

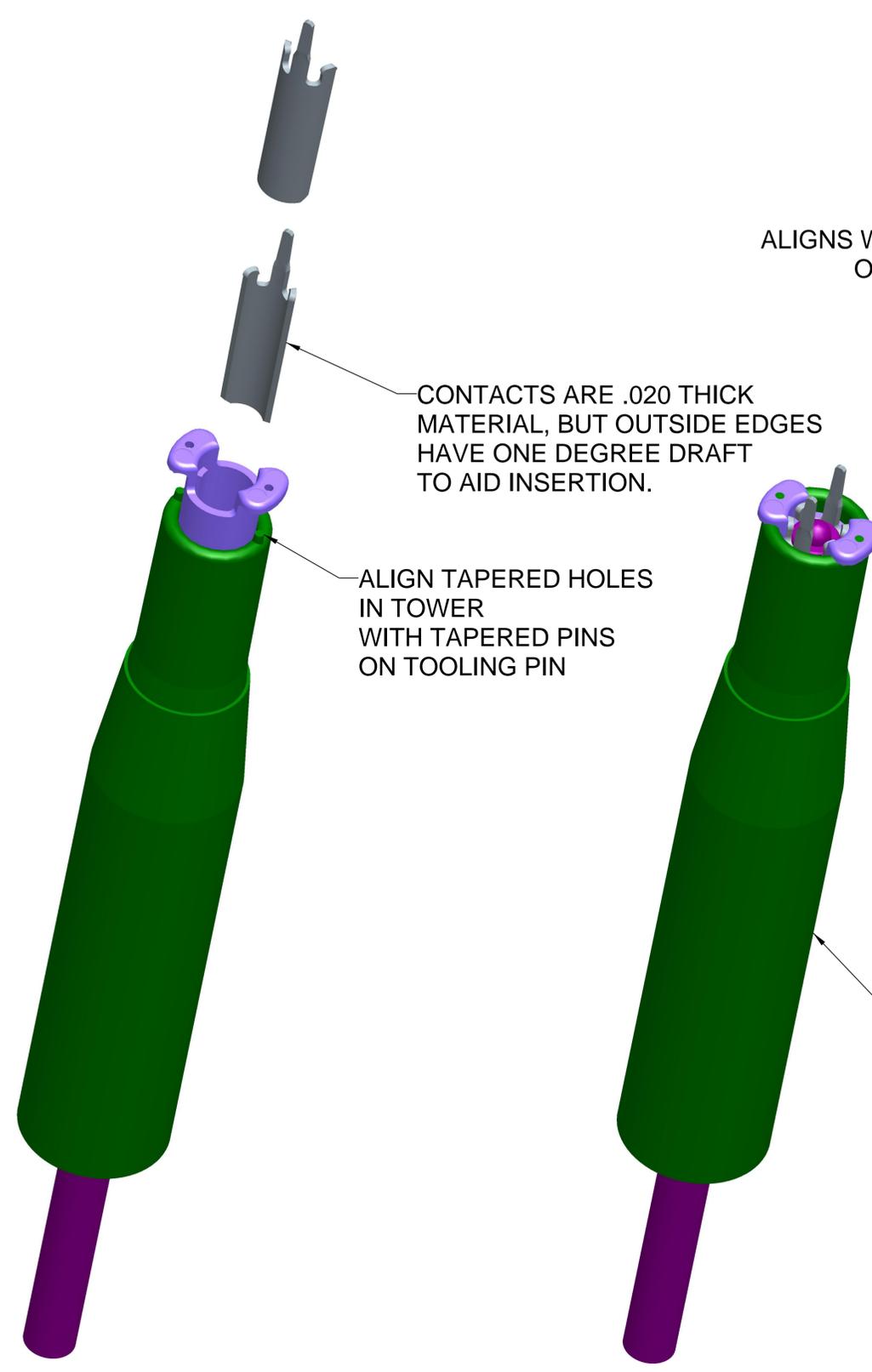
NOTES: UNLESS OTHERWISE SPECIFIED.

