

1. SCOPE

1.1. Content

This specification establishes the procedure to measure the assembly dimension of the center contact of the Cable Plug for the Switching Coax Connectors.

1.2. Purpose

The purpose of this procedure is to guarantee the same measurement method at the different Tyco facilities and outside vendors.

2. APPLICABLE DOCUMENTS

The following documents constitute a part of this specification to the extent specified herein. Unless otherwise specified, the latest revision of the document applies.

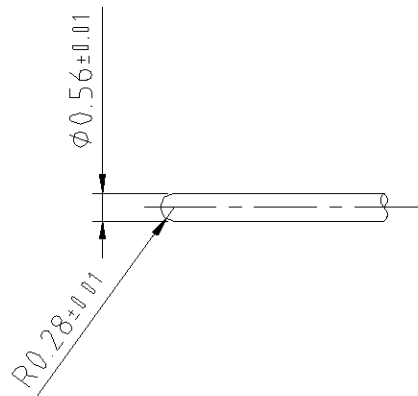
2.1. Part Number List

PN 619028-x	PN 619068-x
PN 619039-x	PN 619077-x
PN 619041-x	PN 619078-x
PN 619049-x	PN 619052-x

3. PROCEDURE

3.1. Measurement tool: components

3.1.1. Micrometer touch



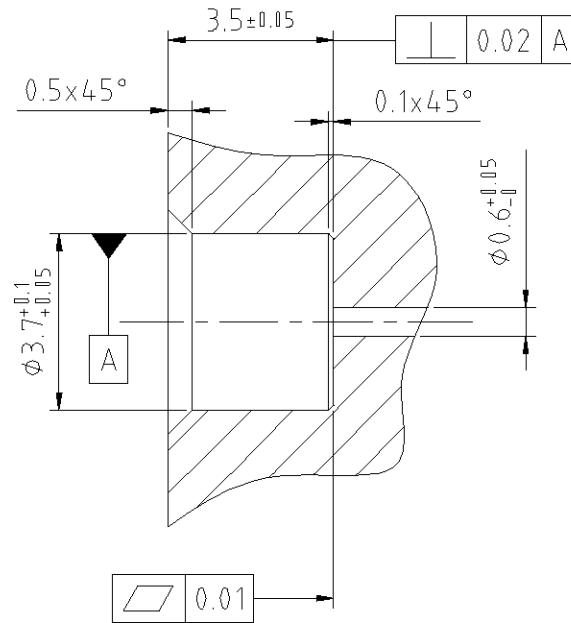
DR : O. Gend're

DATE : 12-March-01

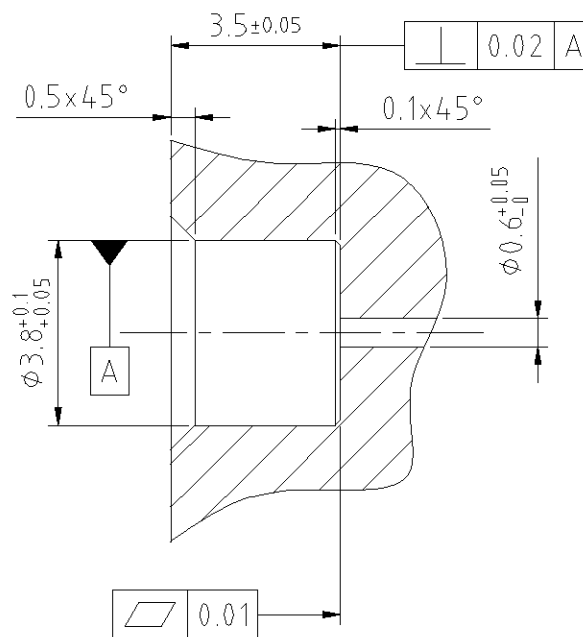
APVD : B. Rithener

DATE : 19-June-01

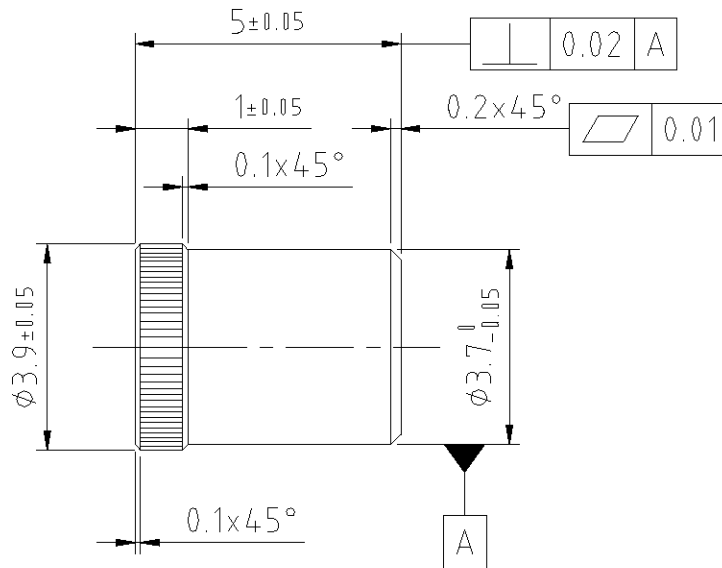
3.1.2. Housing for cable plug (619028, 619039, 619041, 619049, 619052, 619068, 619077)



