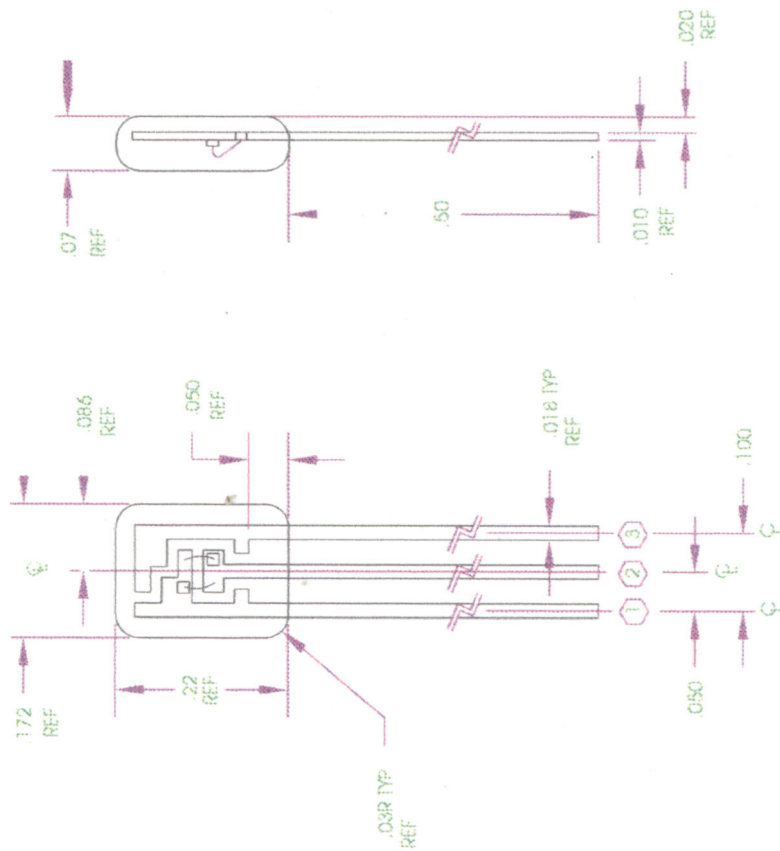
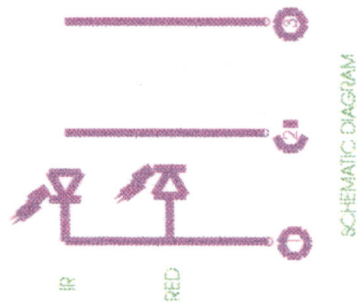




FINISHED PART



SCHEMATIC DIAGRAM



TITLE LED ASSEMBLY

DWG NO.

ANGLE TOLERANCE

DECIMALS
XX 2X TOLERANCE
XXX 3X TO FINISH

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

MATERIAL

SCALE:

