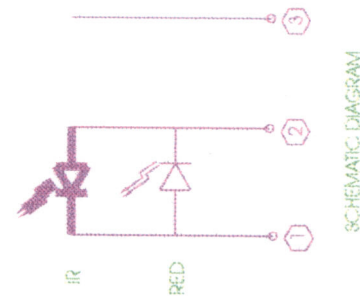
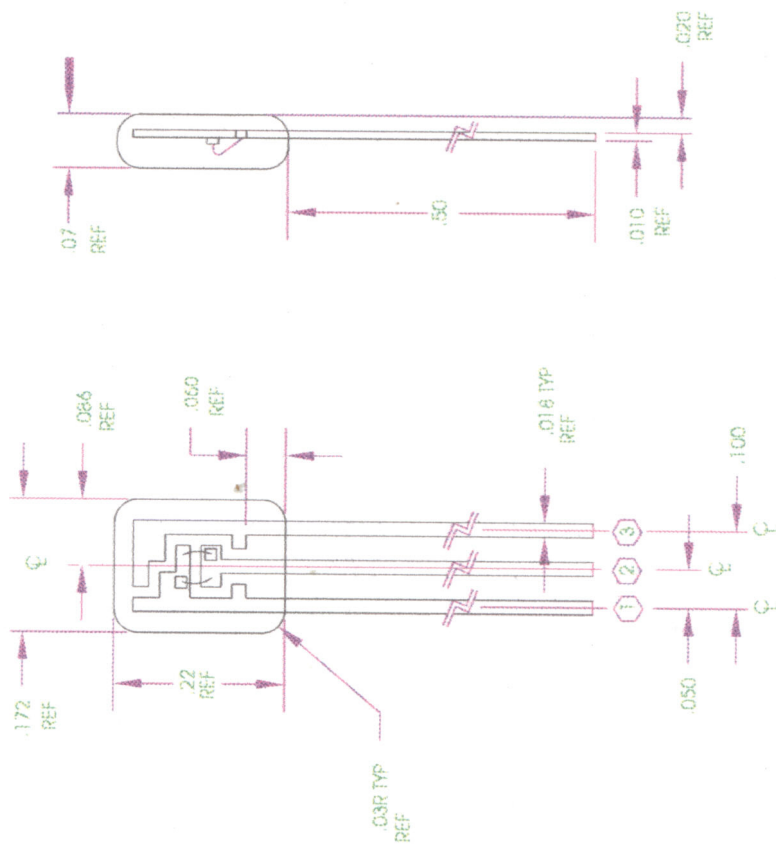
