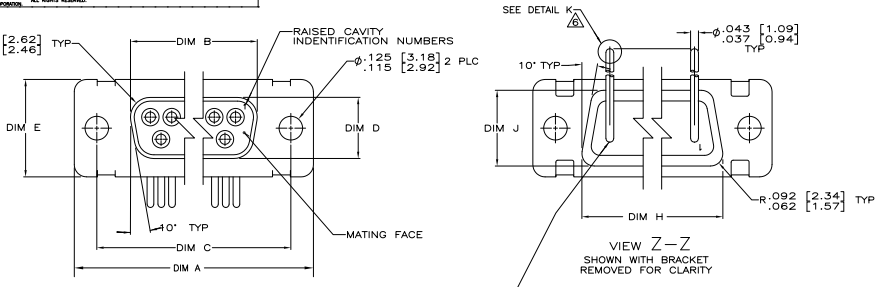


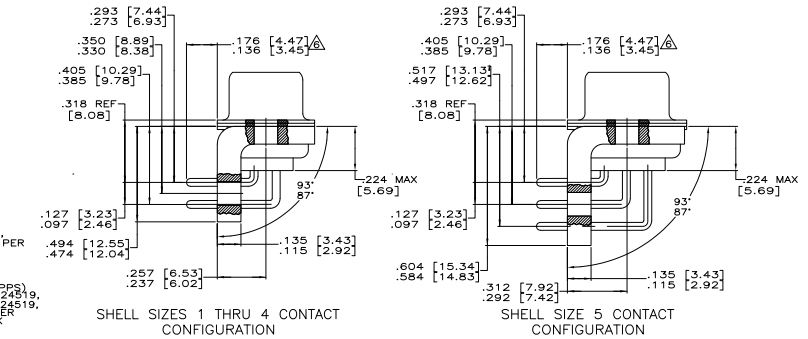
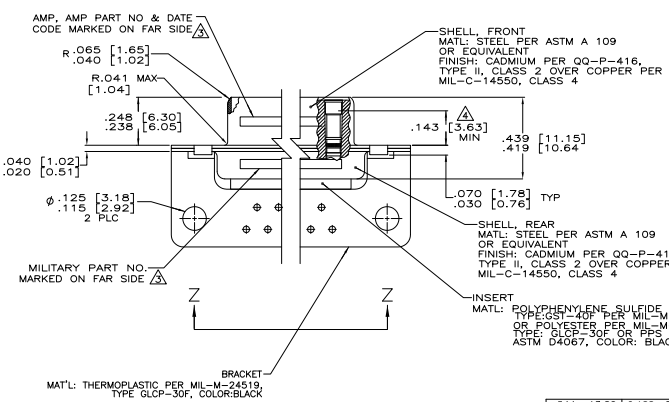
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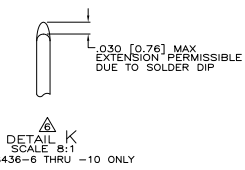
REV	DATE	DESCRIPTION	BY	CHK	APP
1					
2					
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- SEE SHEET 2 FOR RECOMMENDED P.C. BOARD LAYOUT. TRUE POSITION TOLERANCE FOR P.C. BOARD LAYOUT IS .010 [0.25] AT MAX MATERIAL CONDITION. SUGGESTED BOARD THICKNESS IS .125 [3.18]
- THE CONNECTORS DESCRIBED IN THIS DOCUMENT MEET THE REQUIREMENTS OF MIL-C-24308 AND MATE WITH ANY PLUG CONNECTOR WITH SAME INSERT ARRANGEMENT.
- MARKED WITH .047 [1.19]-.062 [1.57] HIGH CHARACTERS. FAR SIDE REFERS TO THE WIDE SIDE OF THE KEYSTONE. NEAR SIDE REFERS TO THE NARROW SIDE OF THE KEYSTONE. IF THE REAR SHELL IS TOO SMALL FOR THE ENTIRE MILITARY PART NUMBER, MARKING SHALL BE LOCATED AS FOLLOWS:
 - A. "M24308" ON FRONT SHELL, FAR SIDE.
 - B. SLASH SHEET AND DASH NUMBER ON REAR SHELL, FAR SIDE.
 - C. "AMP" AND DATE CODE ON FRONT SHELL, NEAR SIDE.
 - D. AMP PART NUMBER ON REAR SHELL, NEAR SIDE.
- IF THE FRONT SHELL IS TOO SMALL FOR "AMP", AMP PART NUMBER AND DATE CODE, MARKING SHALL BE SPLIT AS FOLLOWS:
 - A. AMP PART NUMBER ON REAR SHELL, NEAR SIDE.
 - B. "AMP" AND DATE CODE ON FRONT SHELL, NEAR SIDE.
 - C. MILITARY PART NUMBER ON REAR SHELL, FAR SIDE.
- POINT OF ELECTRICAL ENGAGEMENT - AS MEASURED WITH A .0390 [0.991]-.0393 [0.998] DIA SQUARE ENDED TEST PIN.
- THIS DRAWING SHALL BE INTERPRETED IN ACCORDANCE WITH APPLICABLE STANDARDS LISTED IN MIL-STD-100.
- SOLDER DIP PER MIL-STD-2000 COMPOSITION Sn63 CONFORMING TO QQ-S-571 IN THE ENTIRE AREA OF DIMENSION SHOWN. 1218436-6 THRU -10 ONLY.

