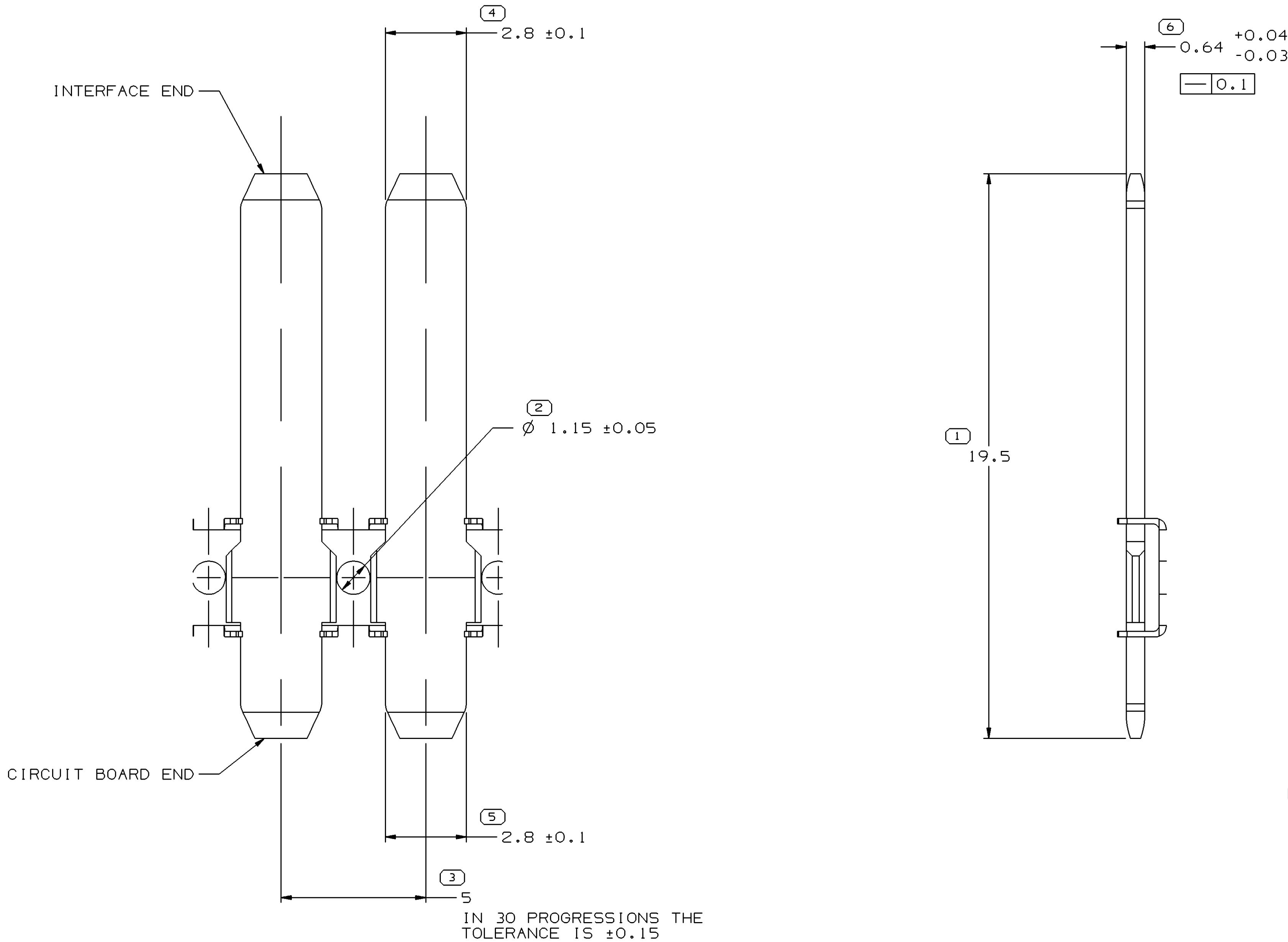


SYMBOL DEFINITION			MISSING SYMBOLS	
A DIMENSION WITHOUT AN INSPECTION REPORT SYMBOL DOES NOT REQUIRE INSPECTION. IT MAY BE CONTROLLED ON THE INDIVIDUAL COMPONENT DRAWING.	TOTAL NO OF INSPECTIONS REQUIRED	6	NO MISSING SYMBOL NUMBER	
	LAST NO. USED	6		