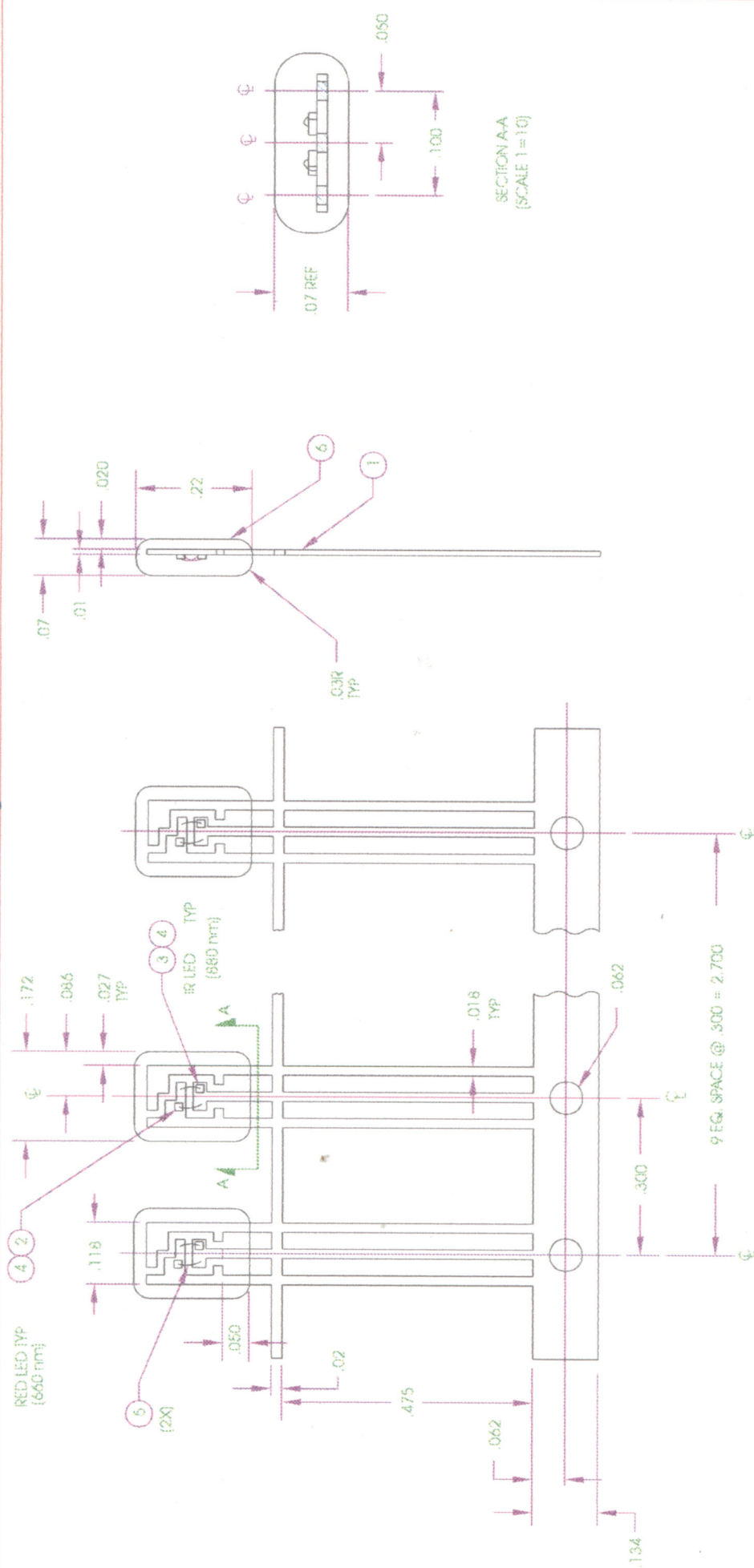




