

NOTES: UNLESS OTHERWISE SPECIFIED.

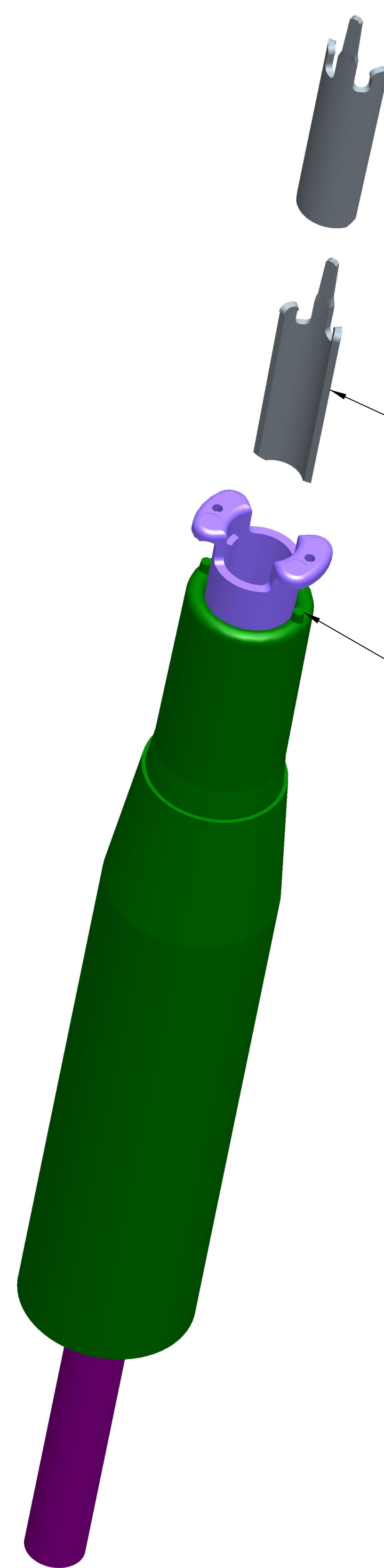
1. FLUKE IS WILLING TO INVEST IN COST EFFECTIVE TOOLING TO ACHIEVE AN EFFICIENT MOLDING OPERATION.
2. IT IS RECOMMENDED THAT TOOLING BE DEVELOPED TO FACILITATE THE EFFECIENT INSERT MOLDING OF A FOUR CAVITY TOOL WITH NO OPEN MOLD IDLE TIME.
3. A MULTITUDE OF FOUR CAVITY TOOLING RACKS FOR 16 TOWER SUB-ASSEMBLY LOADING SHOULD BE FABRICATED TO ALLOW QUICK MOLDING TOOL CYCLES.

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UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN MILLIMETERS (INCHES)		<b>INSERT MOLDING TOOLING          RACK LOADING PINS          TOOLING CONCEPT</b>	
TOLERANCES ARE: .X = ± SEE SHEET 1 .XX = ± FOR TOLERANCE ANGLES = ±		DRAWING NO. <b>D</b> SIZE <b>D</b> PART NO. <b>H9</b> FSCM <b>536</b> <b>DO NOT SCALE DRAWING</b>	
		SHEET 1 OF 3	

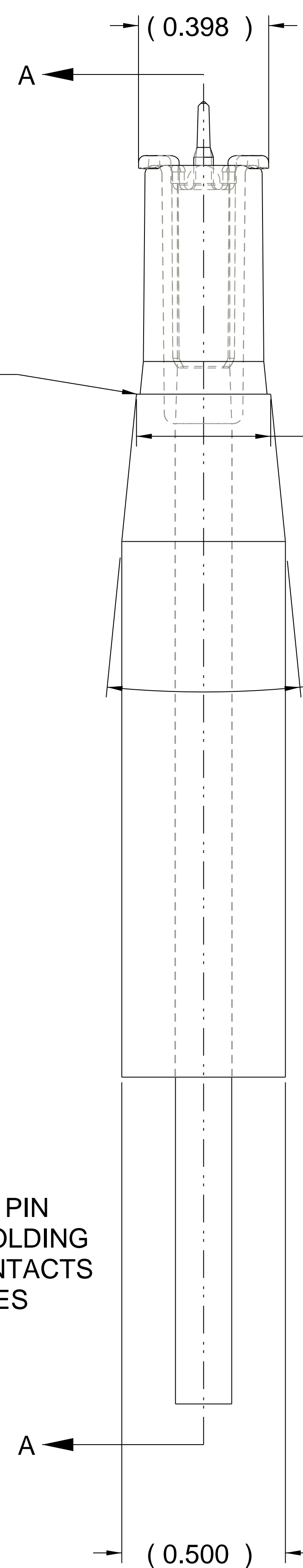




—ALIGN TAPERED HOLES  
IN TOWER  
WITH TAPERED PINS  
ON TOOLING PIN

ALIGNS WITH TOP SURFACE  
OF MAIN BODY PART

# LOADING RACK PIN FOR INSERT MOLDING OF TOWER/CONTACTS SUB-ASSEMBLIES

A 
$$- (0.410)$$
 $(11.4^\circ)$ A 

( 0.500 )

THE TOWER PART HAS 1.1 DEGREE DRAFT ON THE OUTSIDE SURFACE ONLY. IF DRAFT WAS ADDED TO THE INSIDE SURFACE TO ALLOW FOR A TAPERED CORE PIN AN UNDERCUT WOULD BE CREATED, ALONG WITH A REDUCED WALL THICKNESS IN AN AREA THAT IS ALREADY VERY THIN.