CONTACT (QTY = NO. OF POSN)
 MATL: BRASS PER ASTM-B-16, OR BERYLLIUM COPPER PER ASTM-B-194
 FINISH: GOLD PER MIL-G-45204, TYPE II, GRADE C, CLASS 1 IN CONTACT MATING AREA, .000010 [0.0003] MIN THK GOLD PER MIL-G-45204 OVER .000050 [0.0013] MIN THK NICKEL PER QQ-N-290 ON CONTACT BODY



DIM J	DIM H	DIM E	DIM D	DIM C	DIM B	DIM A	INSERT ARRANGEMENT	NO OF POS	SHELL SIZE	MILITARY P/N ON CONNECTOR	AMP P/N MARKED ON CONNECTOR	AMP PART NO.
.544 [13.82]	2.188 [55.58]	.620 [15.75]	.428 [10.87]	2.411 [61.24]	2.069 [52.55]	2.650 [67.31]	MS18277-1	50	5	M24308/23-47F	1218436-5	1-1218436-0
.524 [13.31]	2.168 [55.07]	.590 [14.99]	.418 [10.69]	2.401 [60.98]	2.059 [52.30]	2.620 [66.55]	MS18276-1	37	4	M24308/23-46F	1218436-4	1218436-9
.432 [10.97]	2.282 [57.96]	.509 [12.93]	.316 [8.03]	2.505 [63.63]	2.164 [54.97]	2.744 [69.70]	MS18275-1	25	3	M24308/23-45F	1218436-3	1218436-8
.432 [10.97]	1.635 [41.53]	.509 [12.93]	.316 [8.03]	1.857 [47.17]	1.516 [38.51]	2.103 [53.42]	MS18274-1	15	2	M24308/23-44F	1218436-2	1218436-7
.412 [10.46]	1.815 [45.92]	.479 [12.17]	.306 [7.77]	1.847 [46.91]	1.506 [38.25]	2.073 [52.65]	MS18273-1	9	1	M24308/23-43F	1218436-1	1218436-6
.432 [10.97]	1.083 [27.76]	.509 [12.93]	.316 [8.03]	1.317 [33.45]	.976 [24.79]	1.556 [39.52]	MS18276-1	37	4	M24308/23-46F	1218436-4	1218436-9
.412 [10.46]	1.073 [27.25]	.479 [12.17]	.306 [7.77]	1.307 [33.20]	.966 [24.54]	1.526 [38.76]	MS18275-1	25	3	M24308/23-45F	1218436-3	1218436-8
.432 [10.97]	1.635 [41.53]	.509 [12.93]	.316 [8.03]	1.857 [47.17]	1.516 [38.51]	2.103 [53.42]	MS18274-1	15	2	M24308/23-44F	1218436-2	1218436-7
.412 [10.46]	1.815 [45.92]	.479 [12.17]	.306 [7.77]	1.847 [46.91]	1.506 [38.25]	2.073 [52.65]	MS18273-1	9	1	M24308/23-43F	1218436-1	1218436-6
.432 [10.97]	1.083 [27.76]	.509 [12.93]	.316 [8.03]	1.317 [33.45]	.976 [24.79]	1.556 [39.52]	MS18276-1	37	4	M24308/23-46F	1218436-4	1218436-9
.412 [10.46]	1.073 [27.25]	.479 [12.17]	.306 [7.77]	1.307 [33.20]	.966 [24.54]	1.526 [38.76]	MS18275-1	25	3	M24308/23-45F	1218436-3	1218436-8
.432 [10.97]	1.635 [41.53]	.509 [12.93]	.316 [8.03]	1.857 [47.17]	1.516 [38.51]	2.103 [53.42]	MS18274-1	15	2	M24308/23-44F	1218436-2	1218436-7
.412 [10.46]	1.815 [45.92]	.479 [12.17]	.306 [7.77]	1.847 [46.91]	1.506 [38.25]	2.073 [52.65]	MS18273-1	9	1	M24308/23-43F	1218436-1	1218436-6