		TITLE: LED ASSEMBLY	
FINISH:		DWG NO.:	
MATERIAL:		SCALE:	
A. REMOVE ALL BURRS B. MACHINE SURFACES AS C. BREAK ALL SHARP D. DIMENSIONS PER ANSI Y14.5 E. DIMENSIONS ARE IN INCHES F. DO NOT SCALE DRAWING		G. TOLERANCE/UN D/CAMLS XX 2K TOLERANCE XXX 3K TOLERANCE	
ANGLE ANGLE		ANGLE TOLERANCE XX 2K TOLERANCE XXX 3K TOLERANCE	
REV:		SHEET:	
REVISION LETTER:		OF:	

NOTES: UNLESS OTHERWISE SPECIFIED.

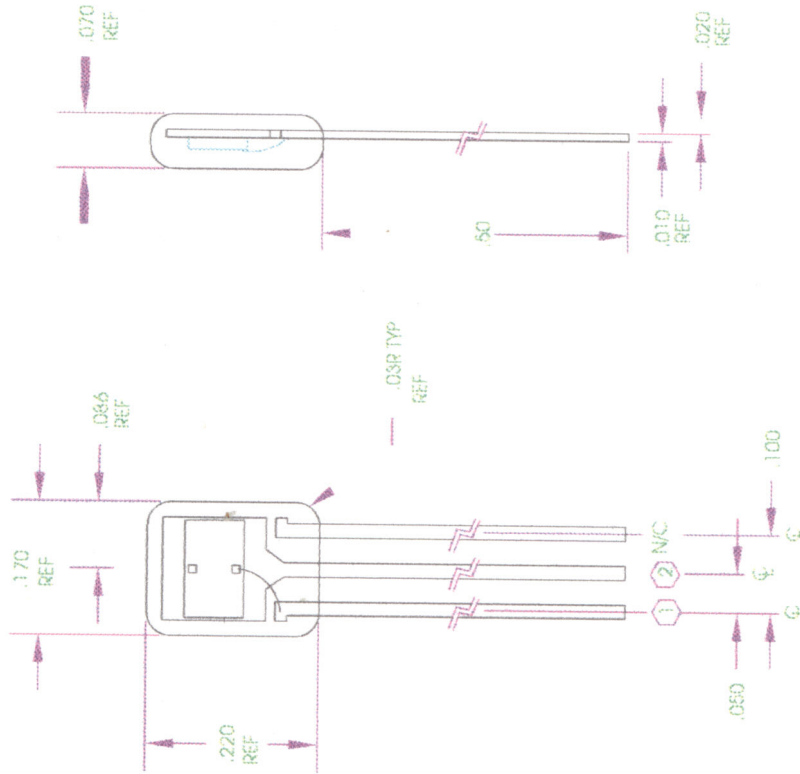


FINISH A. REMOVE ALL BURRS B. MACHINE SURFACES AS SHOWN C. BREAK ALL SHARP EDGES .010 MAX D. DIMENSIONS PER ANSI Y14.5 E. DIMENSIONS ARE IN INCHES F. DO NOT SCALE DRAWING		G. TOLERANCES ON DECIMALS XX .XX TOLERANCE XXX .XXX TOLERANCE ANGLES XX .XX TOLERANCE XXX .XXX TOLERANCE		TITLE LED ASSEMBLY	
MATERIAL		DWG NO.		SCALE:	
REV		DRAWING NUMBER		SIZE:	
REVISION LETTER		SHEET		OF	

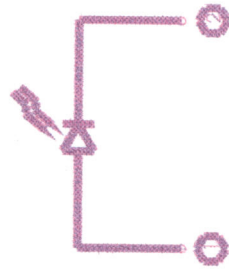
4. NO CRACK ALLOWED ON MOLDED PART.
 3. MOLDED PART SHOULD MEET ISO/ISO SCRYATCH/DIG CRITERIA.
 2. MOLDED PART SHOULD BE FREE OF FLASHES.

NOTES: UNLESS OTHERWISE SPECIFIED.

Form ENG023 (04/93)