SIZE: B

SHEET OF

OF

REVISION LETTER

REV

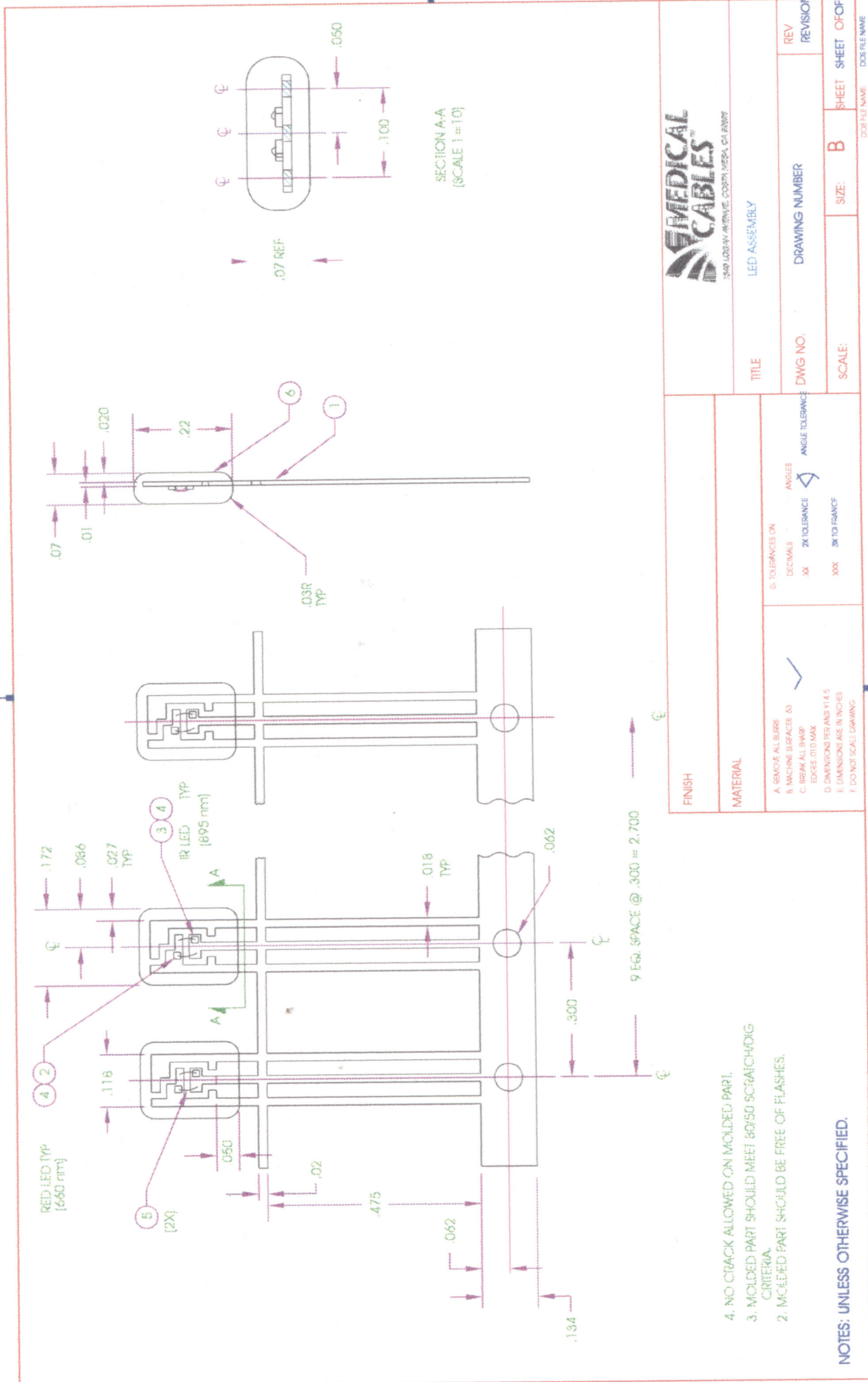
DOE FILE NAME

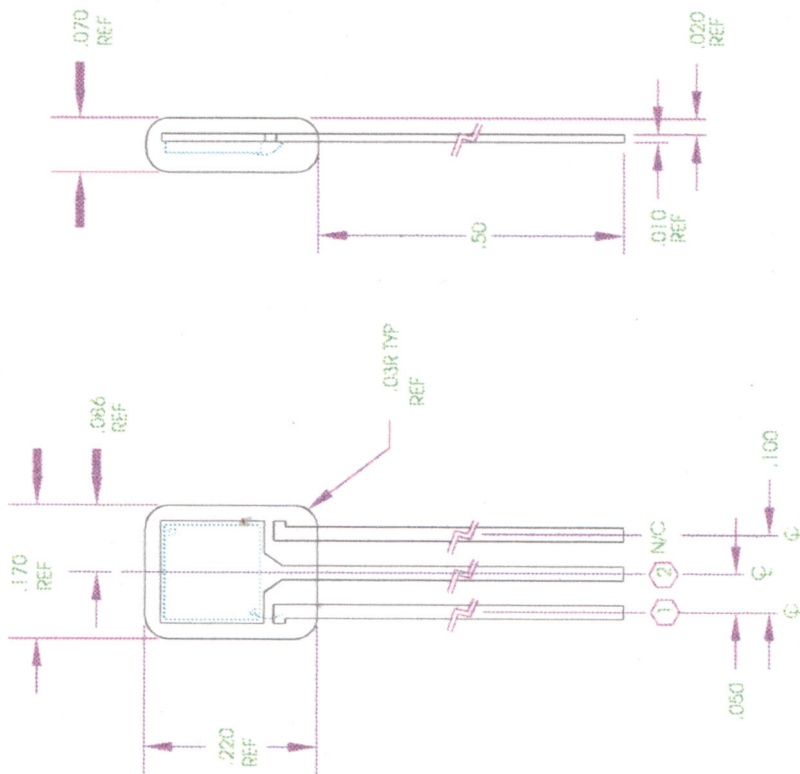
DOE FILE NAME

NOTES: UNLESS OTHERWISE SPECIFIED.

