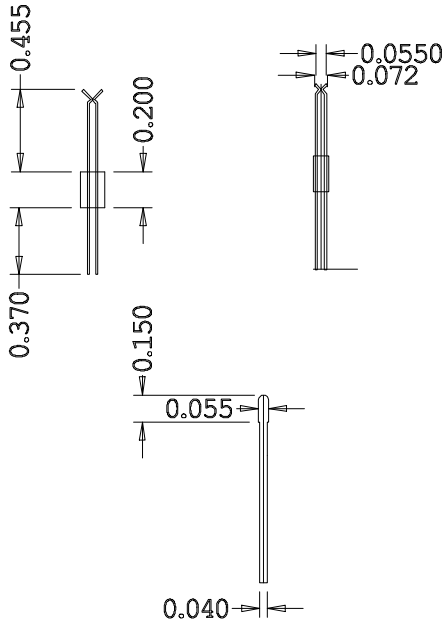

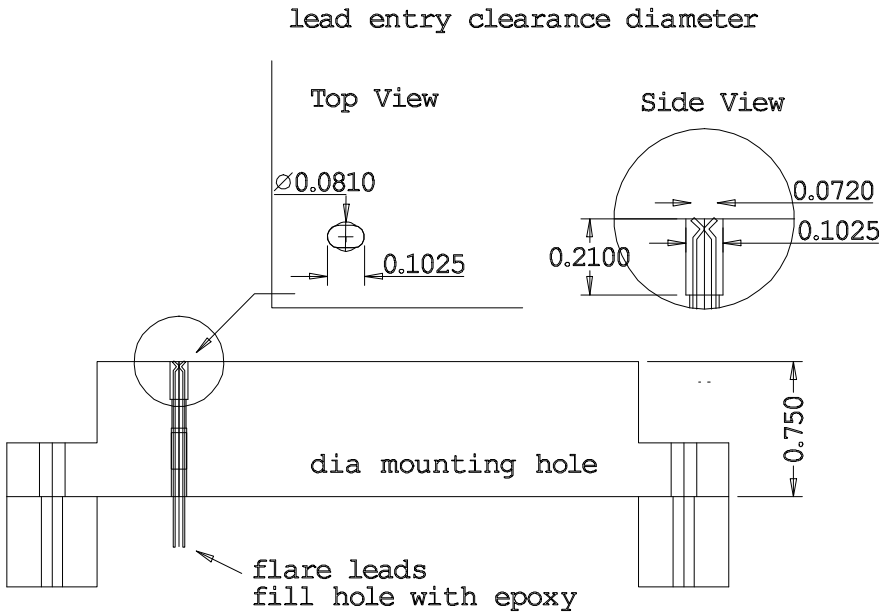

Building a socket

Tools Required :
0.081" dia #46 drill
0.086" dia #44 drill
1/16" dia End mill
5/64 " blade screwdriver
15 minute epoxy
drill press

Instructions :

1. Measure transformer lead diameter.
2. Measure transformer lead spacing.
3. Place or tape guide template to fixture block.
4. Use felt marker to mark holes. (hole to hole on guide = .100", diagonal = .1414")
5. Place on drill press. drill 0.081"dia completely through block.
6. Slot top holes for lead clearance (See Drawing) drill no deeper than 0.210".
7. Variation in the k100 barrel diameter may require the hole to be made wider by drilling from the back 0.085" dia. leaving 0.375" stock as measured from the top of the socket.
8. Flip socket over insert pin, and align.
9. Press in pin to desired depth using pressure on plastic barrel of pin. NEVER USE FORCE ON THE GOLD CONTACT !
   NOTE : a 5/64" flat blade screwdriver works good for this.
10. Spread leads and fill hole with epoxy.

Wilco K100 .100 kelvin pin
typical block thickness 0.75"

Warning !!! NEVER BEND OR FORCE PIN
Pin is meant to be epoxied in place.
When removing pin grasp both leads firmly with pliers.

Press in place by using light force on rear of plastic barrel, never on surface contact of pin.

Minimum pin to pin spacing .100"

Wilco Control Service
.100" kelvin pin
Date Sept. 9, 1999
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