FINISHED PART



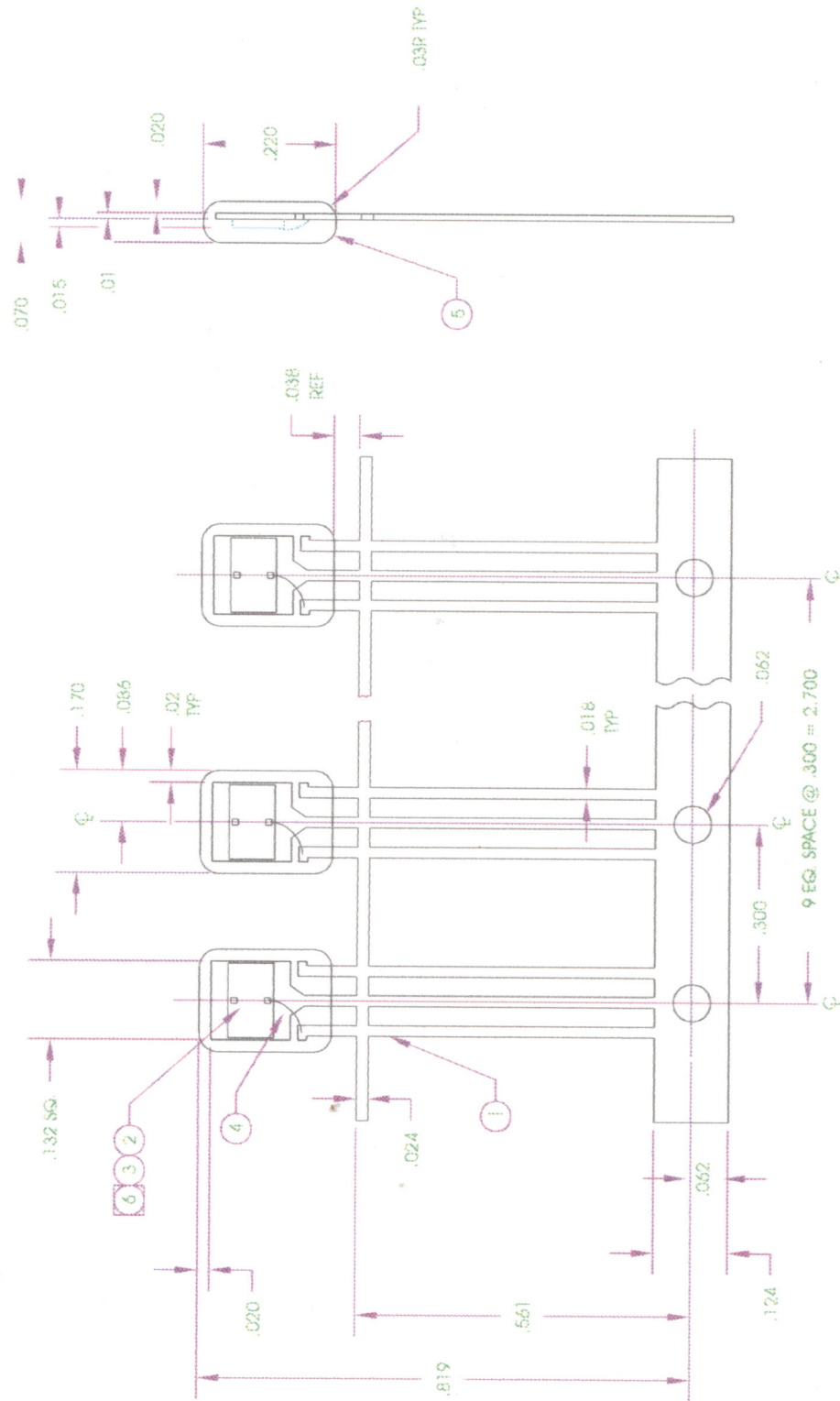
SCHEMATIC DIAGRAM

		DETECTOR ASSEMBLY	
TITLE		DRAWING NUMBER	
DWG NO.		SCALE:	
REV		SHEET	
REVISION LETTER		OF OF	
G. TOLERANCES ON DECIMALS		ANGLE	
XX 2X TOLERANCE		ANGLE TOLERANCE	
XXX 3X TOLERANCE		ANGLE TOLERANCE	
A. REMOVE ALL BURRS		B. MACHINE SURFACES AS	
C. BREAK ALL SHARP EDGES .010 MAX		D. DIMENSIONS PER ANSI Y14.5	
E. DIMENSIONS ARE IN INCHES		F. DO NOT SCALE DRAWING	

NOTES: UNLESS OTHERWISE SPECIFIED.

