




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DOCUMENT: 0-80633

DOCUMENT REVIEW (PRELIMINARY UNTIL COMPLETED)		 PACIFIC AEROSPACE & ELECTRONICS, INC. 434 Olds Station Rd. Wenatchee, Washington 98801		GENERAL TOLERANCES, UNLESS NOTED DIMENSIONS AND TOLERANCES IAW ASME Y14.5M-1994 DIMENSIONS APPLY AFTER PROCESSES DIMENSIONS IAW U.S. CUSTOMARY UNITS DIMENSIONAL TOLERANCES: .X±0.1 .XX±0.01 .XXX±0.005 ≤ ±0.5 .010 MAX OUTSIDE CORNER RADIUS OR CHAMFER .005 MAX INSIDE CORNER RADIUS SURFACE FINISH ON MACHINED SURFACES PARENTHETICAL INFORMATION FOR REFERENCE ONLY		COMPUTER GENERATED CAD MAINTAINED ALL SHEETS SAME REV LEVEL	
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ENGINEERING:	DATE:	N. FOSTER 01-05-06 (SEE ELECTRONIC APPROVAL SUMMARY)					
MANUFACTURING:	DATE:	CONNECTOR, MATE, JR-D					
QUALITY ASSURANCE:	DATE:	THE INFORMATION HEREIN CONTAINS PROPRIETARY RIGHTS OF PACIFIC AEROSPACE & ELECTRONICS AND SHALL NOT BE USED, REPRODUCED, OR DISCLOSED TO THIRD PARTIES FOR ANY PURPOSE EXCEPT AS SPECIFICALLY AUTHORIZED IN WRITING BY PACIFIC AEROSPACE & ELECTRONICS					
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CONFIGURATION:	DATE:	SHEET:	1 OF 6				
						 	CAGE CODE: 64567 DOCUMENT: 0-80633

1. SCOPE

1.1 Scope. This drawing establishes the requirements for a non-hermetic male connector intended to be used with Pacific Aerospace and Electronics (PA&E) hermetic female JR-D connectors.

1.2 PA&E Interconnect Division control number. The PA&E Interconnect Division control number consists of this drawing number and a dash number assigned as follows:

PA&E Interconnect Division Generic Number

0-80633-X Connector, Mate, Jr-D

See Table 1, Figure 1, and Suggested Source(s) of Supply for dash numbers (-X).

2. APPLICABLE DOCUMENTS

2.1 Government documents. The following documents of the issue in effect on the date of invitation forbids or request for proposal form a part of this drawing to the extent specified herein.

SPECIFICATIONS

FEDERAL

QQ-N-290 Nickel Plating, Electrodeposited

MILITARY

MIL-M-24519 Molding PLastics, Electrical, Thermoplastic

MIL-PRF-83513 Connectors, Electrical, Rectangular,

MIL-STD-681 Identification Coding and Application of Hookup and Lead Wire

2.2 Other publications.

SPECIFICATIONS

AMERICAN SOCIETY FOR TESTING AND MATERIALS

ASTM B-196 Copper-Beryllium Alloy Rod and Bar

ASTM B-197 Copper-Beryllium Alloy Wire

ASTM A-582 Free Machining Stainless Steel Bars

ASTM B-488 Electrodeposited Coatings of Gold for Engineering Uses

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2.3 Order of precedence. In the event of a conflict between this drawing and the references cited herein, this drawing takes precedence.

3. REQUIREMENTS

3.1 Design, construction, and physical requirements. The design, construction, and physical requirements shall be in accordance with the manufacturer's applicable documents and procedures to the extent specified herein.

3.1.1 Materials and finishes. Materials and finishes shall be as specified herein.

3.1.1.1 Shell. The shell material shall be 303 stainless steel IAW ASTM A-582.

3.1.1.2 Jacking hardware. The jacking hardware material shall be 303 or 18-8 stainless steel IAW ASTM A-582.

3.1.1.3 Contacts. The contact material shall be Beryllium-Copper IAW ASTM B196 or B197. The contact plating shall be Nickel plate IAW QQ-N-290, Class I, 100 to 250 microinches thick and Gold plate IAW MIL-G-45204, Type II, Grade A, 50 to 150 microinches thick.