DWG STATUS		ZONE		REVISION HISTORY		AUTH	DR	APVD
DATE	STG	REV	N/P	CHG				
23JN04	R	01	-	-	RELEASED, WAS PE123250	256075	AKJ	AKJ
20AU04	R	02	-	-	1.15 ±0.05 WAS 1.59 ±0.05 REVISED "SOLDERABILITY REQUIREMENT" NOTE	257848	ADK	ADK
04N004	R	02	AA	-	UPDATED PDM ATTRIBUTES	260944	CJP	CJP
02DE04	R	02	AB	-	UPDATED PDM ATTRIBUTES	261759	CCV	JVM
03JA05	R	02	AC	-	MATERIAL SPEC CDA210 WAS M1546 CDA210, REVISED NOTE 1 IN PACKAGING NOTES	262494	CJP	CJP
25JA05	R	02	AD	-	ADDED STRAIGHTNESS REQUIREMENT TO 0.64 ±0.04/-0.03; REMOVED BANDOLIER NOTE	263883	CJP	CJP
16MR05	R	02	AE	-	REVISED TERMINAL PUSHOUT FORCE NOTE	264974	HAM	HAM
09SE05	R	03	-	-	TERMINAL BASE MAT'L WAS CDA 210 EXTRA SPRING TEMPER AND COPPER UNDERPLATE WAS 0.0013 MM MIN	270606	LLJ	LLJ



NOTES

- UNLESS OTHERWISE SPECIFIED AND/OR INDICATED:
DIMENSIONS ARE TO FACE OF VIEW SHOWN AND AUTOMATICALLY ROUNDED BY COMPUTER FOR INSPECTION (SEE MATH MODEL FOR PRECISE DIMENSIONS). FOR ALL OTHER DIMENSIONS NOT SHOWN BUT REQUIRED FOR TOOL BUILD, SEE MATH MODEL FOR PRECISE TOOL PATH DATA.
- THIS PART USED IN PIN BLOCK ASSEMBLY 15491960 OR EQUIVALENT.
- TERMINALS MUST BE FREE OF CRACKS AND TOOL MARKS THAT EXPOSE BASE MATERIAL FOR DISTANCE SHOWN WITH "*", ALL SIDES.
- TERMINALS MUST MEET A TOTAL PUSHOUT FORCE OF 30N +12N/-10N AT AN EXTRACTION RATE OF 50MM/MIN AFTER PLATING. FORCE PER SIDE OF BANDOLIER SHALL BE WITHIN 5N OF FORCE ON OPPOSITE SIDE. FORCE TO BE APPLIED TO EXTRACT PIN FROM BANDOLIER.
- INDICATED END OF POST-PLATED TERMINALS MUST BE IN CONFORMANCE WITH THE SOLDERABILITY REQUIREMENT OF ESO-1514.
- PARTS MUST BE FREE OF ALL PROCESSING LUBRICANTS, PLATING FLAKES, SLIVERS, AND OTHER CONTAMINATION. ANY CLEANING PROCESS MUST NOT DAMAGE THE INTEGRITY OF THE PRODUCT, AND MUST ALLOW THE PARTS TO MEET THE SOLDERABILITY AND STRAIGHTNESS REQUIREMENTS.