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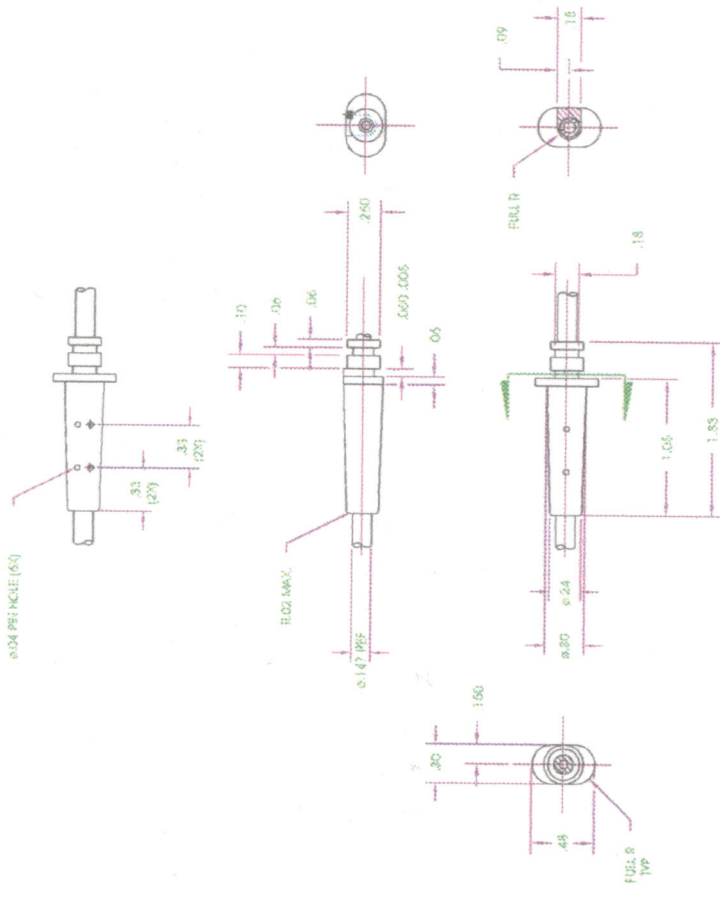
Probe P858 RA 03/25/98



- 1. MOUNT CHIP AS SHOWN, CENTER CHIP TO CENTER OF PAD WITHIN 0.01".
- 2. NO CRACK ALLOWED ON MOLDED PART.
- 3. MOLDED PART SHOULD MEET 80/20 SCRATCH/DIG CRITERIA.
- 4. MOLDED PART SHOULD BE FREE OF FLASHES.

NOTES: UNLESS OTHERWISE SPECIFIED:

 1540 LOGAN AVENUE, COSTA MESA, CA 92626	
TITLE: DETECTOR ASSEMBLY	
DWG NO.	DRAWING NUMBER
SCALE:	SIZE: B
SHEET	SHEET OF OF
REV	REVISION LETTER



DETAIL A

DETAIL B

 1360 LOGAN AVENUE, COSTA MESA, CA 92626		TITLE CABLE ASSEMBLY		REV REVISION LETTER	
FINISH		DWG NO.		SIZE: B	
MATERIAL		SCALE:		SHEET B OF OF	
A. REMOVE ALL BURRS B. MACHINE SURFACES AS C. BREAK ALL SHARP EDGES .010 MAX D. DIMENSIONS PER ANSI Y14.5 E. DIMENSIONS ARE IN INCHES F. DO NOT SCALE DRAWING		G. TOLERANCES ON DECIMALS XX .XX TOLERANCE XXX .XXX TOLERANCE		ANGLE ANGLE	

NOTES: UNLESS OTHERWISE SPECIFIED.

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1940 LOOM AVENUE, COSTA MESA, CA 92626

CABLE ASSEMBLY

CABLE ASSEMBLY

DRAWING NUMBER

DRAWING NUMBER

SIZE:

SIZE:

DOC8 FILE NAME:

