

**NOTE**

All numerical values are in metric units [with U.S. customary units in brackets]. Dimensions are in millimeters [and inches]. Unless otherwise specified, dimensions have a tolerance of ± 0.13 [$\pm .005$] and angles have a tolerance of $\pm 2^\circ$. Figures and illustrations are for identification only and are not drawn to scale.

1. PURPOSE

This specification contains the guidelines to process the ACTION PIN contact.

2. ADDITIONAL DOCUMENTS**2.1. Customer Drawing**

The customer drawing shows the dimensions, materials and surfaces.

2.2. Product Specification

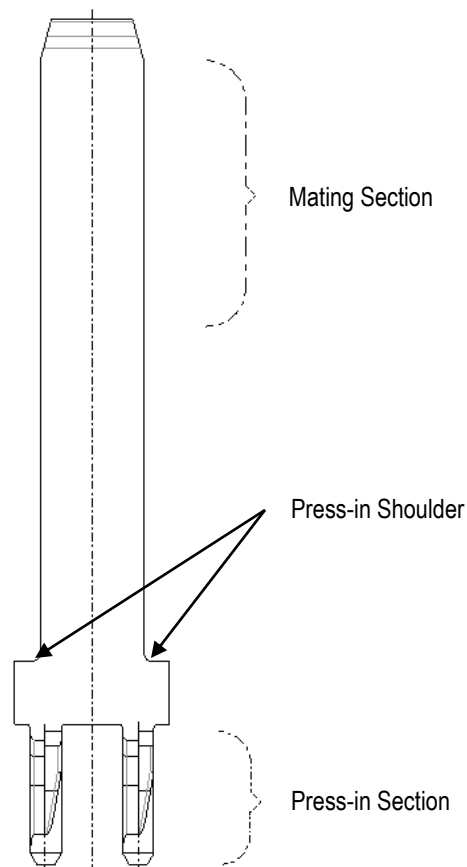
The electrical and mechanical characteristics of the contact are described in the Product Specification 108-18644.

2.3. Test Specification

See Product Specification 108-18644.

3. DESCRIPTION**3.1. Action Pin**

The ACTION PIN consists of the press-in section for Printed Circuit Boards of 1.6mm thickness and the mating section for socket contacts.



4. REQUIREMENTS

4.1. Printed Circuit Board

Printed Circuit board requirements can be found in product specification 108-18644.

4.2. Printed Circuit Board Holes

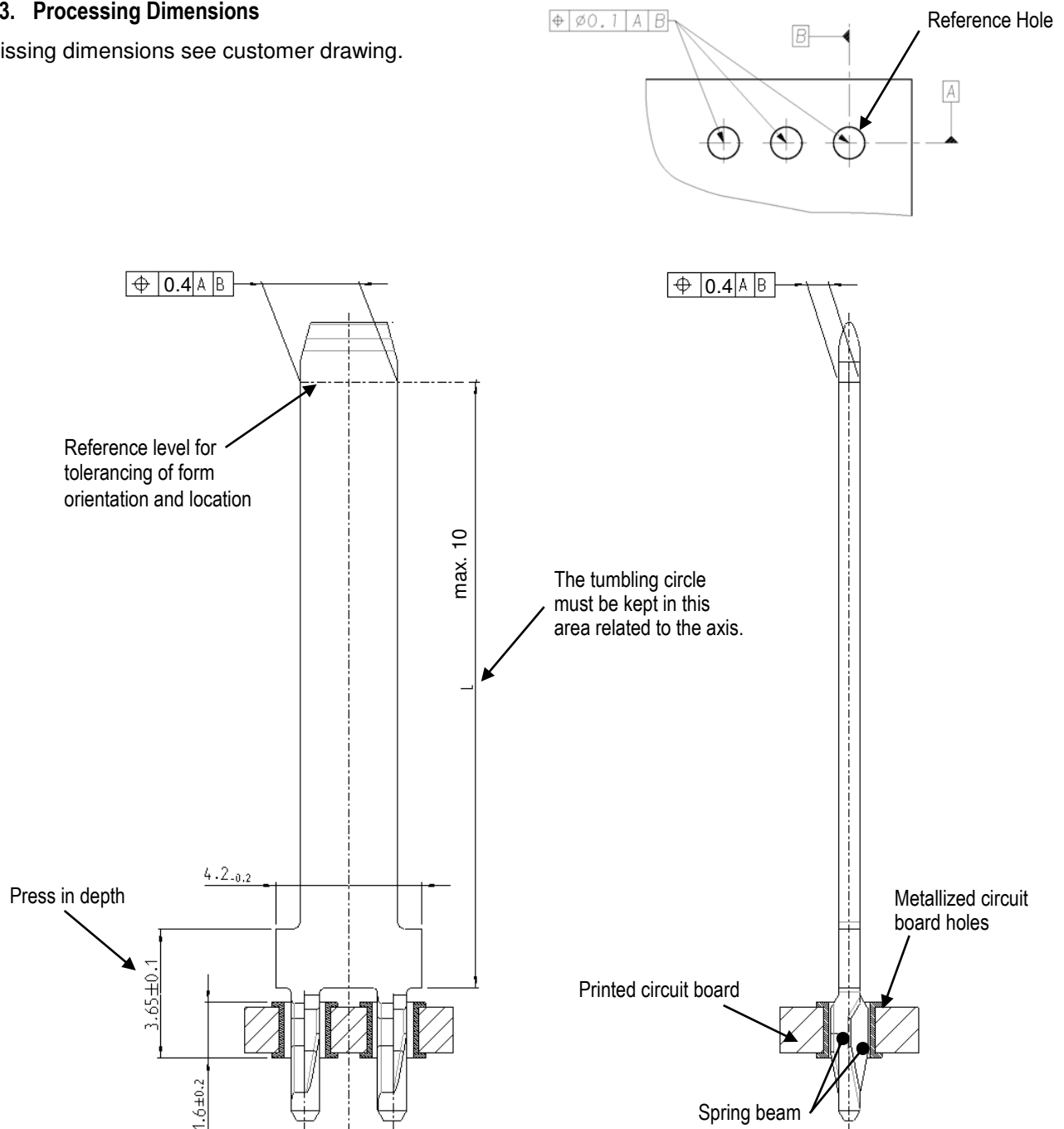
For missing dimensions for the layout of the holes such as i.e.:

- Hole diameter
- Cu layer thickness
- Sn layer thickness

See customer drawing.

4.3. Processing Dimensions

Missing dimensions see customer drawing.



4.4. Press-in Speed and Insertion Force

The different values are dependent on the application and execution; therefore, observe the example in table 4.4.1. If no comparable examples are present, the user must have the individual case tested or checked.

1. Example: Processing Machine P300

<i>Example of processing with P300 X Y insert machine</i>	
<i>Insertion Force</i>	<i>Press-in Speed</i>
<i>120 N... 400 N</i>	<i>max. 200 mm/sec</i>

5. TE CONNECTIVITY PROCESSING TOOLS

Documents and specifications for inserting machines need to be requested from the manufacturer.