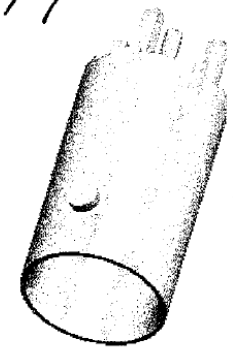
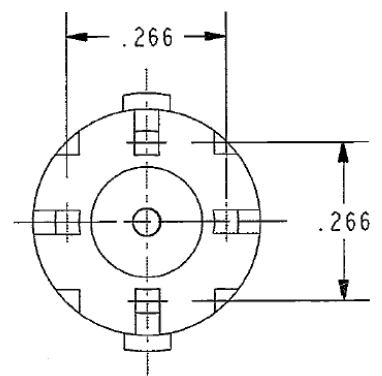
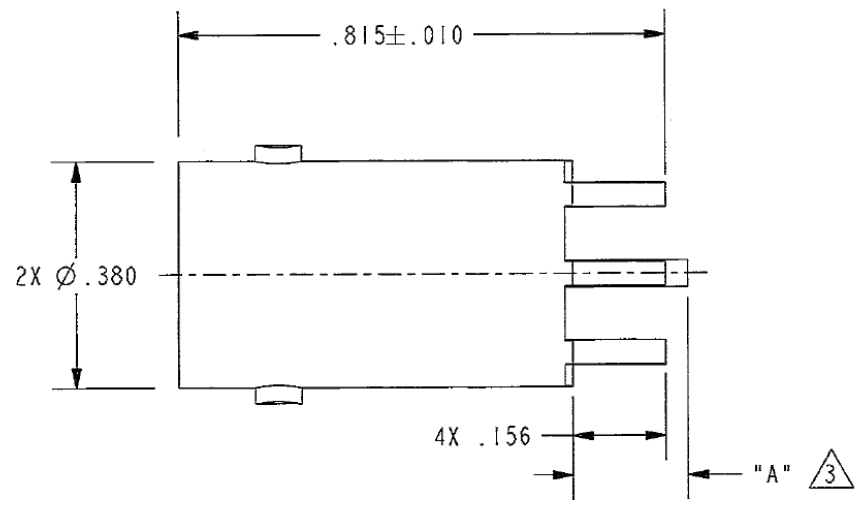


PART NO	"A" DIMENSION	CENTER CONTACT PLATING: TFS-1B
UCBJ224	.193±.015	5G; .000050 GOLD
UCBJ224-1	.156±.015	3G; .000030 GOLD

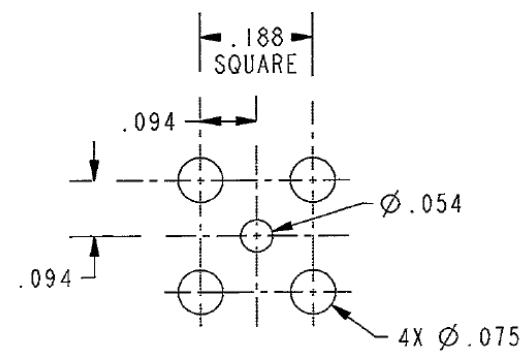
REVISIONS			
REV	DESCRIPTIONS	DATE	APPROVED
K	REVISED PER ECO # 16518	1/15/08	<i>[Signature]</i>