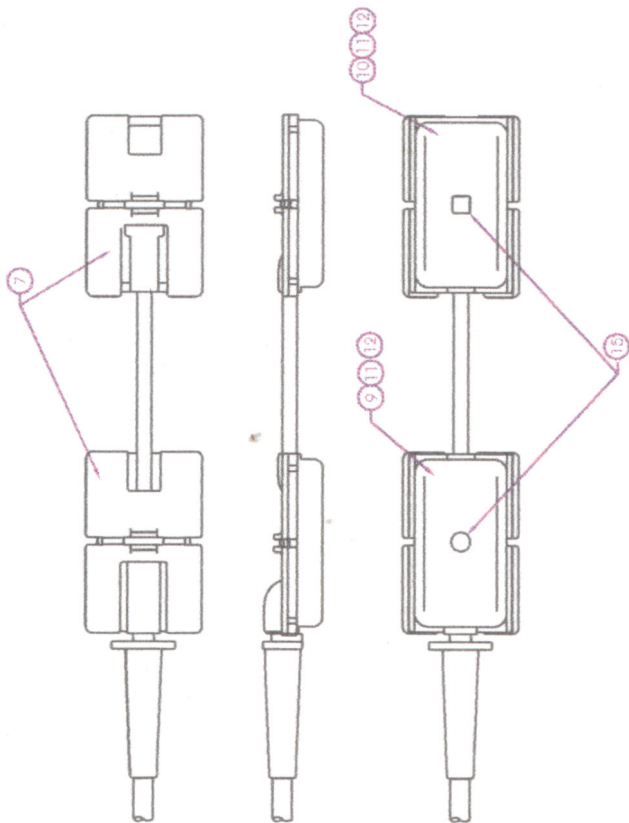
DOC# FILE NAME

NOTES: UNLESS OTHERWISE SPECIFIED.

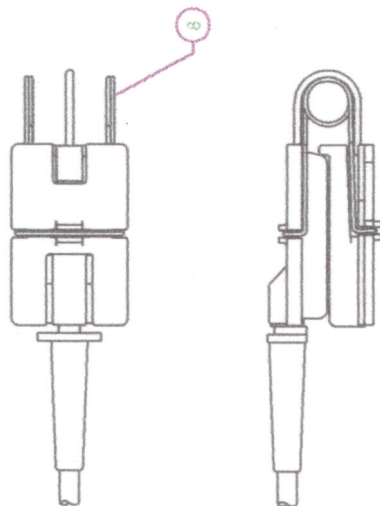
Form ENG023 (04/93)

Probe P858 RA 03/25/98

Probe P858 RA



FRAME TO POUCH/CABLE ASSEMBLY



SPRING TO POUCH ASSEMBLY

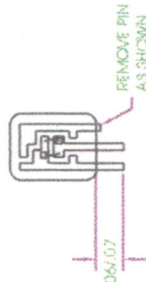
 1849 LONDRON AVENUE, SUITE 100, COSTA MESA, CA 92627		REV REVISION LETTER	
TITLE FINAL ASSEMBLY		DWG NO.	DRAWING NUMBER
SCALE:		SIZE: B	SHEET OF
FINISH		DOE FILE NAME	
MATERIAL		DOE FILE NAME	
A. REMOVE ALL BURS B. MACHINE SURFACES 53 C. BREAK ALL SHARP EDGES .010 MAX D. DIMENSIONS PER ANSI Y14.5 E. DIMENSIONS ARE IN INCHES F. DO NOT SCALE DRAWING		G. TOLERANCES ON DECIMALS .XX 2X TOLERANCE .XXX 3X TOLERANCE	
ANGLES ANGLE TOLERANCE		SCALE:	

NOTES: UNLESS OTHERWISE SPECIFIED.

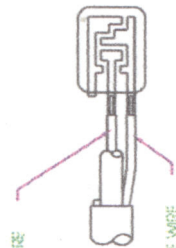
Form ENG023 (04/93)

Probe P858 RA 03/25/98

EMITTER



RED WIRE



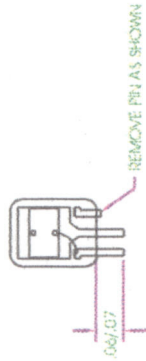
BLACK WIRE



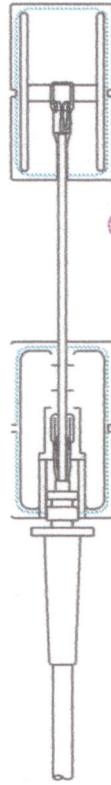
WHITE WIRE

SOLDER WIRE TO BACK SIDE OF PIN (TYP)

