

W1995/1

WESLEY COE (CAMBRIDGE) LIMITED

SCOTLAND ROAD, CAMBRIDGE

MAT'L SPEC.	THIRD ANGLE PROJECTION	ITEM NO.	MATERIAL	PART NO.	NO OFF
	DIMENSIONS IN M/M'S INCHES IN BRACKETS	1	EN2A	F5617/1	1
PART NO. D5617 183, 3	JIGGING ATTITUDE AS DRAWN	2	48% NiFe	902227	1
		3	NE3	M4206/4	1

PIN DIA. 1.02 ± 0.03
(0.040 ± 0.001)
FERRULE MUST NOT BE DAMAGED.
CONCENTRIC TO WITHIN 0.25 (0.010)

GLASS MUST NOT EXTEND BEYOND FERRULE.
JIGGING LENGTH 3.30 ± 0.13
(0.130 ± 0.005)
0.51 REF (0.020)
0.51 (0.020) MAX. RAD.
HOLE DIA. 1.02 ± 0.08
(0.040 ± 0.003)
PIN FLATTENED & PIERCED AFTER SEALING
SECTION ON 2

OP	ALL OPERATIONS TO HAVE FIRST OFF INSPECTION	SURFACE FINISH 1.6/ UNLESS OTHERWISE STATED	BURR FREE - MAX DEBURRING CHAMFER 0.25mm x 45°
1	WITHDRAW & CHECK PIECE PARTS		11 PASS TO METAL PARTS - FLATTEN & PIERCE
2	DECAPS ALL PARTS MF2/13		12 FINAL VIEW QA-1P/8 DIMENSIONAL
3	PRENICKEL ALL PARTS 0002-0003		13 FINAL FINISH HOT TIN DIP MF2/13
4	NICKEL TEST QA-1P/16		14 PLATING CHECK QA-1P/14
5	RETURN TO STORES		15 ELECTRICAL - 10000 MV @ 500 V.D.C. QA-1P/12
6	ISSUE TO SHOP		16 LEAK TEST D/P QA-1P/11
7	CHECK PIECE PARTS		17 FINAL INSPECTION QA-1P/13
8	LOAD JIGS USE TOPS		18
9	KILN LOAD S2/9 86L 940°C 8%		19
10	END OF KILN QA-1P/16		20

ISSUE CHANGES 3 16-6-75 D/01253
 1 8-5-67 D/0108
 2 26-10-67 D/01133

DRAWN 2-11-71
 CHK. AR
 SCALE 1:1
 D5617

SG BRNN 02754