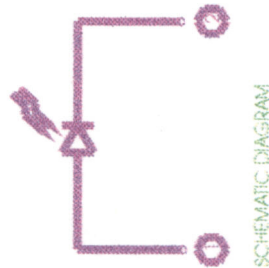
Form ENG023 (04/93)

Probe P872 RA 03/25/98





FINISHED PART



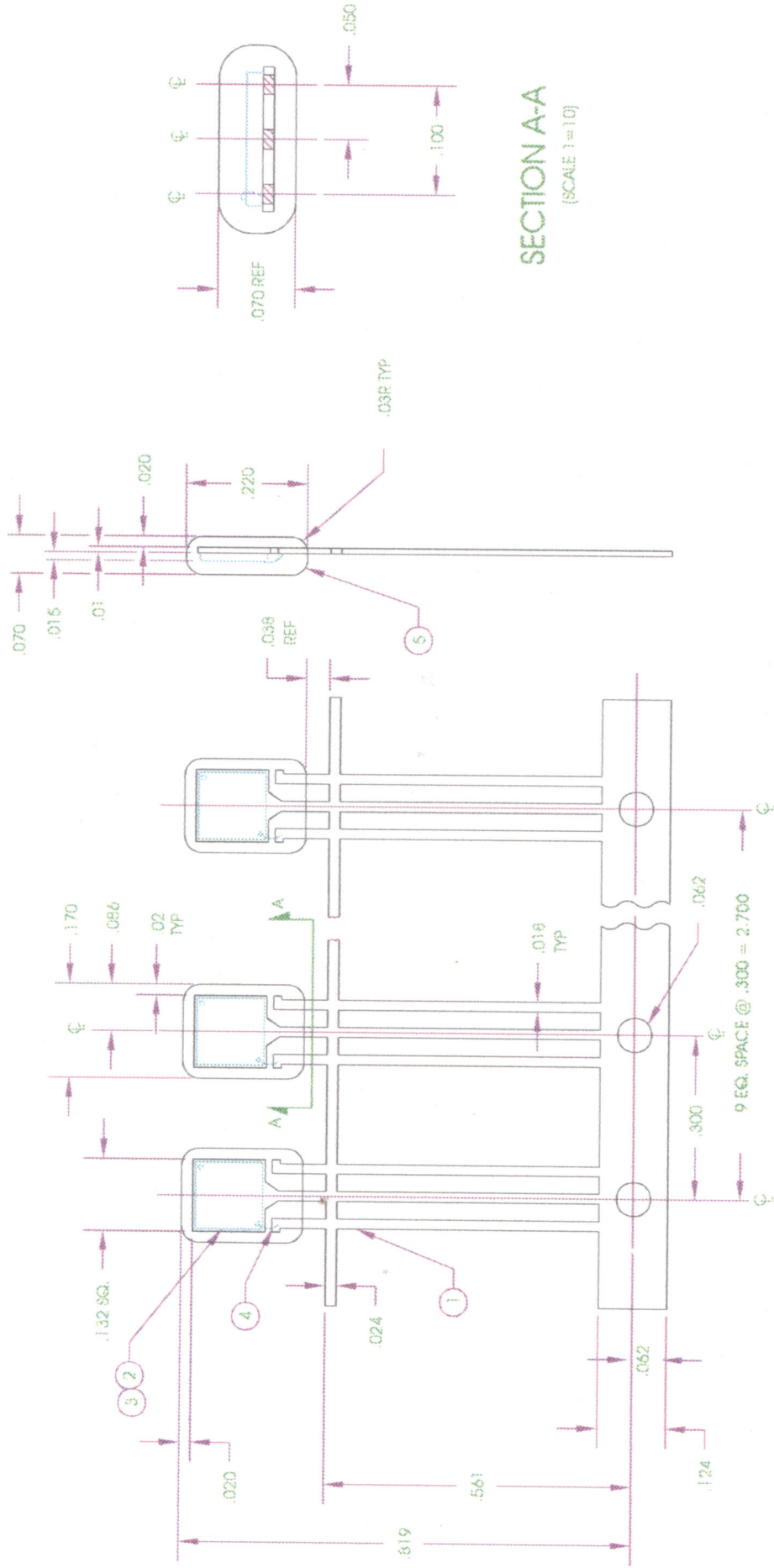
SCHEMATIC DIAGRAM

 1840 LOGAN AVENUE, COSTA MESA, CA 92626		TITLE: DETECTOR ASSEMBLY	
FINISH:		DWG NO.:	
MATERIAL:		SCALE:	
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 .2X TOLERANCE XXX .3X TOLERANCE	