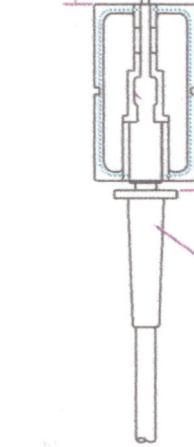
DETECTOR



REMOVE PIN AS SHOWN



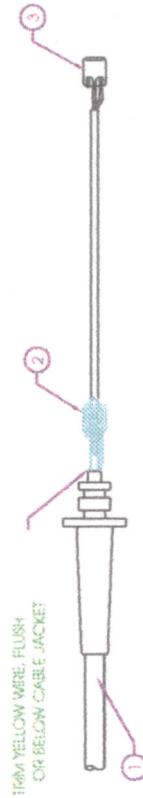
1.24 TO



0.78

STRAIN RELIEF OF CABLE
MUST BE POSITIONED AS SHOWN
PRIOR OVERMOLDING

CABLE ASSEMBLY TO POUCH

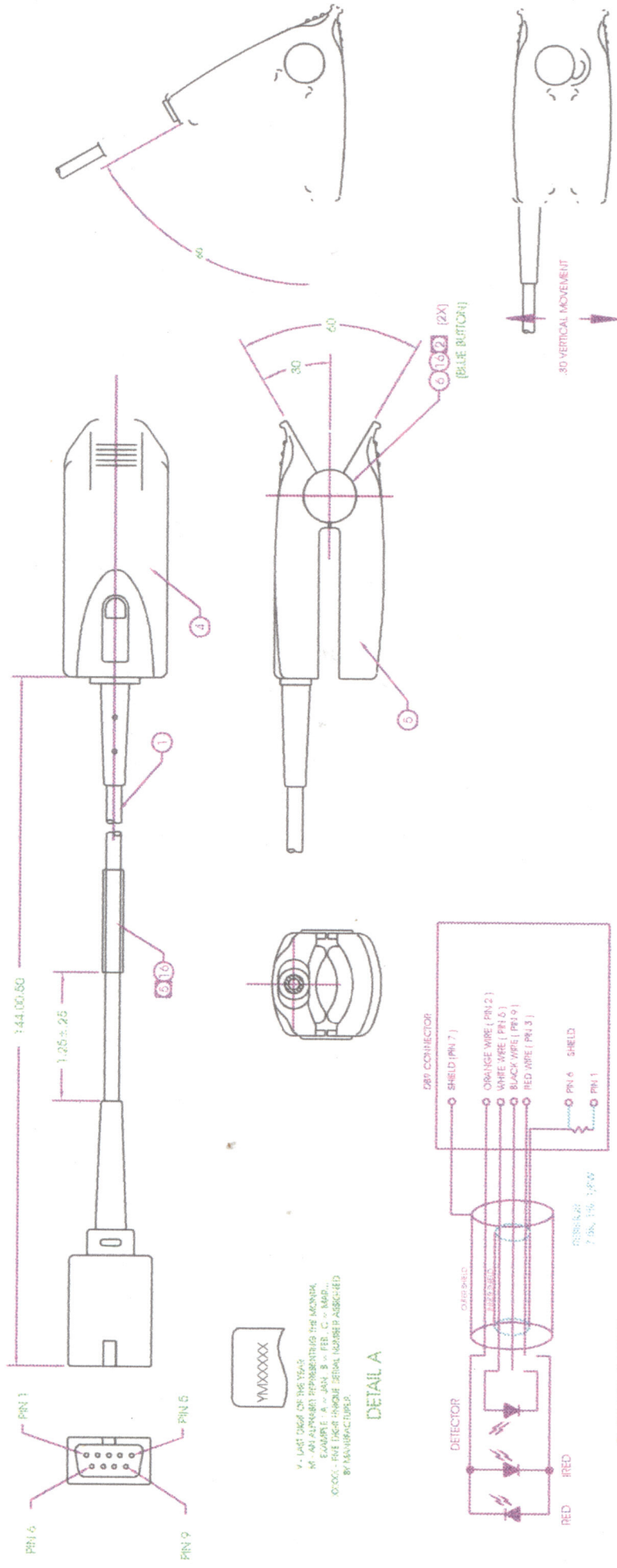


CERAMIC ASSEMBLY (LED/DET) TO CABLE

		TITLE: FINAL ASSEMBLY	
FINISH:		DWG NO.:	
MATERIAL:		DRAWING NUMBER:	
A. REMOVE ALL BURRS B. MACHINE SURFACES .03 C. BREAK ALL SHARP EDGES .010 MAX D. DIMENSIONS PER ANSI Y14.5 E. DIMENSIONS ARE IN INCHES F. DO NOT SCALE DRAWING		SCALE:	
G. TOLERANCES ON DECIMALS XX .2X TOLERANCE XXX .3X TOLERANCE		ANGLE:	
ANGLE:		ANGLE TOLERANCE:	
REV:		SHEET:	
REVISION LETTER:		SHEET OF:	

NOTES: UNLESS OTHERWISE SPECIFIED.

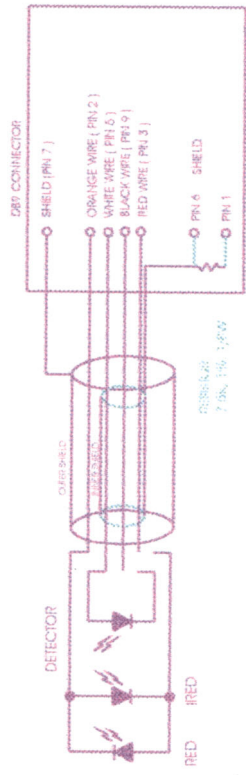
Form ENG023 (04/93)



VXXXXX

V - LAST DIGIT OF THE YEAR
M - JANUARY REPRESENTING THE MONTH
EXAMPLE: A - JAN, B - FEB, C - MAR, ...