3.1.1.4 Potting. The potting shall be thermoset resin (Hysol) IAW MIL-PRF-83513.

3.1.1.5 Contact block. The contact block shall be PPS plastic IAW MIL-M-24519, TYPE GST-40F.

3.1.1.6 Wires. The wires shall be insulated, stranded wire IAW MIL-STD-681 SYS I, color coded IAW MIL-STD-681.

3.1.1.7 All solder connections shall be made using Sn 96 solder IAW ANSI/J-STD-006.

3.1.2 Physical dimensions and outline. The physical dimensions and outline of each dash part number shall be as specified in Figure 1 and Table 1 herein.

3.1.3 Requirements. Requirements shall be as specified herein.

3.1.3.1 Mating. Individual contacts shall mate into a tube of diameter .017+/- .0003 with a maximum force of 3grams. Individual contacts shall extract from a tube of diameter .017+/- .0003 with a minimum force of 1gram. Mating shall apply over a temperature range of -65°C to +150°C.

3.1.3.2 Operating temperature. The operating temperature range shall be -55°C to +125°C.

3.1.3.3 Storage temperature. The storage temperature range shall be -55°C to +165°C.

3.2 Marking. Device marking shall be in accordance with the manufacturer's standard practice.

3.3 Certificate of conformance. The manufacturer shall provide a certificate of conformance with each shipment of items delivered to this drawing. The certificate shall state that the delivered items meet all of the requirements specified herein.

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3.4 Change of qualified product. The manufacturer shall notify in writing the procuring activity upon implementing any change(s) which could affect the device's form, fit, function, performance, quality or reliability. Failure to do so may result in rejection of delivered products or disapproval of the manufacturer as a source of supply for devices specified herein.

4. QUALITY ASSURANCE PROVISIONS

- 4.1 General. The quality assurance provisions for this item shall be in accordance with the manufacturer's standard assurance plan.
- 4.2 Qualification. Qualification shall be conducted at the discretion of the procuring activity when required. Qualification by the manufacturer is not required by this drawing.

5. PREPARATION FOR DELIVERY

- 5.1 Packaging requirements. The requirements for packaging shall be in accordance with the manufacturer's standard practice.
- 5.2 Marking for shipment. Each unit package, intermediate and exterior container shall be marked in accordance with the manufacturer's standard procedure. As a minimum, marking shall include the following information:
 - a. Manufacturer's name, trademark or CAGE code.
 - b. Manufacturer's part number
 - c. Date code
 - d. Purchase order number
 - e. PA&E Interconnect Division control number, enclosed in parentheses

7. Suggested Source(s) of Supply

Vendor CAGE Code	Vendor Name and Address
54455	Min-E-Com 3160 Pullman Costa Mesa, Ca 92626 (714) 434-7312

7.1 Vendor part identification table

PA&E Interconnect Division Control Number	Vendor Part Number	CAGE Code
80633		
-1	SK991022-09	54455
-2	SK991022-15	54455
-3	SK991022-21	54455
-4	SK991022-25	54455
-5	SK991022-31	54455
-6	SK991022-37	54455

7.2 Identification of the Suggested Source(s) of Supply hereon is not to be construed as a guarantee of present or continued availability as a source of supply for the item(s).