MATERIAL SPECIFICATIONS

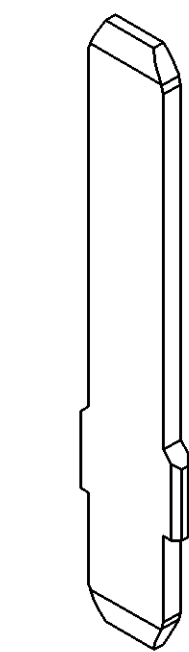
- TERMINAL BASE MATERIAL: CDA260, TENSILE STRENGTH 400-483 MPa, YIELD STRENGTH 310 MPa MIN
- BANDOLIER MATERIAL: CDA260 HARD BRASS OR 1010 COLD ROLLED STEEL

POST-PLATING SPECIFICATIONS

- POST-PLATE WITH COPPER UNDERPLATE OF 0.0025 MM MIN THICKNESS, THEN BRIGHT TIN OVERPLATE 0.0019-0.0038 MM THICK.
- THE ELECTROPLATED TIN SHALL HAVE A BRIGHT FINISH, WITH A COMPOSITION OF 99.9 % TIN MINIMUM.
- PLATING THICKNESS SHALL BE DETERMINED USING A KOCOUR THICKNESS TESTER OR AN X-RAY METHOD, MEASURED AT THE APPROXIMATE CENTER OF THE PLATED AREA.
- ELECTRO-DEPOSIT ADHESION SHALL BE TESTED PER ASTM-B-571. A SECTION OF THE TERMINAL SHALL BE BENT REPEATEDLY THROUGH AN ANGLE OF 180 DEGREES UNTIL SEPARATION OF THE BASE MATERIAL OCCURS. EXAMINATION AT 10X MAGNIFICATION SHALL REVEAL NO SEPARATION OR PEELING OF THE PLATING. FRYING WITH A SHARP BLADE WILL INDICATE UNSATISFACTORY ADHESION BY LIFT OFF OF THE PLATING.

PACKAGING NOTES

- TERMINALS MUST BE SINGLE WRAPPED ON PLASTIC REELS (P/N MHC01050) WITH PASSIVATED PAPER INTERLEAF (P/N MHC01045).
- REELS OF TERMINALS MUST BE PACKAGED IN CLEAN POLYETHYLENE BAGS, EITHER INDIVIDUALLY OR IN LINED CONTAINERS. BAGS MUST BE CLOSED DURING STORAGE AND SHIPMENT WITH A DESICCANT ENCLOSED.
- TERMINALS MUST FLOW OFF BOTTOM OF REEL FROM LEFT TO RIGHT WITH TERMINAL ORIENTATION AS SHOWN. LONG ENDS OF TERMINAL FACE INWARD, SHORT ENDS FACE OBSERVER.
- TERMINALS REMOVED FROM BANDOLIER FOR INSPECTION OR SOLDERABILITY TEST MUST BE REPLACED OR SPLICE THE BANDOLIER
- FULL REELS SHALL NOT EXCEED 30 LBS. IN WEIGHT.



SCALE 5:1

(N/A) PROCESS SENSITIVE DIMENSION	
DIMENSIONS ENCLOSED IN () INDICATE RETROFIT DIMENSIONS AND NO TOLERANCE LIMITS ARE ESTABLISHED	
DIMENSIONAL RANGE (MM)	CHART D
FROM 0	>12
TO 12	
TOLERANCE UNLESS OTHERWISE SPECIFIED	
±0.1	±0.2
ANGULAR TOLERANCE ±2°	

THIRD ANGLE PROJECTION	
DO NOT SCALE	USE MATH DATA



DELPHI	
DELPHI PACKARD ELECTRIC SYSTEMS WARREN, OH	
OR	DATE
APVD1 ANAND JAGANATHAN	23JN04
APVD2 ANAND JAGANATHAN	23JN04
APVD3 RAY BLASKO	23JN04
APVD4	
APVD5	
SUBSTANCES OF CONCERN AND RECYCLED CONTENT PER DELPHI 10949001	
MATERIAL SPEC. NOTES	
DRAWING NAME	
TERM M/M 6T 280 SN	
DRAWING NUMBER	
15491952	
SIZE	SCALE
A0	10:1
FRAME NO	1 OF 1
SHEET NO	1 OF 1
STG	REV
1	03