

NOTES:		81-203-4050		REVISIONS					
1. MATERIALS & FINISHES:		DRAWING NO.		REV	DESCRIPTION		DATE	ECO	APPR
BODY = BRASS (ASTM-B-16 H02, C36000), NICKEL PLATED(.000100/.000250) THICK. AN UNDERLAY OF .000020 COPPER IS OPTIONAL TO ASSIST ADHESION REQUIREMENTS.		THIRD ANGLE PROJ.		A	RELEASE TO MFG.		5/22/02	44065	CPM
SLEEVE (2) = PBT 15%, INJECTION GRADE, COLOR WHITE				B	CLARIFIED SLEEVE MATERIAL; ADD PLATE TO SPLIT WASHERS		6/14/02	44079	CPM
MALE CONTACT = BRASS (ASTM-B-16 H02, C36000), TIN PLATE (.000100/.000300) THICK PER MIL-T-10727.				C	ADDED CABLE STRIPPING DIMENSIONS SPLIT WASHERS WERE NICKEL PLATED BECU		8/12/02	44149	MAH
COMPRESSION SPRING = MUSIC WIRE, HIGH CARBON STEEL ALLOY PER ASTM A228.				D	A) ITEM 6 WAS: 81-8113-TE B) ADDED NOTE 8 & Ø.356 ±.002		3/13/03	44397	BCG
FERRULE = SEAMLESS COPPER TUBING, ALLOY 122 (DHP), ASTM-B75 HARD. DRAWN TO ROCKWELL 58-77 ON 30T SCALE, NICKEL PLATED (.000100/.000250) THICK. AN UNDERLAY OF .000020 COPPER IS OPTIONAL TO ASSIST ADHESION REQUIREMENTS.									
INSULATOR = TPX RT18, POLYMETHYPENTENE COPOLYMER, COLOR: NATURAL.									
SPLIT WASHERS (2) = BLUE TEMPER SPRING STEEL, 1075									
2. PACKAGING:									
A. BULK PACKAGE CONNECTOR 100 PER BAG.									
B. MARK BAG OR TAG "81-203-4050 YYWW".									
3. INSULATOR (ITEM 1) IS A SLIP FIT INTO BODY (ITEM 2). STAKE BODY AS SHOWN TO RETAIN INSULATOR.									
4. CONTACT, ITEM 7, TO BE SUPPLIED UNASSEMBLED.									
5. INSULATOR MUST WITHSTAND A 6 LB. MIN. PUSHOUT FORCE FROM CABLE END OF CONNECTOR.									
6. CRIMP USING AMPHENOL TOOL 227-944 (M22520/5-01) AND DIE SET 227-1221-11, CAVITY "A" (.213 HEX.) AND CAVITY "B" (.068 HEX.)									
7. SLEEVE, ITEM 5, MUST WITHSTAND A 75LB. MIN. PULL.									
8. AFTER ASSEMBLY, THE BODY TINES (ITEM 6) MUST MEET THE DIMENSIONS SHOWN.									

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