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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	INSERT MOLDING TOOLING RACK LOADING PINS TOOLING CONCEPT		
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN MILLIMETERS [INCHES]	DRAWING NO. D	PART NO. 9536	FSCM 9536
TOLERANCES ARE: .X = ± SEE SHEET 4 .XX = ± FOR TOLERANCE NOTES	RECOMMENDED SCALE DRAWING SHEET 1 OF 3		

D
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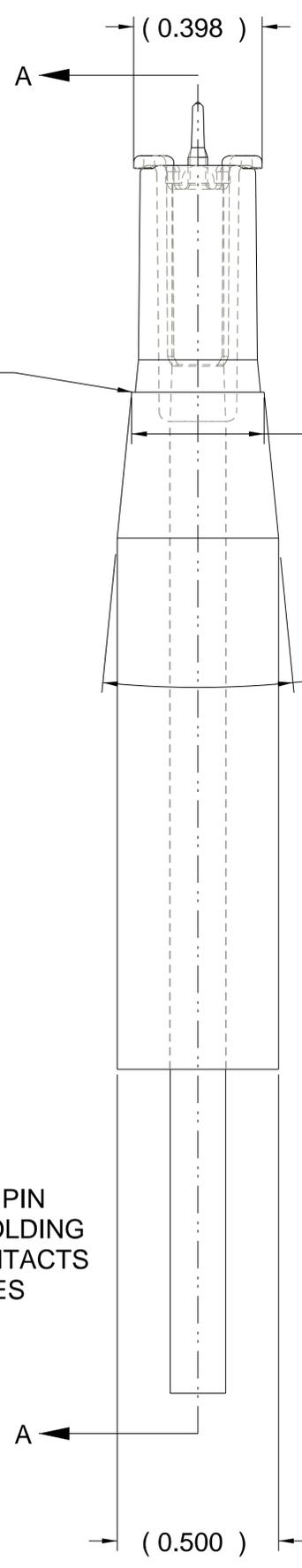


ALIGNS WITH TOP SURFACE OF MAIN BODY PART

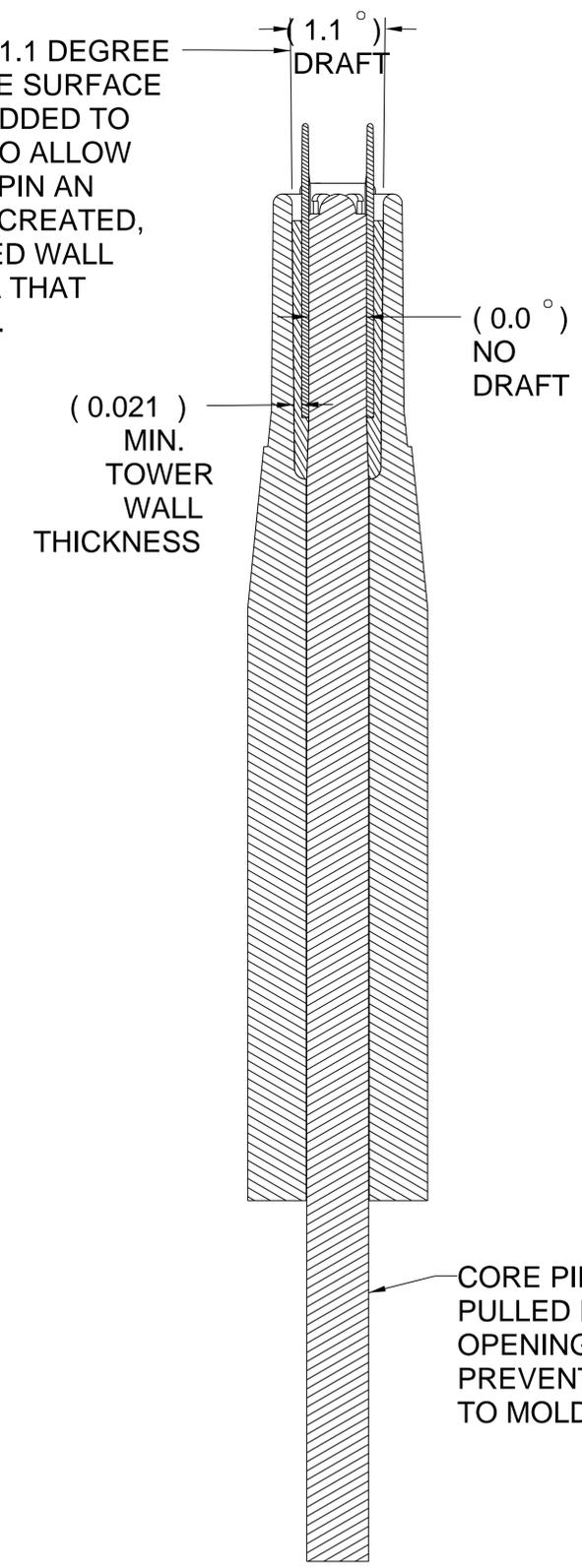
CONTACTS ARE .020 THICK MATERIAL, BUT OUTSIDE EDGES HAVE ONE DEGREE DRAFT TO AID INSERTION.

ALIGN TAPERED HOLES IN TOWER WITH TAPERED PINS ON TOOLING PIN

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



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.