SCALE 2/1



SCALE 3/1



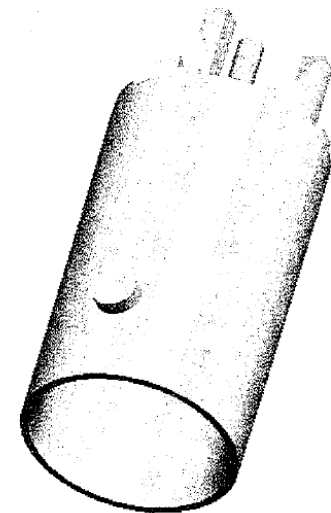
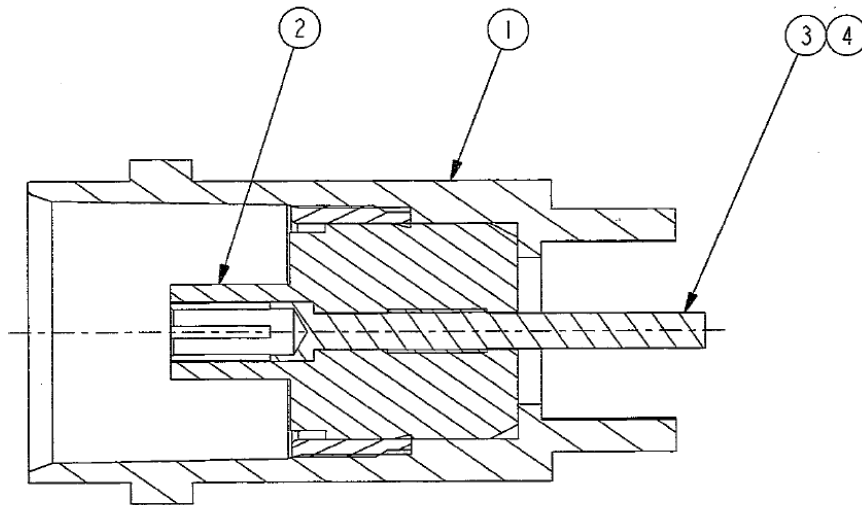
RECOMMENDED MTG HOLE PATTERN SCALE 3/1

△ CENTER CONTACT ONLY

- FINISH:
UCBJ224: TFS-1Y (NICKEL) WITH PRE-TINNED LEGS
UCBJ224-1: TFS-1B (GOLD) WITH NO PRE-TINNED LEGS
- 75 Ω CIRCUIT BOARD MOUNT, ZINC DIECAST OR BRASS, BNC RECEPTACLE

NOTES: UNLESS OTHERWISE SPECIFIED.

INTERPRET DRAWING PER MIL-STD-100. DIMENSIONS ARE IN INCHES AND INCLUDE FINISH THICKNESS UNLESS OTHERWISE SPECIFIED.		TOL: UNLESS SPECIFIED. .XX ± .02 .XXX ± .010 ANGLE ± 1°		<h1>HO CHIEN</h1> www.hochien.com	
DRN J. CARPENTER	11-20-07	MATERIAL:	FINISH:		
CHK M.S.	1-10-08	QUALITY		SIZE A	CAGE CODE 14949
HAND		APPROVED <i>[Signature]</i>	1/10/08	DRAWING NO. 1-0532	REV. K
NEXT ASSY	PROJ FILE NO. 1-0532	DO NOT SCALE DWG	SCALE 3/1	DATE 3-21-95	SHEET 1C

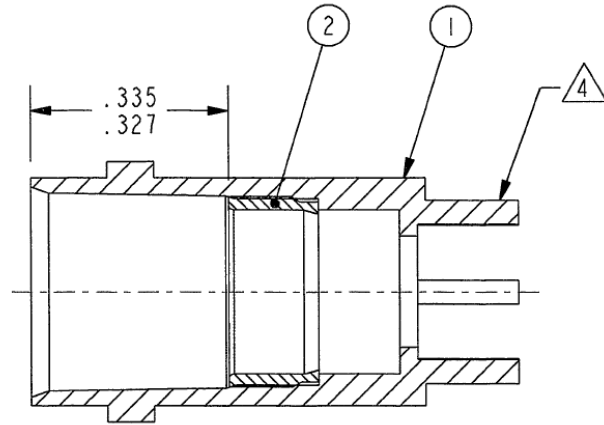


1		CONTACT	805-1959-1	4
	1	CONTACT	805-1959	3
1	1	DIELECTRIC	805-1958	2
1	1	BODY ASSEMBLY	8-3767	1
-1	BASIC	DESCRIPTION	PART NUMBER	ITEM

