

## Building a socket

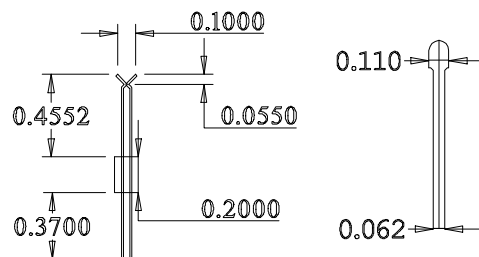
### Tools Required :

1/8" blade screwdriver  
 15 minute epoxy  
 drill press  
 drill bits : #29 .136 dia,  
 #26 .147" dia, #24 .152 dia,  
 #22 .157 dia

8-32 tap

### Instructions :

1. Measure transformer lead diameter.
2. Measure transformer lead spacing.
3. Place or tape guide template to fixture block.
4. Use felt marker to mark holes.  
 ( hole to hole on guide = .100",  
 diagonal = .150" )
5. Place on drill press. drill .136 dia completely through block.
6. Enlarge top of holes for lead clearance.  
 ( See Drawing ) drill no deeper than 0.375".
7. Tap rear holes 3 turns 8-32 to hold epoxy.
8. Flip socket over insert pin, and align.
9. Press in pin to desired depth using pressure on plastic barrel of pin.  
**NEVER USE FORCE ON THE GOLD CONTACT !**  
 NOTE : a 3/32 flat blade screwdriver works good for this.
10. Spread leads and fill hole with epoxy.

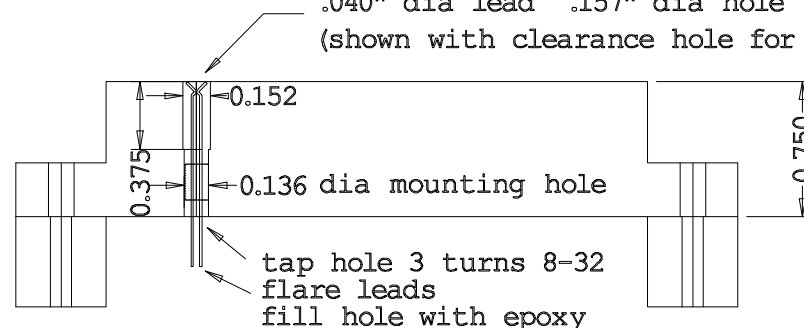


Ø0.132  
 Barrel cross section

lead entry clearance diameter

.025" dia lead .136" dia hole  
 .030" dia lead .147" dia hole  
 .035" dia lead .152" dia hole  
 .040" dia lead .157" dia hole

(shown with clearance hole for .035" lead)



Wilco K150 .150 kelvin pin  
 typical block thickness 0.75"

Warning !!! NEVER BEND OR FORCE PIN  
 Pin is meant to be epoxied in place.  
 When removing pin grasp both leads firmly with pliers.

Press in place by using light force on rear of plastic barrel, never on surface contact of pin.

Minimum pin to pin spacing .150"

Wilco Control Service  
 .150" kelvin pin  
 Date 1/30/98