OCC - FIVE DIGIT INHOUSE SERIAL NUMBER ASSIGNED BY MANUFACTURER

DETAIL A



SCHEMATIC

- ⑤ PRINT SERIAL NUMBER AND DATE CODE ON LABEL. SEE DETAIL A.
- ④ PRIOR APPRIVING ISO 9000 DETACH AND CLEAN BOTH WIRES FOR BETTER BONDING.
- ③ PRIOR TO APPLYING SILICONE EPOXY (ITEM 11) TO TOP/BOTTOM FRAMES, TREAT BONDING AREA OF TOP/BOTTOM FRAME WITH PRIMER (ITEM 12).
- ② NO EPOXY (ITEM 16) ALLOWED ON SURFACE OF PROBE. DO NOT APPLY EXCESSIVE EPOXY.

NOTES: UNLESS OTHERWISE SPECIFIED.

		TITLE FINAL ASSEMBLY	
FINISH		DWG NO.	
MATERIAL		SCALE:	
A. REMOVE ALL BURRS B. MACHINE SURFACES AS C. BREAK ALL SHARP EDGES .010 MAX D. DIMENSIONS PER ANSI Y14.5 E. DIMENSIONS IN INCHES F. DO NOT SCALE DRAWING		DRAWING NUMBER	
G. TOLERANCES ON DECIMALS XX 2X TOLERANCE XXX 3X TOLERANCE		REV REVISION LETTER	
ANGLES 		SIZE: B	
SHEET		SHEET OF OF	
DOS FILE NAME: D08 FILE NAME			

Form ENG023 (04/93)