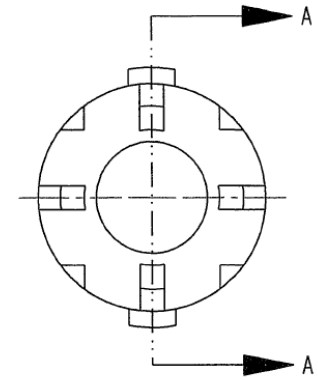
SIZE	CAGE CODE	DRAWING NO.	REV.
A	14949	1-0532	K
SCALE	3/1	SHEET	2 OF 2

PART NO	PLATING
8-3767	△3
8-3767-1	△5
8-3767-2	△6

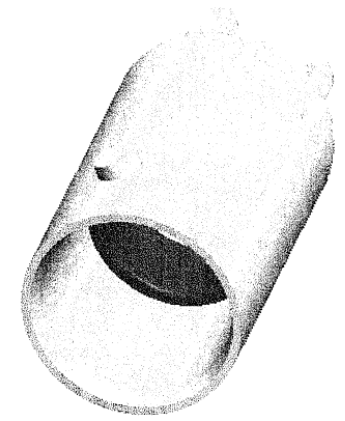
REVISIONS			
REV	DESCRIPTIONS	DATE	APPROVED
A	REVISED PER ECO # 16555		



SECTION A-A



SCALE 3/1



SCALE 3/1

△6 TFS-1Z (.000005 GOLD)
(TOTAL BUILD-UP .000152 - .000235 PER SURFACE) △4 IS NOT REQUIRED

△5 TFS-1B (1G; .000010 GOLD)
(TOTAL BUILD-UP .000132 - .000355 PER SURFACE) △4 IS NOT REQUIRED

△4 PRE-TIN LEGS .0015 MAX THICK WITH SN63 OR EQUIVALENT
SOLDER PER QQ-S-571 TO WITHIN .060 MAXIMUM OF SHOULDER
AFTER PLATING

△3 PLATE PER TFS-1Y (TOTAL BUILD-UP .000300 - .000800 PER SURFACE)

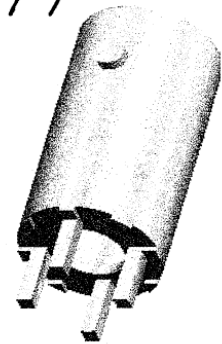
- 2. TFS-4
- 1. PRESS ITEM 2 INTO ITEM 1 PRIOR TO PLATING

NOTES: UNLESS OTHERWISE SPECIFIED.

