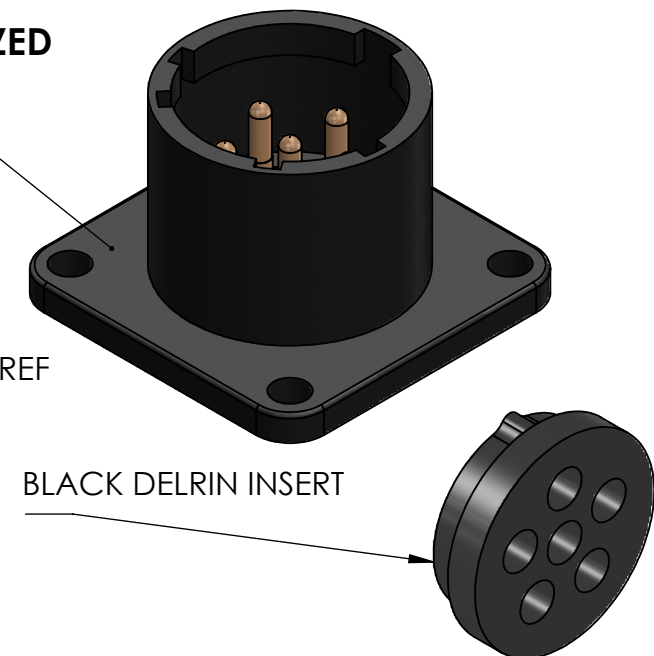


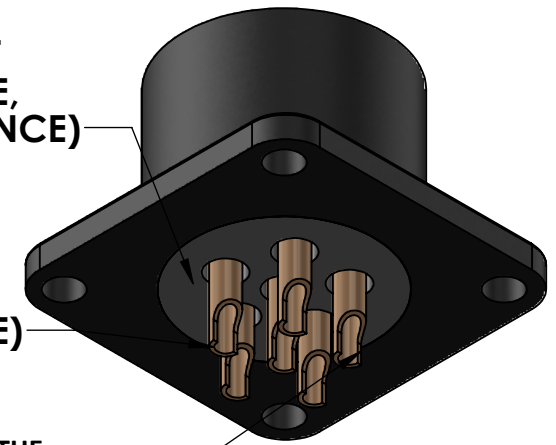
REVISIONS			
REV	DESCRIPTION	DATE	ENG
G	ADDED SHEET 2, ADHESION PROMOTER AND CYANOACRYLATE INSTRUCTIONS	11/19/2021	CWA

BLACK ANODIZED FINISH



**APPLY HEPTANE PRIMER AND CYANOACRYLATE PRIOR TO PRESS FIT
SEE SHEET 2 FOR DETAILS**

**PRESS FIT DELRIN INSERT
(FLUSH TO OUTSIDE EDGE,
0.0015" ± 0.0005" INTERFERENCE)**



**PRESSED IN PINS
(0.0015" ± 0.0005" INTERFERENCE)**

**OPEN SIDE OF THE SOLDER CUP
SHOULD FACE OUTWARD FROM THE
CENTER AND BE PARALLEL TO THE
DELRIN KEY.**

UNLESS OTHERWISE SPECIFIED:
 DIMENSIONS ARE IN: INCHES
 TOLERANCES: .XX: ± 0.03
 .XXX: ± 0.005
 ANGULAR: .X*: 1°
 .XX*: 0.5°
 BREAK EDGES: .005 - .020
 FILLETS: .005 - .020
 SURFACE FINISH:
 GEOMETRIC TOLERANCING
 PER: ASME Y14.5-2009
 MATERIAL: SEE DRAWING NOTES
 FINISH: SEE DRAWING NOTES
 DO NOT SCALE DRAWING

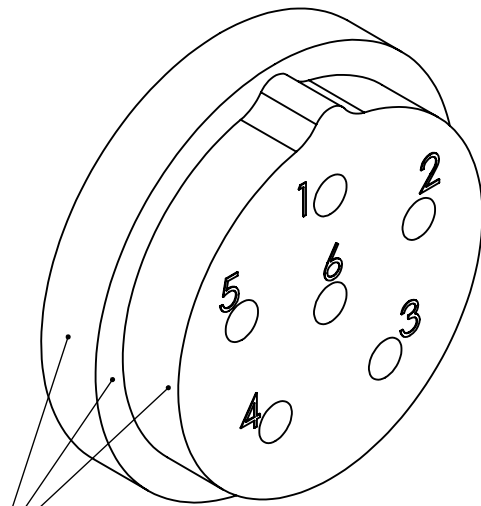
	NAME	DATE
DRAWN	TC	03/16/15
CHECKED	RJB	03/16/15
COMMENTS:		

PROPRIETARY AND CONFIDENTIAL
 THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF SUPPLYNET, INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF SUPPLYNET INC. IS PROHIBITED.

