ASTM B 152

OBSOLETE

OPEN	0.71-0.84 [.028-.033]	TIN	1	GOLD	4-5332070-4
KNOCKOUT	0.94-1.02 [.037-.040]			TIN	3-5332070-5
OPEN	0.94-1.02 [.037-.040]	TIN	1	TIN	2-5332070-9
	0.86-0.94 [.034-.037]			TIN	2-5332070-8
	0.76-0.84 [.030-.033]			TIN	2-5332070-6
CLOSED	0.94-1.02 [.037-.040]	TIN	1	GOLD	2-5332070-5
	0.86-0.94 [.034-.037]			TIN	2-5332070-3
BOTTOM TYPE	RECOMMENDED PIN DIA	EYELET	5	TIN	2-5332070-2
				GOLD	2-5332070-1
				SPRING	PART NO
				FINISH	

THIS DRAWING IS A CONTROLLED DOCUMENT.		DWN	22APR2005	A. FERNANDEZ-DOCK5	
DIMENSIONS: INCHES		CHK	22APR2005	J. HAVENER	
TOLERANCES UNLESS OTHERWISE SPECIFIED:		APVD	22APR2005	J. HAVENER	
0 PLC ± -		PRODUCT SPEC		108-14008	
1 PLC ± -		APPLICATION SPEC		114-13152	
2 PLC ± -		WEIGHT		-	
3 PLC ± 0.20 [.008]		CUSTOMER DRAWING		SCALE 20:1	
4 PLC ± -		SHEET		1 of 1	
ANGLES ± -		REV		A1	
FINISH		SEE TABLE			

1471-9 (3/11)

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