DETAIL K
 SCALE: 8:1
 FOR 1218436-6 THRU -10 ONLY

THIS DRAWING IS A CONTROLLED DOCUMENT.

REVISIONS: 12-18-88

DATE: 12-18-88

BY: [Signature]

CHKD: [Signature]

APP: [Signature]

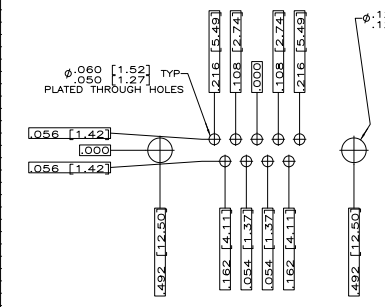
RECEPTACLE ASSY, AMP/LITE RIGHT ANGLE, SERIES 109 SIZES 1 THRU 5

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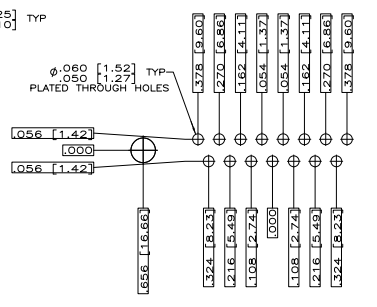
CUSTOMER DRAWING: 1218436

REV: 4.1 SHEET: 1 OF 2

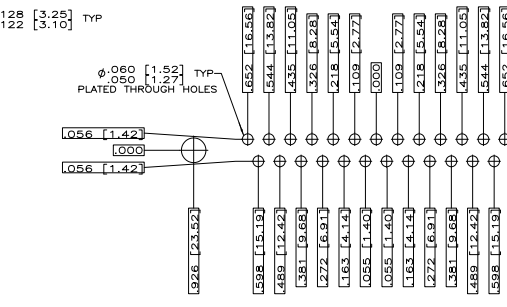
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DF	DO	SEE SHEET 1	-	-



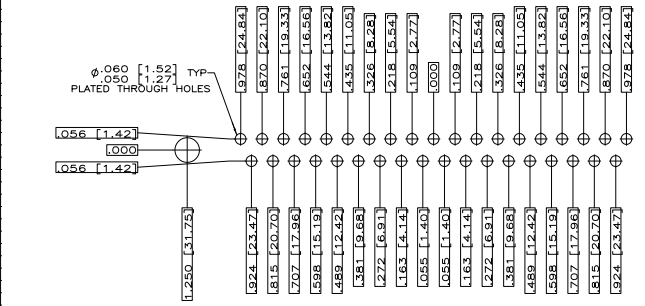
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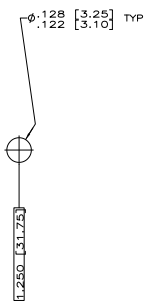
RECOMMENDED P.C. BOARD LAYOUT SHELL SIZE 2 (15 POSITION)



RECOMMENDED P.C. BOARD LAYOUT SHELL SIZE 3 (25 POSITION)



RECOMMENDED P.C. BOARD LAYOUT SHELL SIZE 4 (37 POSITION)



RECOMMENDED P.C. BOARD LAYOUT SHELL SIZE 5 (50 POSITION) Δ

THIS DRAWING IS A CONTROLLED DOCUMENT.		DATE: 12-13-88		DRAWN BY: J. THOMAS	
DESIGNED BY: J. THOMAS	DATE: 12-13-88	CHECKED BY: J. THOMAS	DATE: 12-13-88	TYPED BY: J. THOMAS	
APPROVED BY: J. THOMAS	DATE: 12-13-88	DATE: 12-13-88	DATE: 12-13-88	TWO ELECTRONICS CORPORATION HARRISBURG, PA 17105-3608	
CUSTOMER DRAWING		PART NO: 1218436		REV: 4.1	