

8

7

6

5

4

3

2

1

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LOC

DIST

REV

DATE

DWN

APVD

DESCRIPTION

ECO-11-005030

11MAR11

RK

HMR

RAISED CAVITY IDENTIFICATION NUMBERS

B

R.106
.102

[2.69]
[2.59]

TYP

Ø.125
.115

[3.18]
[2.92]

2 PLC

E

10° TYP

C

A

MATING FACE

10° TYP

J

H

R.092
.062

[2.34]
[1.57]

TYP

VIEW Z-Z

3 MARK AMP, PART NO AND DATE CODE, FAR SIDE.

R.065
.040

[1.65]
[1.02]

G

.224 MAX
[5.69]

M

N TYP

SEE DETAIL 'K' TYP

5

SHELL, FRONT
MATL: STEEL PER ASTM A 109
OR EQUIVALENT
FINISH: CADMIUM PER QQ-P-416,
TYPE II, CLASS 2 OVER COPPER PER
MIL-C-14550, CLASS 4

.204
[5.18]

MAX

F

.070
.030

[1.78]
[0.76]

TYP

SHELL, REAR
MATL: STEEL PER ASTM A 109
OR EQUIVALENT
FINISH: CADMIUM PER QQ-P-416,
TYPE II, CLASS 2 OVER COPPER PER
MIL-C-14550, CLASS 4

INSERT ASSEMBLY
MATL: POLYPHENYLENE SULFIDE (PPS) PER MIL-M-24519, TYPE: GST-40F
OR POLYESTER PER MIL-M-24519, TYPE: GLCP-30F OR PPS PER
ASTM D4067, COLOR, BLACK

CONTACT
MATL: BRASS ALLOY PER ASTM B 16, OR BERYLLIUM
COPPER 173, 1/2 HARD PER ASTM-B-197.
FINISH: GOLD PER MIL-G-45204, TYPE II,
GRADE C, CLASS 1 OVER NICKEL PER
QQ-N-290, .000050 MIN THICK

DETAIL K
SCALE 8:1

5

.030 [0.76] MAX
EXTENSION
PERMISSIBLE DUE
TO SOLDER DIP

4

4 REQUIREMENT FOR FULL PIN DIAMETER EXTENSION:
.159 [4.04] MIN, SHELL SIZES 1 AND 2.
.150 [3.81] MIN, SHELL SIZES 3, 4, AND 5.

5 SOLDER DIP PER MIL-STD-2000 COMPOSITION Sn63 CONFORMING TO QQ-S-571.
COVERAGE SHALL BE COMPLETE TO A DISTANCE .020 [0.51] MAX FROM
INSERT ASSEMBLY.

6. THE SOLDER DIP PROCESS IS PERFORMED SUBSEQUENT TO THE COMPLETION
OF PRODUCTION OF THE MILITARY QUALIFIED CONNECTOR. DIMENSIONS
APPLY PRIOR TO SOLDER DIPPING.

7 SPACERS (QTY 2) ARE SUPPLIED WITH CONNECTORS
(NOT ATTACHED TO THE CONNECTOR).

8. DIMENSIONS AND TOLERANCES PER ANSI Y14.5M-1982.

9. THIS DRAWING SHALL BE INTERPRETED IN ACCORDANCE WITH APPLICABLE
STANDARDS LISTED IN MIL-STD-100.

.195 MAX
[4.95]

.120 REF
[3.05]

246±.003
[6.25±0.08]