ANGLES 		ANGLE TOLERANCE XXX .3X TO FRANGE	
REV:		SHEET: B	
REVISION LETTER		OF:	

NOTES: UNLESS OTHERWISE SPECIFIED.

Form ENG023 (04/93)

Probe P872 RA 03/25/98



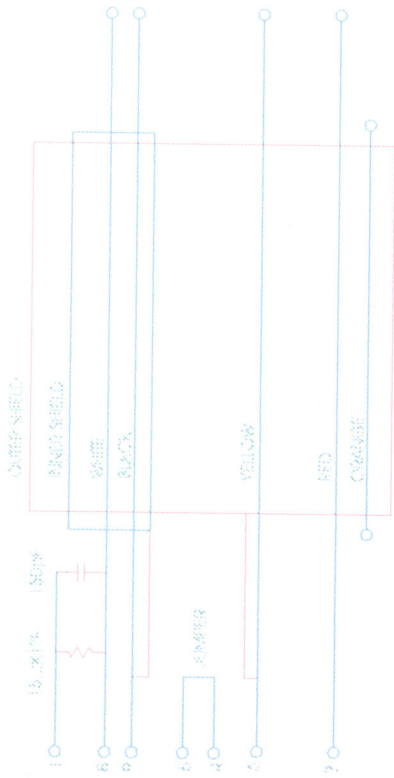
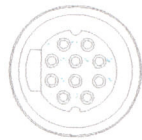
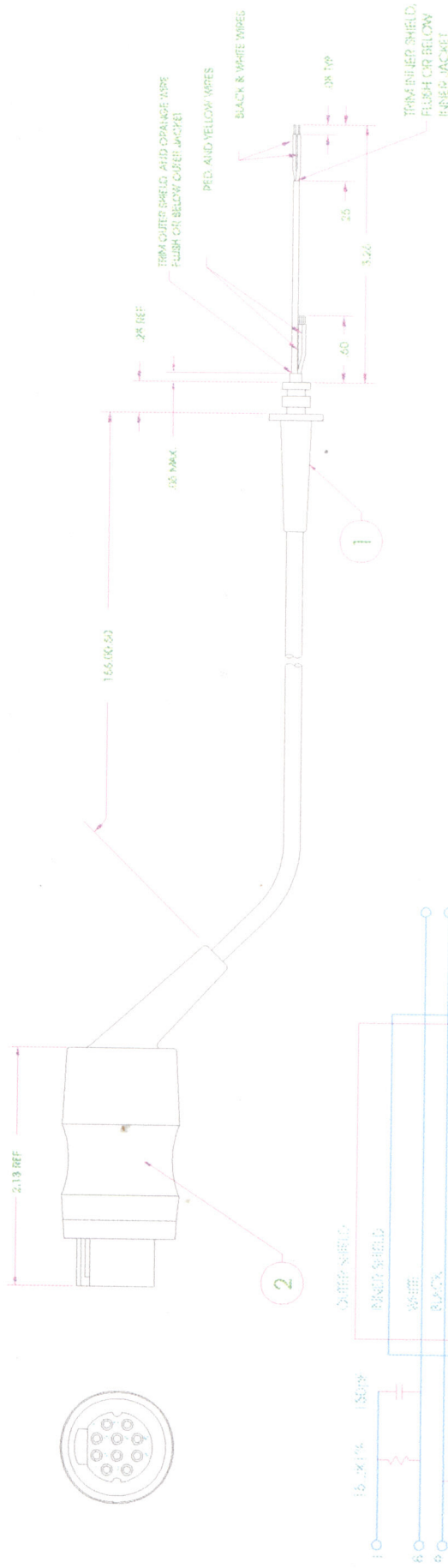
SECTION A-A (SCALE 1=10)

