



QA Technology Company, Inc.

Following these instructions will ensure that QA Technology sockets are installed in the correct manner for best accuracy, retention force and overall performance.

1) Inspect the Mounting Hole:

Before installing sockets, check that the mounting hole is the correct diameter with the appropriate Go/NoGo gauge (as shown in the table below). When drilling laminates such as G10, there is usually a difference between the drill diameter and the actual measured diameter of the finished hole. Drill feed, spindle speed and material affect selection of the proper diameter drill. Solid carbide, printed circuit board drills with 1/8" shanks are recommended. Diameters of commonly used drills are also shown in the table.

Socket Series	Finished Hole Diameter	Go/NoGo Gage Part Number	Installation Tool Part Number*	Suggested Drill Sizes
025-16	.0205/.0215"	PG25	Request Installation Notes	
039-16, 039-25	.0307/.0317	PG39	IT39	1/32", .80mm
050-05	.0368/.0378	PG050-05/16	IT050-05 or AT50	#63, .95mm
050-16	.0368/.0378	PG050-05/16	IT050-16 or AT50	#63, .95mm
050-R25, 050-T25	.0380/.0390	PG050-25	IT050-25 or AT50	#62, #61
All .075 inch centers	.0530/.0550	PG75	IT75 or AT75	1.35mm, #54
All .100 inch centers	.0670/.0690	PG100	IT100 or AT100	#51, 1.75mm
125-25	.0940/.0960	PG125	IT125	2.4mm, #41

* The IT style tools have fixed set heights, AT style tools are adjustable.

2) Insert the Socket in the Mounting Hole:

The socket should slide easily into the hole until the press ring makes contact with the top surface of the mounting plate.

3) Install the Socket:

Fit the nosepiece of the proper Installation Tool (see table) over the top end of the socket (the end closest to the press ring). Install the socket by lightly tapping the back of the tool several times with a hammer until the nose of the tool contacts the plate. Sockets installed with several light taps will have at least double the pushout force of sockets installed with a single blow.

4) Install the Probe:

Slide the appropriate probe into the socket. Seat the probe fully by pushing in a controlled manner with the proper Probe Installation Tool (PT100/75, PT50/39) or other non-metallic object.