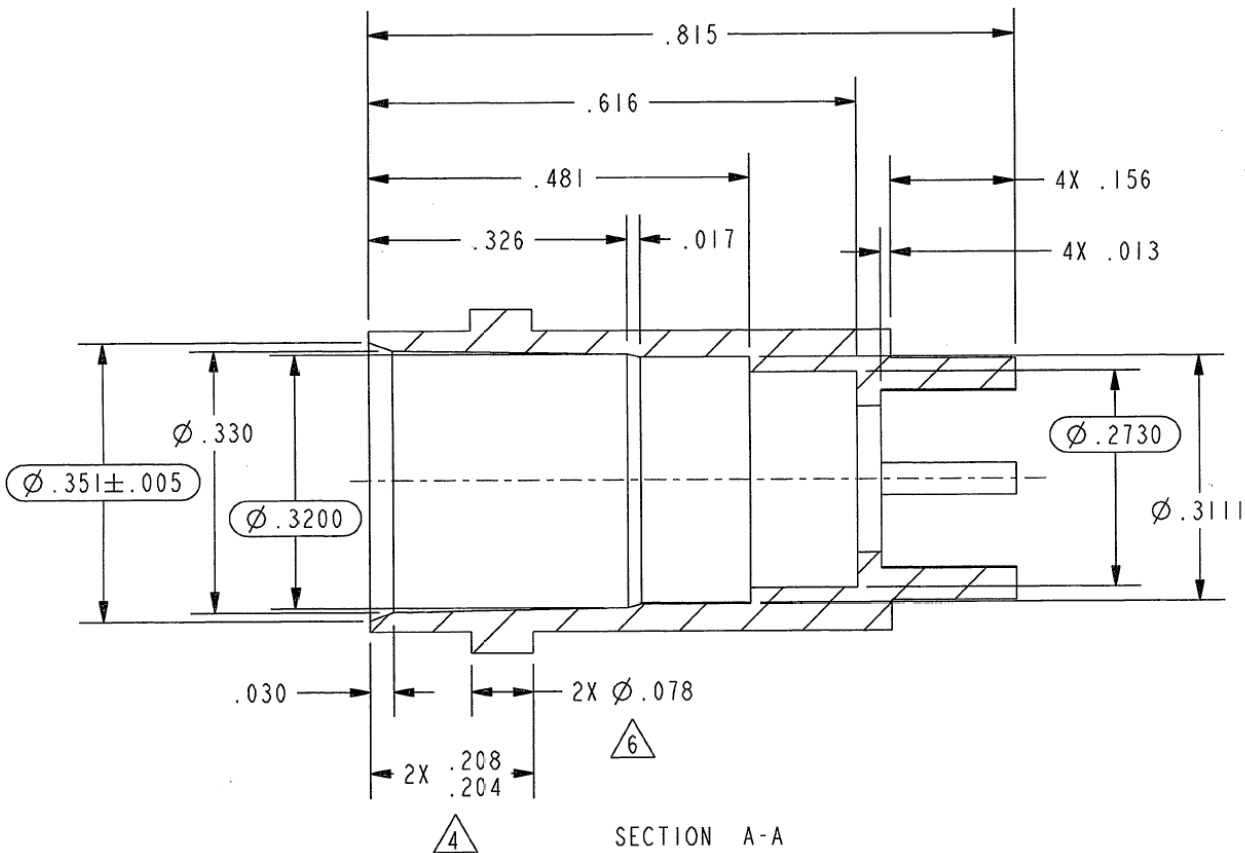
1	SLEEVE	8-3736	2
1	BODY	8-3372	1
QTY	DESCRIPTION	PART NUMBER	ITEM

INTERPRET DRAWING PER MIL-STD-100. DIMENSIONS ARE IN INCHES AND INCLUDE FINISH THICKNESS UNLESS OTHERWISE SPECIFIED.		TOL: UNLESS SPECIFIED. .XX ± .01 .XXX ± .003 .XXXX ± .0010 ANGLE ± 1° 00' CRITICAL		HO CHIEN www.hochien.com	
DRN J. CARPENTER 01-23-08	MATERIAL:	BODY ASSEMBLY			
CHR M.J 2-13-08 QUALITY	FINISH:				
MANUF 105-2089	APPROVED M 2/13/08	SIZE A	CAGE CODE 14949	DRAWING NO. 8-3767	REV. A
NEXT ASSY	PROZE FILE NO. 8-3767	DO NOT SCALE DWG	SCALE 3/1	DATE 1-10-08	SHEET 1 OF 1

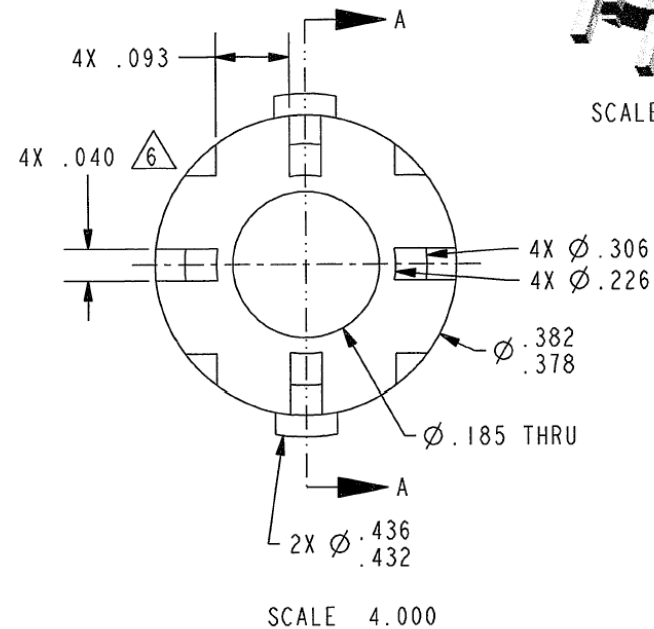
REVISIONS			
REV	DESCRIPTIONS	DATE	APPROVED
C	REVISED PER ECO # 16517	1/15/08	<i>MJC</i>



