

Building a socket

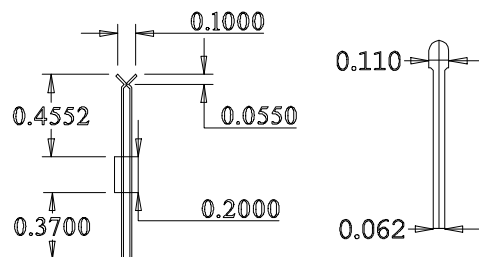
Tools Required :

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

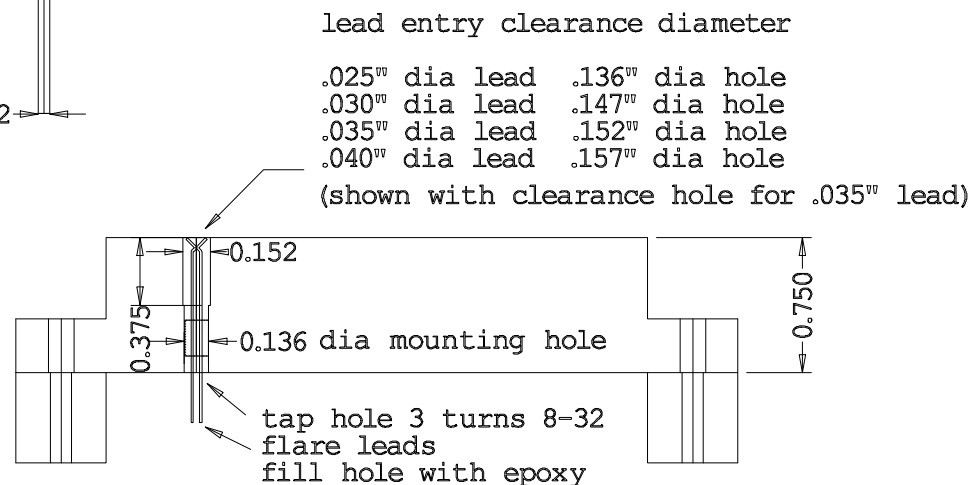
8-32 tap

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