SECTION A-A

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TOLERANCES ARE: .XX = ± .005 .XXX = ± 0.001 ANGLES = ± 1/8	DO NOT SCALE DRAWINGS		

TOOLING CONCEPT

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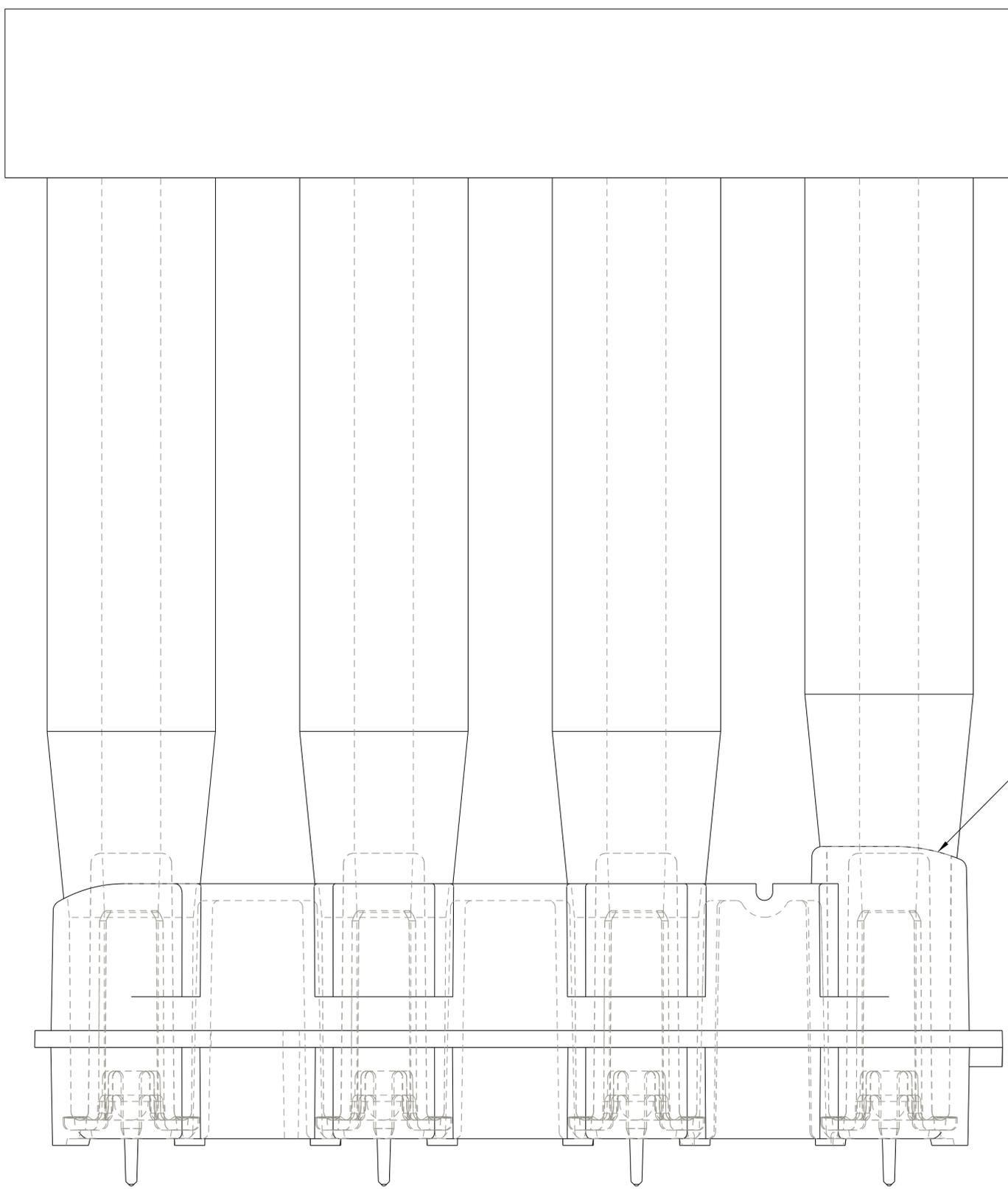
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LOADING PINS ON EACH END OF FOUR TOWER PARTS REQUIRE A CURVED CONTOUR TO TO CREATE THE RADII SURFACES ON THE MAIN BODY OF THE ASSEMBLY.

TOOLING CONCEPT

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TOLERANCES ARE: .X = ± SEE SHEET 1 .XX = ± FOR TOLERANCE NOTES ANGLES = ±	NOT TO SCALE DRAWING SHEET 3 OF 3		