- NO CRACK ALLOWED ON MOLDED PART.
- NO BUBBLE GREATER THAN 7 MIL ALLOWED ON ACTIVE AREA AND GREATER THAN 1.4 MIL OTHER THAN ACTIVE AREA.
- MOLDED PART SHOULD MEET 80/50 SCRATCH/DIG CRITERIA.
- MOLDED PART SHOULD BE FREE OF FLASHES.

NOTES: UNLESS OTHERWISE SPECIFIED.

 13481 DORR AVENUE, COSTA MESA, CA 92626		REV REVISION LETTER	
TITLE DETECTOR ASSEMBLY		DWG NO. DRAWING NUMBER	
SCALE:		SIZE: B	SHEET OF
FINISH		REV REVISION LETTER	
MATERIAL		DWG NO. DRAWING NUMBER	
A. FINISH ALL SURFACES B. MACHINE SURFACES .05 C. BREAK ALL SHARP EDGES .010 MAX D. DIMENSIONS PER ANSI Y14.5 E. DIMENSIONS ARE IN INCHES F. DON'T SCALE DRAWING		SCALE:	
G. TOLERANCES ON DECIMALS XX .XX TOLERANCE XXX .XXX TOLERANCE		SIZE: B	
H. ANGLES XX .XX TOLERANCE XXX .XXX TOLERANCE		SHEET OF	

Form ENG023 (04/93)



SCHEMATIC



CABLE ASSEMBLY

FINISH

MATERIAL

- A. REMOVE ALL BURRS
- B. MACHINE SURFACES AS
- C. BREAK ALL SHARP EDGES 0.030 MAX
- D. DIMENSIONS PER ANSI Y14.5
- E. DIMENSIONS ARE IN INCHES
- F. DO NOT SCALE DRAWING

6. TOLERANCES ON

DECIMALS

XX 2X TOLERANCE

XXX 3X TOLERANCE

ANGLES

XX 2X TOLERANCE

XXX 3X TOLERANCE

ANGLE TOLERANCE

DWG NO.

DRAWING NUMBER

TITLE

REV

REVISION LETTER

SCALE

SIZE

SHEET

OF

DOE FILE NAME

DOE FILE NAME

DOE FILE NAME

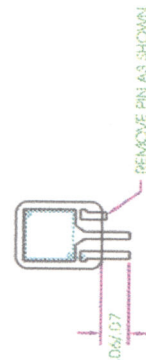
DOE FILE NAME

Form ENG023 (04/93)

Probe P872 RA 03/25/98

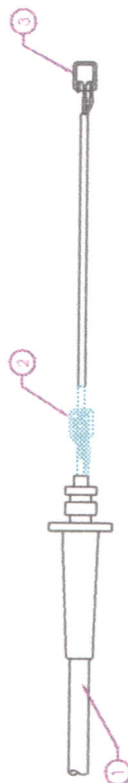
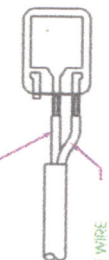
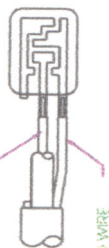
NOTES: UNLESS OTHERWISE SPECIFIED.

DETECTOR

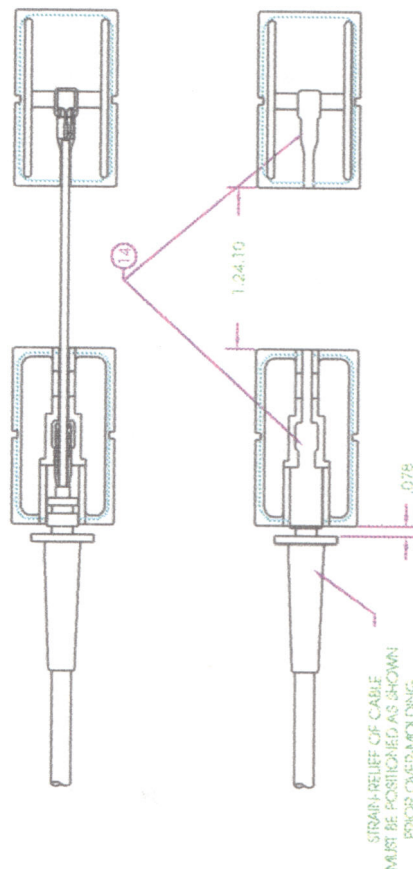
 RED WIRE

RED WIRE

SOLDER WIRE TO BACK SIDE OF PIN (VP)



