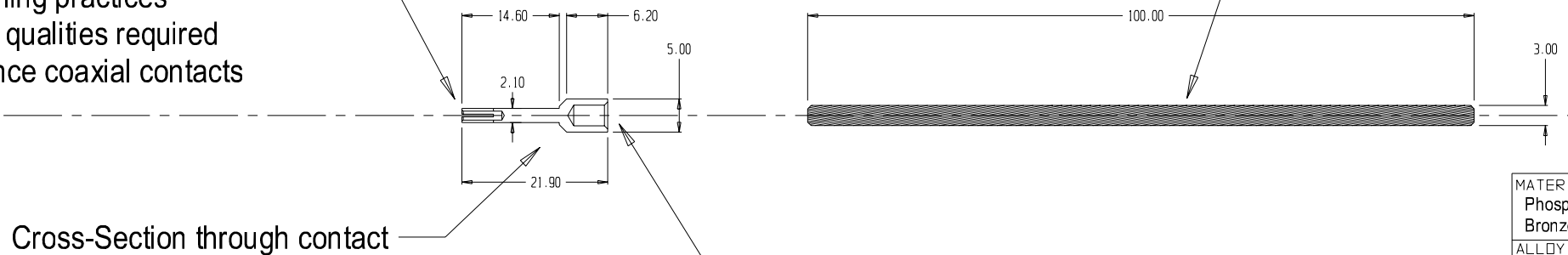


Material Options:
1) Berillium Copper C17500-AT(TF00)
2) Phosphor Bronze
Heat Treatment as appropriate

Electroplating to Mil 17C...:

- 1) Nickel
- 2) Copper
- 3) 5u" Gold (or perhaps Silver if the solder is a silver alloy)

- Stainless Wire Rope
(see Special Notes)



- Drill 3.10mm Diameter $+0.10 - 0.00\text{mm}$ with 0.5mm chamfer for 7x7 Stainless Grade 316 wire rope 3mm nominal dia (future design may use 2mm SS316 Wire Rope instead of the 3mm shown here)

- 1) 3mm Stainless Wire Rope (nominally 100mm long) is to be Soldered into the 3.1mm cavity so as to achieve a tidy concave meniscus/fillet with the 5mm outer body on the TNC contact.
- 2) Surplus Solder must NOT flow over the contact and effect the cylindrical shape of the 5mm OD.
- 3) Flux residues, if any, MUST be cleaned off with an appropriate solvent.
- 4) Soldering temperatures must NOT effect the tensile properties of the TNC contact fingers or the plating of the whole external surface of the contact.

MATERIAL	Phosphor Bronze
ALLOY	PB-xxxx
EST. AREA	xxx mm
EST. WEIGHT	xxx kg/m
EST. PERIPHERY	
EXT: xxx	mm
TOT: xxx	mm
TOLERANCE	
0.00mm ±0.1mm	
00.00mm ±0.25mm	
0000mm ±0.5mm	
0-600mm ±0.1mm	
> 600mm ±0.5mm	
BS1474:1987	
APPLIES UNLESS OTHERWISE SPECIFIED	
JOB No.	
30xx	

<div>CASA</div> <div>Modular Systems</div>	CUSTOMER : PERRY Engineering				SIZE	DRAWING Reference No.	ISSUE		
	DESCRIPTION : Custom TNC Female Contact				A4	CONT-TNC	A		
P.O. BOX 38-828, WELLINGTON, NEW ZEALAND					DRAWN : AWD	DATE : 30/06/98	APPROVED : ?	DWG. SCALE : 1:1	© COPYRIGHT : CASA Modular Systems ALL RIGHTS RESERVED
TELEPHONE : (64-4) 5687 277 FACSIMILE : (64-4) 5685 161									