



QA Technology Company, Inc.

Applications Note

Assembly Instructions for UNSET Socket / X Probe Termination Tools

Document# D10046 Rev A ECN# 1892 Page 1 of 1

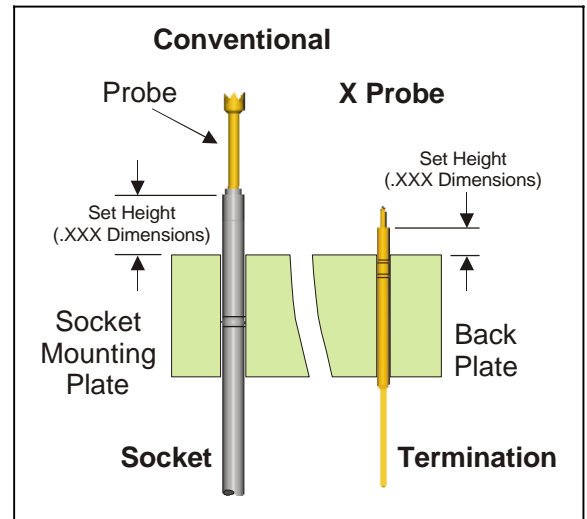
QA Technology's UNSET Socket/Termination installation tools (IT{series}-UNSET and IT-X{series}-UNSET) is a partially assembled Installation Tool for Conventional sockets and X Probe Terminations. All pre-assembly is completed at the factory, and only the adjustment of the socket set height ("XXX" dimension on drawing) and final assembly of the Nosepiece into the Handle are left to be done.

QA Technology also supplies completely assembled Installation Tools with set heights in increments of .001 inches, permanently locked and with the set height engraved on the tool Handle. Also available is a fully adjustable Installation Tool (not available for the X Probe Series), which is recommended when the set height is unknown or may vary.

To adjust and permanently set the socket set height, follow these steps:

Step One: Apply Adhesive to Threads and Assemble Nosepiece.

Apply Loctite Thread Locking Adhesive #262 or equivalent completely around the exposed threads of the Adjuster Screw. *The threads must be locked* or the set height will change during use of the tool. Screw the Drive Pin into the Stop Tube Holder so that the shoulder on the Drive Pin is at the desired .XXX dimension. A socket/termination is helpful for this adjustment, and a preliminary dry assembly is recommended.



Step Two: Allow Adhesive to Cure and Mark Handle.

After adjusting, allow at least five minutes for the adhesive to partially cure so that the set height does not change during installation of the Nosepiece into the Handle. Permanently mark the Handle with the set height (.XXX dimension) to which the Drive Pin was adjusted.

Step Three: Assemble Nosepiece to Handle.

Apply a small amount of Loctite High Strength Retaining Compound #680 or equivalent to the outside of the large end of the Nosepiece. Press the Nosepiece fully into the Handle while twisting to distribute the adhesive.

Allow 24 hours for the adhesive to cure before using the tool.