CERAMIC ASSEMBLY (LED/DET) TO CABLE



STRAIN-RELIEF OF CABLE
MUST BE POSITIONED AS SHOWN
PRIOR OVER-MOLDING

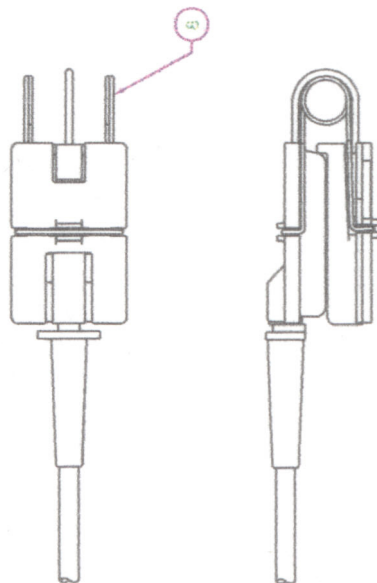
CABLE ASSEMBLY TO POUCH

 3000 LOGAN AVENUE, COVINGTON, MISSISSIPPI 39401		TITLE FINAL ASSEMBLY		REV REVISION LETTER	
FINISH		DWG NO.		DRAWING NUMBER	
MATERIAL		ANGLE TOLERANCE		SHEET OF OF	
A. REMOVE ALL BURRS		G. TOLERANCES ON		SIZE: B	
B. MACHINE SURFACES AS		DECIMALS		SCALE:	
C. BREAK ALL SHARP		XXX		SHEET	
EDGES TO D MAX		2X TOLERANCE		OF	
D. DIMENSIONS HIG AND Y TO 4.5		XXX		OF	
E. DIMENSIONS ARE IN INCHES		3X TOLERANCE		OF	
F. DO NOT SCALE DRAWING				OF	

NOTES: UNLESS OTHERWISE SPECIFIED.

Form: ENG0023, 10/6/03

NOTES: UNLESS OTHERWISE SPECIFIED,



SPRING TO POUCH ASSEMBLY

FRAME TO POUCH/CABLE ASSEMBLY

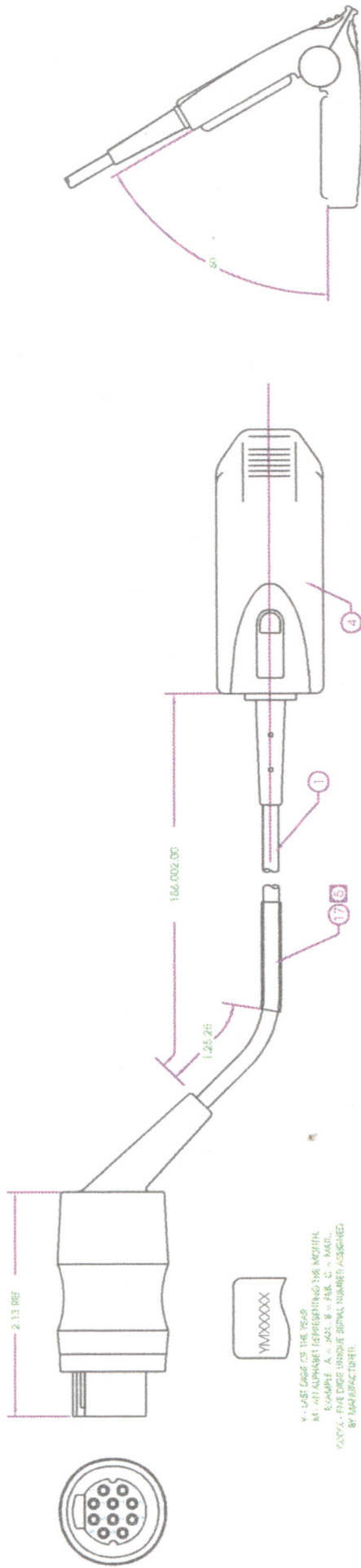
FINISH		 1900 JORDAN AVENUE, CORTI HILLS, CA 94707		TITLE FINAL ASSEMBLY		REV REVISION LETTER	
MATERIAL		G. TOLERANCES ON DECIMALS XX 2X TOLERANCE XXX 3X TOLERANCE		ANGLE TOLERANCE ANGLES ✓		DWG. NO. DRAWING NUMBER	
		A. FINISH ALL SURFS. B. MACHINE SURFACES AS C. BREAK ALL SHARP EDGES TO MAX D. DIMENSIONS PER ANSI Y14.5 E. DIMENSIONS ARE IN INCHES F. DO NOT SCALE DRAWING				SCALE: SIZE: B SHEET SHEET OF OF	