SCALE 2/1



SECTION A-A



SCALE 4.000

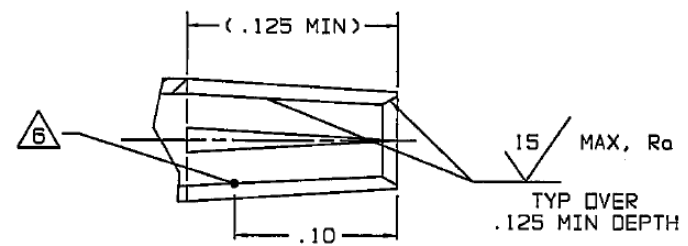
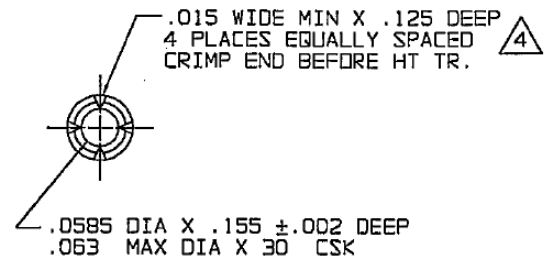
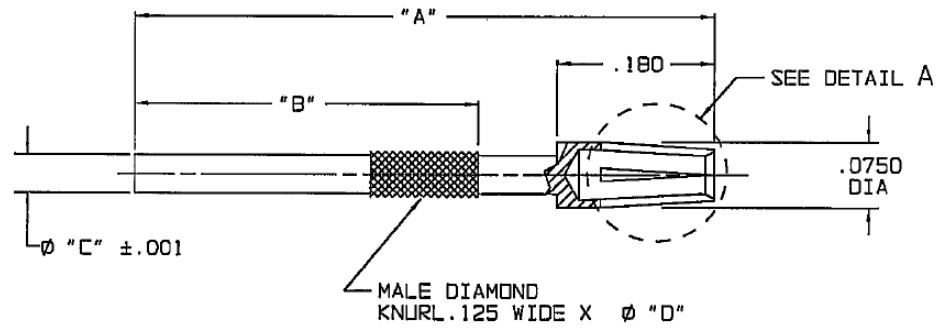
- △6 LUGS TO BE ORIENTED TO LEGS AS SHOWN TO WITHIN $\pm 2 \frac{1}{2}^\circ$
- 5. ALL CORNERS AND FILLETS UP TO R.010 MAXIMUM
- △4 .005 FLAT PERMISSIBLE TO MEET .204-.208 DIMENSION
- 3. PLATE AT NEXT ASSEMBLY
- 2. TFS-4
- △1 INGOT MATERIAL TO BE ALLOY NO.3 PER ASTM B240, CASTING TO BE PER ASTM B86

NOTES: UNLESS OTHERWISE SPECIFIED.