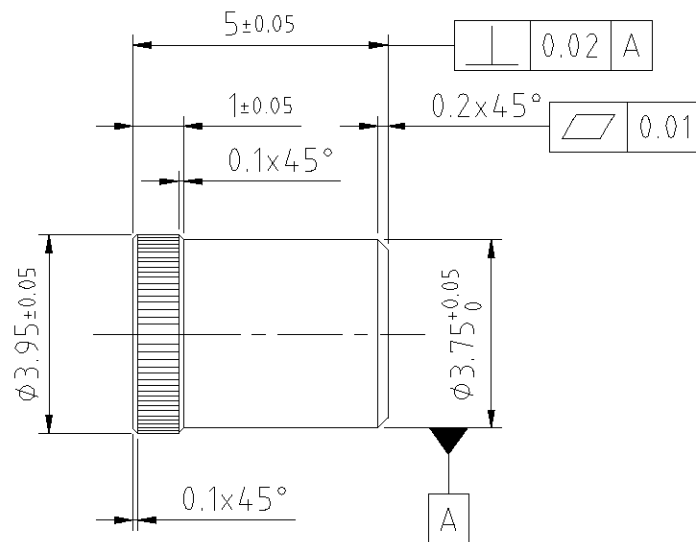
3.1.3. Housing for cable plug (619078)



3.1.4. Zero gauge (619028, 619039, 619041, 619049, 619052, 619068, 619077)

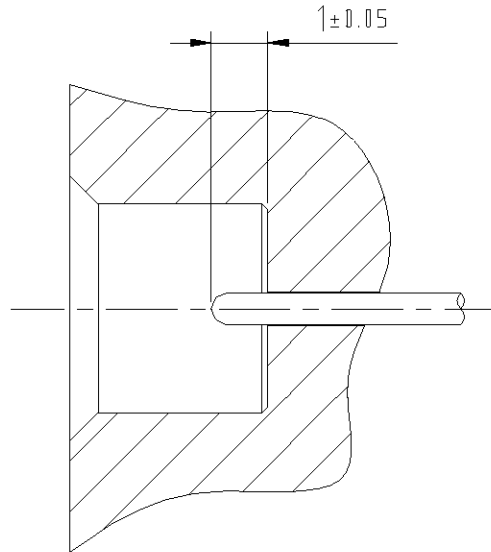


3.1.5. Zero gauge (619078)



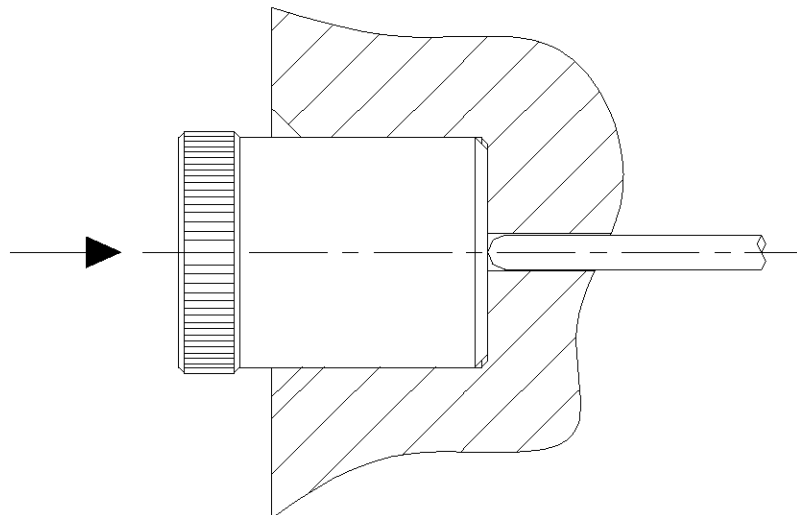
**3.2. Position of the touch**

To ensure a good measurement, mount the touch with a distance of  $1 \pm 0.05$ mm minimum from bottom of housing (as shown below).



**3.3. Initialisation of the tool**

- Insert "zero gauge" into housing.
- Push on gauge to ensure an optimal contact with bottom of housing.



- Press "reset" button of micrometer.
- Remove the gauge and begin with measurement.