NOTES: UNLESS OTHERWISE SPECIFIED:

NOTES: UNLESS OTHERWISE SPECIFIED.

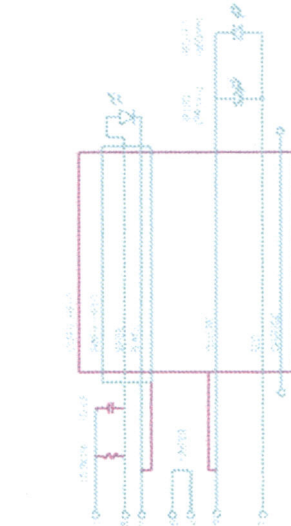
Form ENG023 (04/93)

Probe P872 RA 03/25/98



V - LAST DIGIT OF THE YEAR
M - ALL ALPHABETS REPRESENTING THE MONTH
EXAMPLE: A = JAN, B = FEB, C = MAR, ...
XXXX - FIVE DIGIT UNIQUE SERIAL NUMBER ASSIGNED BY MANUFACTURER

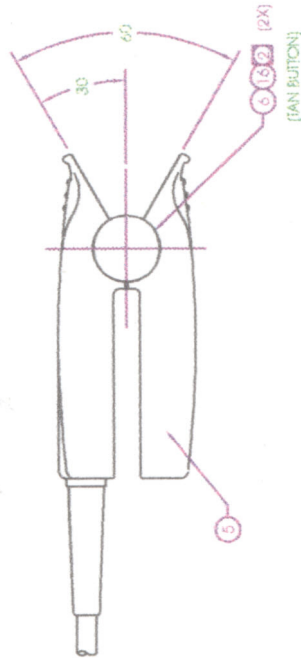
DETAIL A



SCHEMATIC

- 1. PRIOR SERIAL NUMBER AND DATE CODE ON LABEL
- 2. SEE DETAIL A
- 3. PRIOR APPLYING CURSED DEFLASH AND CLEAN BOTH WINDOWS FOR BETTER BONDING.
- 4. PRIOR TO APPLYING SILICONE EPOXY (ITEM 11) TO TOP/BOTTOM FRAMES, TREAT BONDING AREA OF TOP/BOTTOM FRAME WITH PRIMER (ITEM 12).
- 5. NO EPOXY (ITEM 10) ALLOWED ON SURFACE OF PROBE. DO NOT APPLY EXCESSIVE EPOXY.

NOTES: UNLESS OTHERWISE SPECIFIED.



30 VERTICAL MOVEMENT



FINAL ASSEMBLY

FINISH		 TECHNOLOGY. INTEGRITY. COST-EFFECTIVENESS. OUR PROMISE.				REVISION LETTER	
MATERIAL		TITLE		FINAL ASSEMBLY		REV	
✓ A. REMOVE ALL BURRS B. MACHINE SURFACES AS C. BREAK ALL SHARP EDGES 0.10 MAX D. DIMENSIONS PER ANSI Y14.5 E. DIMENSIONS ARE IN INCHES F. DO NOT SCALE DRAWING		G. TOLERANCES ON		DWG NO.		DRAWING NUMBER	
		DECIMALS		ANGLE TOLERANCE		SIZE: B	
		XX 2X TOLERANCE		ANGLE		SCALE:	
		XXX 3X TOLERANCE				SHEET	
						OF	

DO NOT SCALE DRAWING

Form ENG023 (04/93)