INTERPRET DRAWING PER MIL-STD-100. DIMENSIONS ARE IN INCHES AND INCLUDE FINISH THICKNESS UNLESS OTHERWISE SPECIFIED.		TOL: UNLESS SPECIFIED. .XX ± .01 .XXX ± .003 .XXXX ± .0010 ANGLE ± 1° 00' CRITICAL		<h1>HO CHIEN</h1> <p>www.hochien.com</p>					
DRN J. CARPENTER	11-19-07	MATERIAL:	△1			<h2>BODY</h2>			
CHK M.J.	1-10-08	FINISH:		SIZE	CAGE CODE			DRAWING NO.	REV.
MANUF				A	14949	8-3372	C		
APPROVED <i>EM</i>	1/10/08	PROTE FILE NO.	8-3372	SCALE	4/1	DATE	2-22-01	SHEET	1 OF 1
8-3767	NEXT ASSY	DO NOT SCALE DWG							

REVISIONS		805-1959	SH 1
REV	DESCRIPTION	DATE	APPROVED
E	REVISED PER ECD 15891	6/16/05	BS

P/N	"A"	"B"	"C"	"D"
BASIC	.673	.400	.0450	.055-060
-1	.636	.363	.0450	.055-060
-2	.701	.435	.0320	.044-049



DETAIL A
SCALE: 15/1

- 7 TFS-1B (3G; .000030 GOLD X TOTAL BUILD-UP .000160-.000370 PER SURFACE)
- 6 PLATING THICKNESS TO BE MEASURED AT LOCATION INDICATED
- 5 TFS-1B (5G; .000050 GOLD X TOTAL BUILD-UP .000180-.000400 PER SURFACE) THE GOLD PLATING MUST MEET THE LEVEL 1959, II REQUIREMENTS OF NORTHERN TELECOM FINISH SPECIFICATION 1967, WITH PLATING POROSITY CHECKED ON EACH LOT OF CONTACTS. GOLD THICKNESS CAN BE MEASURED BY BETASCOPE OR X-RAY FLUORESCENCE METHODS. THE REFERENCE METHOD SHALL BE THE CALIBRATED X-RAY FLUOROSCOPE. EACH SHIPMENT OF CONTACTS BUILT TO THIS SPECIFICATION SHALL INCLUDE A "CERTIFICATE OF COMPLIANCE", SHOWING THAT THE GOLD PLATING POROSITY REQUIREMENT HAS BEEN MET

4 INSERTION/WITHDRAWAL GAGING: AFTER HT TR (BEFORE PLATING) TO .125 MIN DEPTH WITH 16 MICROINCH FINISH ON ALL PINS

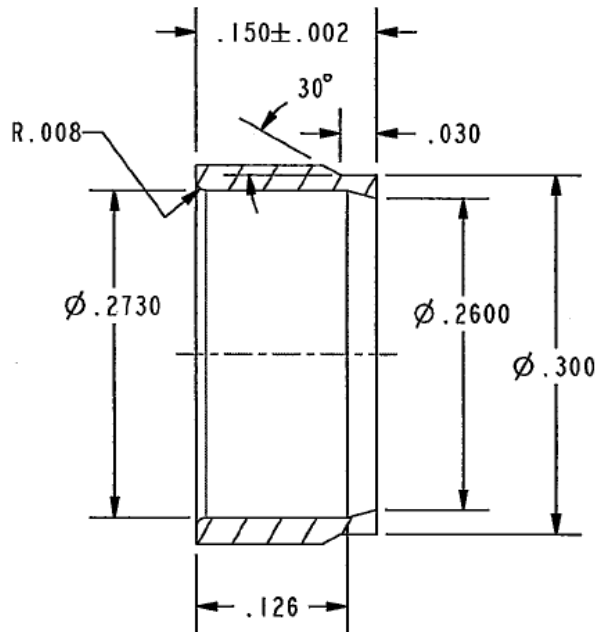
- (A) INSERTION FORCE: 2 LB MAX WITH
.0540 +.0002 DIA TEST PIN
-.0000
- (B) WITHDRAWAL FORCE: 3 OZ MIN WITH
.0520 +.0000 DIA TEST PIN
-.0002

- 3. AGE HARDEN TO Rc 36-44
- 2. TFS-4 (ALL DIMS APPLY AFTER PLATE)