CAGE CODE: 1HJX9

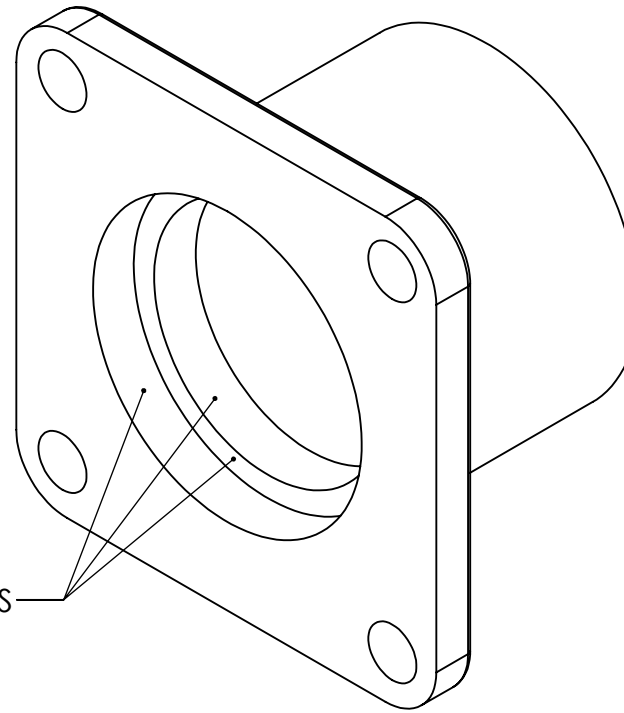
REF. NUMBER: SN0439	
TITLE: BA5590 PANEL MOUNT W/ SOLDER CUPS ALUMINIUM	
SIZE B	DWG. NO. CONN-BA5590-MP-SSC
REV G	
SCALE: NA	WEIGHT:
SHEET 1 OF 2	

DELRIN INSERT



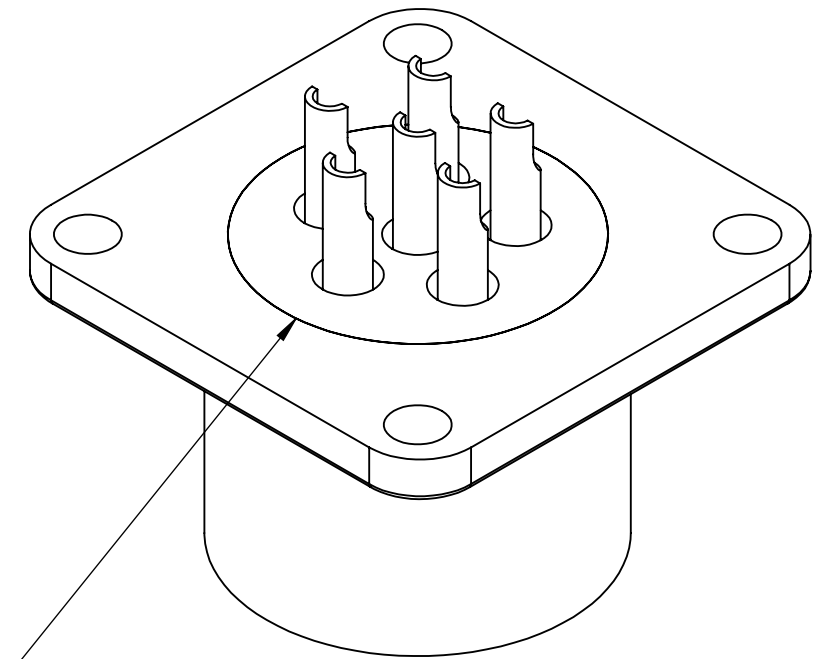
APPLY LOCTITE SF 770 TO THESE SURFACES

ALUMINUM BODY



APPLY LOCTITE 406 TO THESE SURFACES

CONN-BA5590-MP-SSC ASSEMBLY



AFTER PRESS FIT APPLY LOCTITE 406 TO EDGE WHERE DELRIN AND ALUMINUM MEET.

INSTRUCTIONS FOR APPLYING ADHESIVE DURING PRESS FIT

1. APPLY LOCTITE SF 770 PRIMER TO DELRIN INSERT WHERE SHOWN.
2. ALLOW TO DRY 60 SECONDS.
3. APPLY LOCTITE 406 CYANOACRYLATE TO ALUMINUM BODY.
4. PRESS FIT DELRIN INSERT INTO ALUMINUM BODY.
5. APPLY THIN BEAD OF LOCTITE 406 AROUND EDGE WHERE DELRIN INSERT AND ALUMINUM BODY MEET.
6. ALLOW 12-24 HRS FOR ADHESIVE TO FULLY CURE BEFORE TESTING.
7. IF EXCESS LOCTITE 406 IS SEEN AROUND FRONT FACE OF DELRIN INSERT, A SMALL AMOUNT OF ACETONE ON A COTTON SWAB CAN BE USED TO AID IN CLEANING IT OFF THE SURFACE.

NOTES:
1. SEE LOCTITE SF 770 PRIMER, AND LOCTITE 406 SDS SHEETS FOR GUIDANCE ON PROPER HANDLING OF MATERIALS.

UNLESS OTHERWISE SPECIFIED:		NAME	DATE	REF. NUMBER: SN0439		
DIMENSIONS ARE IN: INCHES		DRAWN	TC	3/15/16		
TOLERANCES: .XX: ± 0.03		CHECKED	TC	3/15/16		
.XXX: ± 0.005		COMMENTS:		TITLE: BA5590 PANEL MOUNT W/ SOLDER CUPS ALUMINUM		
ANGULAR: .X°: 1°		<p>PROPRIETARY AND CONFIDENTIAL</p> <p>THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF SUPPLYNET, INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF SUPPLYNET INC. IS PROHIBITED.</p>		SIZE DWG. NO. REV		
.XX°: 0.5°				B CONN-BA5590-MP-SSC G		
BREAK EDGES: .005 - .020				SCALE: NA	WEIGHT:	SHEET 2 OF 2
FILLET: .005 - .020						
SURFACE FINISH:		CAGE CODE: 1HJX9				
GEOMETRIC TOLERANCING PER: ASME Y14.5 -2009						
MATERIAL: SEE DRAWING NOTES						
FINISH: SEE DRAWING NOTES						
DO NOT SCALE DRAWING						