7.3 Procurement by Pacific Aerospace and Electronics Interconnect Division is limited to the items listed herein.

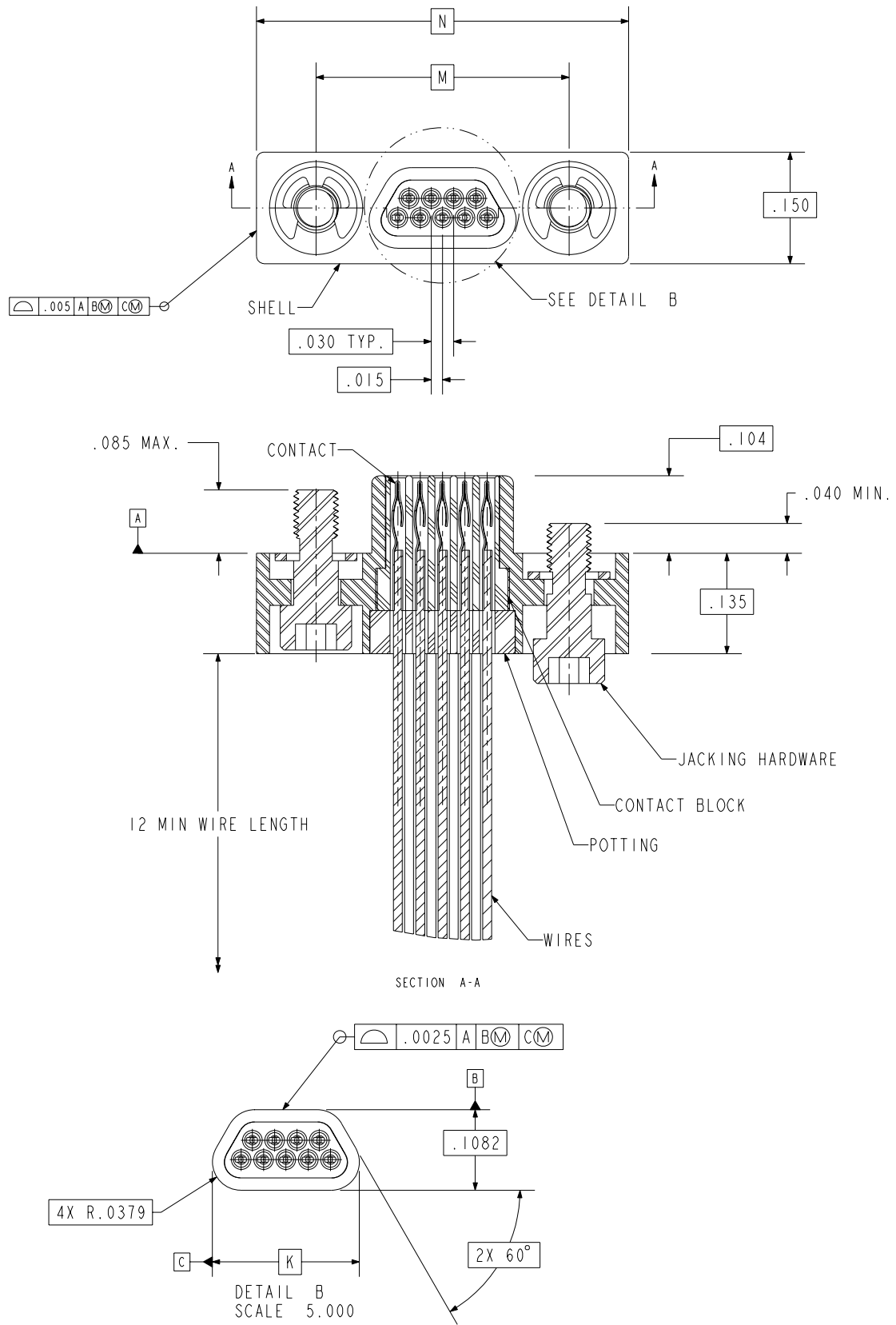
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FIGURE 1. Physical outline.



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TABLE I. Physical dimensions. 1/

PART NUMBER	PIN COUNT	K	M	N
80633_SHELL-9	9	.1976	.340	.5000
80633_SHELL-15	15	.2876	.430	.5900
80633_SHELL-21	21	.3776	.520	.6800
80633_SHELL-25	25	.4376	.580	.7400
80633_SHELL-31	31	.5276	.670	.8300
80633_SHELL-37	37	.6176	.760	.9200

1/ Unless otherwise specified, dimensions are in inches and applied after plating.

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