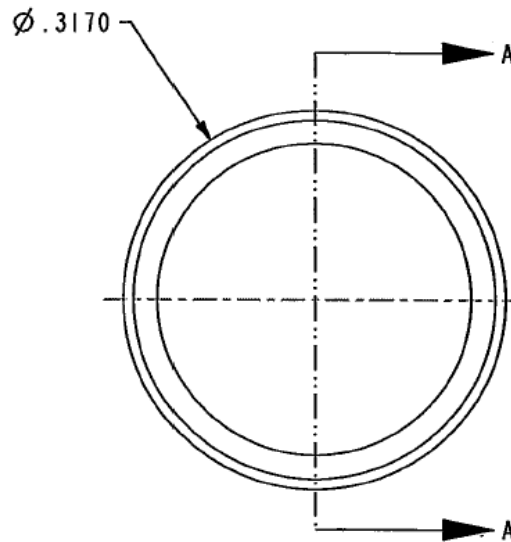
1 BeCu ALLOY C17200 OR C17300 TEMPER T004 (COND H) PER ASTM-B-196 OR TEMPER T002 (COND 1/2 H) PER ASTM-B-197 OR EQUIVALENT

INTERPRET DRAWING PER MIL-STD-100 DIMENSIONS ARE IN INCHES AND INCLUDE FINISH THICKNESS UNLESS OTHERWISE SPECIFIED		TOL: UNLESS SPECIFIED .XX ± .01 .XXX ± .003 .XXXX ± .0010 ANGLES ± 0°30'		<h1>HO CHIEN</h1> www.hochien.com		
DRAWN: AAH CHECKED: T.K.M. QUALITY: MS MANUF: JK APPROVED: BS	DATE: 6-7-05 DATE: 6/8/05 DATE: 6/8/05 DATE: 6/15/05	MATERIAL: 1	FINISH:			TITLE: SOCKET CONTACT
105-2267	105-2209	105-1478	NEXT ASSY	SIZE: A CAGE CODE: 14949	DRAWING NO.: 805-1959	REV.: E
DO NOT SCALE DWG				SCALE: 8/1	DATE: 8-13-99	SHEET: 1 OF 1

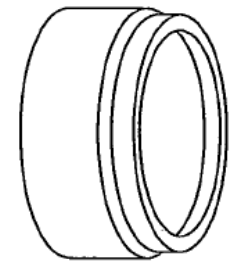
REVISIONS			
REV	DESCRIPTIONS	DATE	APPROVED
A	REVISED PER ECO # 16232	8-25-06	NWC