SPACER
MATL: ALUMINUM ALLOY PER
ASTM B 211
FINISH: IRIDITE PER MIL-C-5541,
CLASS 3, COLOR GOLD

		.049 .029	[1.24 0.74]	.544 .524	[13.82 13.31]	2.188 2.168	[55.58 55.07]	.236 .224	[5.99 5.69]	.436 .416	[11.07 10.57]	.620 .590	[15.75 14.99]	.446 .436	[11.33 11.07]	2.411 2.401	[61.24 60.99]	2.084 2.074	[52.93 52.68]	2.650 2.620	[67.31 66.55]	MS18277-1	50	5	M24308/24-5F	1218124-5	1-1218124-0	5		
		.049 .029	[1.24 0.74]	.432 .412	[10.97 10.46]	1.635 1.615	[41.53 41.02]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	2.103 2.073	[53.42 52.65]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	2.103 2.073	[53.42 52.65]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	MS18276-1	37	4	M24308/24-4F	1218124-4	1218124-9	5
		.040 .020	[1.02 0.51]	.432 .412	[10.97 10.46]	1.635 1.615	[41.53 41.02]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	2.103 2.073	[53.42 52.65]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	2.103 2.073	[53.42 52.65]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	MS18275-1	25	3	M24308/24-3F	1218124-3	1218124-8	5
		.040 .020	[1.02 0.51]	.432 .412	[10.97 10.46]	1.635 1.615	[41.53 41.02]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	2.103 2.073	[53.42 52.65]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	2.103 2.073	[53.42 52.65]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	MS18274-1	15	2	M24308/24-2F	1218124-2	1218124-7	5
		.040 .020	[1.02 0.51]	.432 .412	[10.97 10.46]	1.635 1.615	[41.53 41.02]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	2.103 2.073	[53.42 52.65]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	2.103 2.073	[53.42 52.65]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	MS18273-1	9	1	M24308/24-1F	1218124-1	1218124-6	5
		.049 .029	[1.24 0.74]	.544 .524	[13.82 13.31]	2.188 2.168	[55.58 55.07]	.236 .224	[5.99 5.69]	.436 .416	[11.07 10.57]	.620 .590	[15.75 14.99]	.446 .436	[11.33 11.07]	2.411 2.401	[61.24 60.99]	2.084 2.074	[52.93 52.68]	2.650 2.620	[67.31 66.55]	MS18277-1	50	5	M24308/24-5F	1218124-5	1218124-5			
		.049 .029	[1.24 0.74]	.432 .412	[10.97 10.46]	1.635 1.615	[41.53 41.02]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	2.103 2.073	[53.42 52.65]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	2.103 2.073	[53.42 52.65]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	MS18276-1	37	4	M24308/24-4F	1218124-4	1218124-4	
		.040 .020	[1.02 0.51]	.432 .412	[10.97 10.46]	1.635 1.615	[41.53 41.02]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	2.103 2.073	[53.42 52.65]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	2.103 2.073	[53.42 52.65]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	MS18275-1	25	3	M24308/24-3F	1218124-3	1218124-3	
		.040 .020	[1.02 0.51]	.432 .412	[10.97 10.46]	1.635 1.615	[41.53 41.02]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	2.103 2.073	[53.42 52.65]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	2.103 2.073	[53.42 52.65]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	MS18274-1	15	2	M24308/24-2F	1218124-2	1218124-2	
		.040 .020	[1.02 0.51]	.432 .412	[10.97 10.46]	1.635 1.615	[41.53 41.02]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	2.103 2.073	[53.42 52.65]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	2.103 2.073	[53.42 52.65]	1.857 1.847	[47.17 46.91]	1.539 1.529	[39.09 38.84]	MS18273-1	9	1	M24308/24-1F	1218124-1	1218124-1	
N	M	L		J		H		G		F		E		D		C		B		A		INSERT ARRANGEMENT	NO OF POS	SHELL SIZE	MILITARY P/N ON CONNECTOR	P/N ON CONNECTOR	PART NUMBER			

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DIMENSIONS:
INCHES

0 PLC
1 PLC
2 PLC
3 PLC
4 PLC

± -
± -
± -
± -
± -

ANGLES

± -

TOLERANCES UNLESS
OTHERWISE SPECIFIED:

0 PLC
1 PLC
2 PLC
3 PLC
4 PLC

± -
± -
± -
± -
± -

MATERIAL
SEE CALLOUTS

FINISH
SEE CALLOUTS

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DWN
P. YEAGER
30DEC97

CHK
G. OVER
30DEC97

APVD
H. WYNKOOP
30DEC97

NAME

AMPLITE PLUG ASSY, LOW PROFILE
SIZE 20 POSTED, .030 DIA SHORT POST
SERIES 109, SHELL SIZES 1 THRU 5

SIZE
A1

CAGE CODE
00779

DRAWING NO
1218124

RESTRICTED TO
-

CUSTOMER DRAWING

SCALE
4:1

SHEET
1 OF 2

REV
E1

4805 (3/11)

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