→ ( 1.1 ° ) ←  
DRAFT

— ( 0.0 ° )  
NO  
DRAFT

( 0.021 ) -  
MIN.  
TOWER  
WALL  
THICKNESS

CORE PIN MUST BE  
PULLED PRIOR TO  
OPENING MOLD TO  
PREVENT DAMAGE  
TO MOLDED PART.

SECTION A-A

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MILLIMETERS [INCHES]

TOLERANCES ARE:  
.XX = ± .005  
.XXX = ± 0.001  
ANGLES = ± 1/8 °

FLUKE

FLUKE CORPORATION  
PO BOX 9090  
EVERETT, WA 98206-9090

# INSERT MOLDING TOOLING

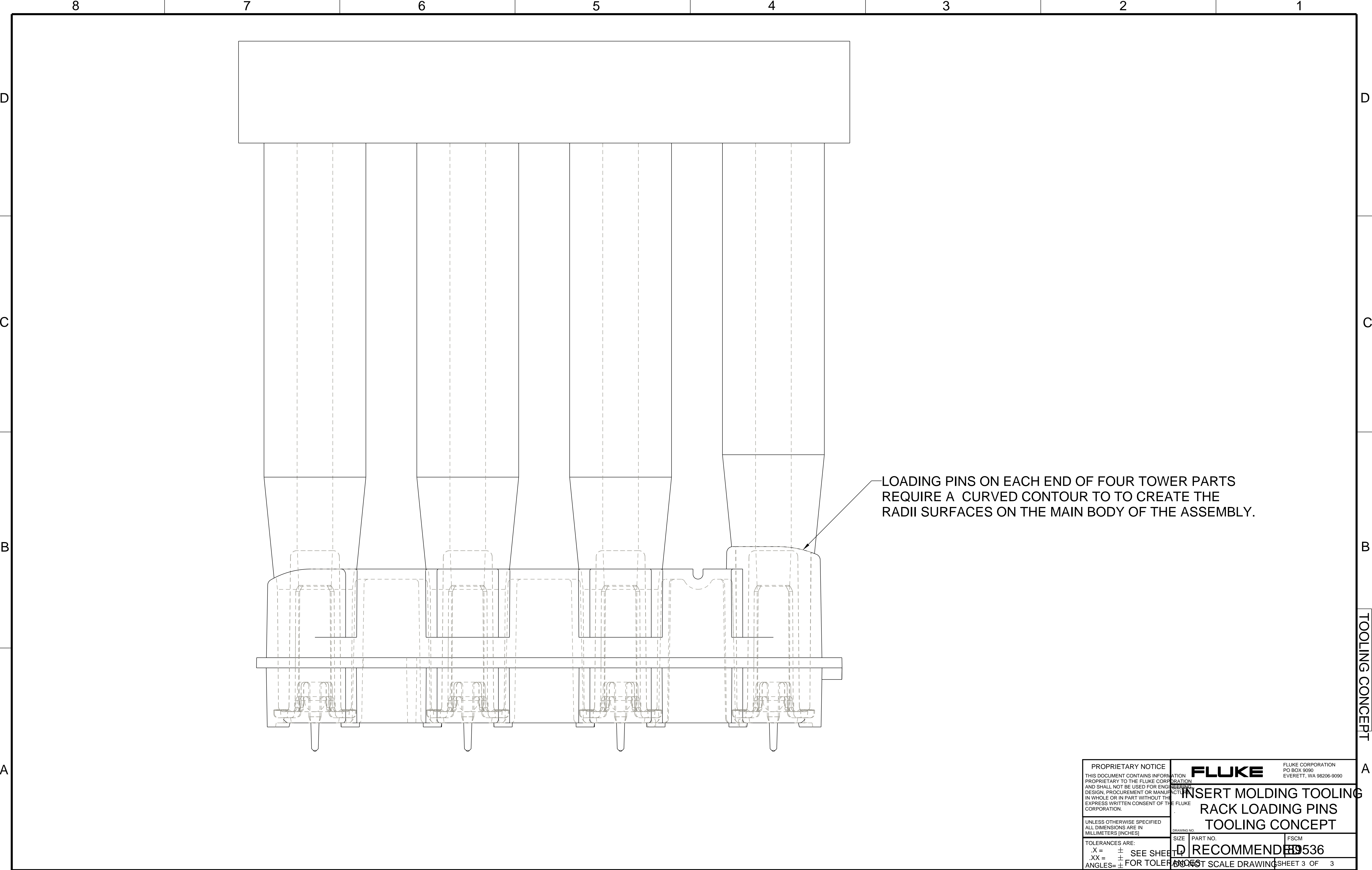
DRAWING NO.		TOOLING CONCEP	
SIZE	PART NO.	FSCM	
D	RECOMMENDED	89536	

DO NOT SCALE DRAWING SHEET 2 OF 3

SHEET 2 OF 3

## TOOLING CONCEPT

A



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TOLERANCES ARE: .X = ± .XX = ± ANGLES = ±		SIZE	PART NO.
SEE SHEET 1 FOR TOLERANCES		RECOMMENDED	FSCM
NOT TO SCALE DRAWING		89536	
SHEET 3 OF 3			