SECTION A-A



SCALE 6/1







SCALE 4/1

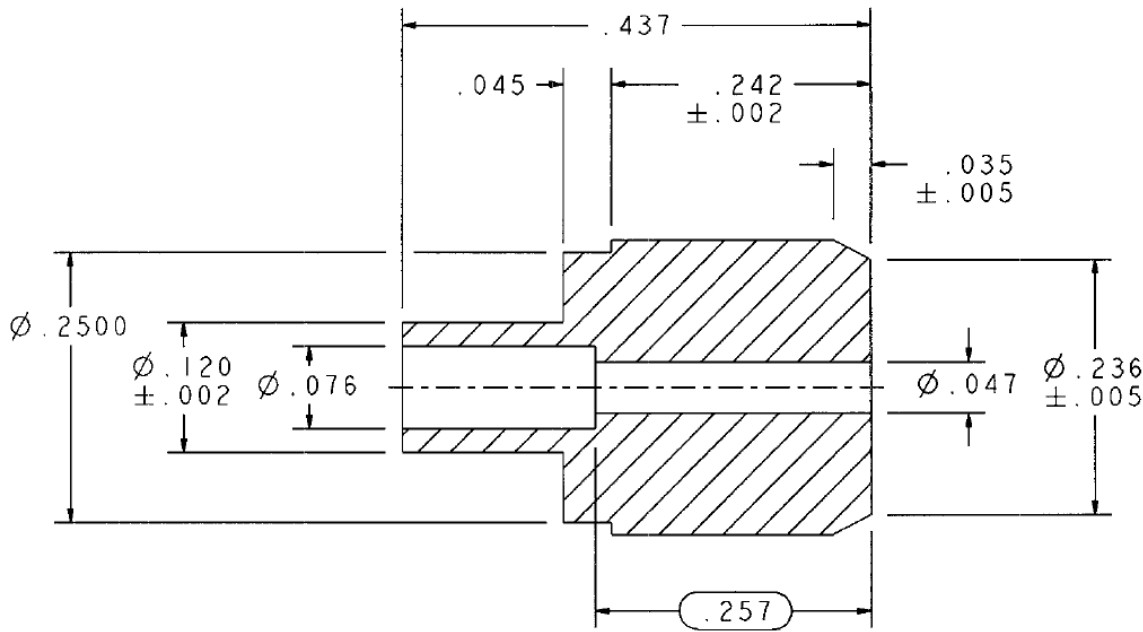
2. TFS-4

 INGOT MATERIAL TO BE ALLOY NO 3 PER ASTM B240
CASTING TO BE PER ASTM B86

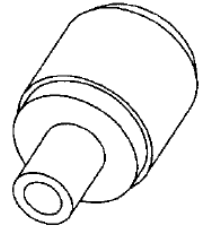
NOTES: UNLESS OTHERWISE SPECIFIED.

INTERPRET DRAWING PER MIL-STD-100. DIMENSIONS ARE IN INCHES AND INCLUDE FINISH THICKNESS UNLESS OTHERWISE SPECIFIED.		TOL: UNLESS SPECIFIED. .XX ± .01 .XXX ± .003 .XXXX ± .0010 ANGLE ± 1° 00'  CRITICAL		HO CHIEN www.hochien.com			
DRN J. CARPENTER	08-11-06	MATERIAL:		TITLE:			
CHK 	8/25/06			SLEEVE			
MANU:	APPROVED 	FINISH:		SIZE A	CAGE CODE 14949	DRAWING NO. 8-3736	REV. A
805-1403	PROVE FILE NO. 8-3736	DO NOT SCALE DWG		SCALE 4/1	DATE 8-8-06	SHEET 1 OF 1	

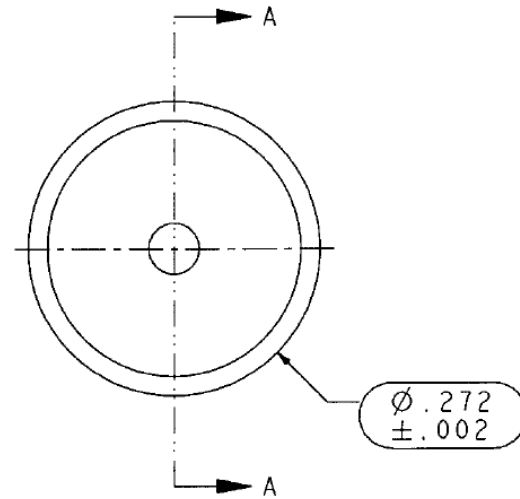
REVISIONS				805-1958	SH 1
REV	ECO NO.	DESCRIPTION	DWN	APPROVED	DATE
C	13515	Ø .272 WAS Ø .275; SEE ECO	JCM		7/11/00



SECTION A-A



SCALE 4/1



2. TFS-4

PTFE PER ASTM-D1710, TYPE II (GENERAL PURPOSE) GRADE I (VIRGIN RESIN), CLASS A (NORMAL DIMENSIONAL STABILITY)

QTY	DESCRIPTION		PART NUMBER		ITEM
TOL UNLESS SPECIFIED .XX ± .01 .XXX ± .003 .XXXX ± .0010 ANGLE ± 0° 30' CRITICAL			HO CHIEN www.hochien.com		DIELECTRIC, PTFE
DWG	JCM	7-5-00	MATERIAL	CODE IDENT	DRAWING NO.
CHK		7-11-00		14949	805-1958
805-1794	ENGR		SCALE 8/1	DATE 8-10-99	SHEET 1 OF 1
NEXT ASSY	APPR	7-11-00			