

**Receptacle Adapter Ultrasonic and One-Piece Die Cast
Assembly Operations**

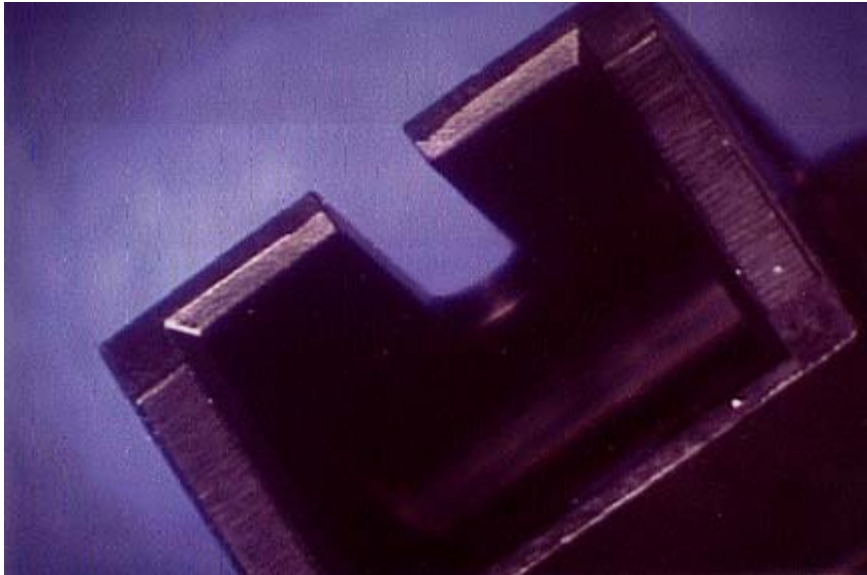
1. SCOPE

This specification covers the acceptable requirements and the not acceptable conditions for the Receptacle Adapter Ultrasonic and One-Piece Die Cast Assembly Operations.

2. INSPECTION CRITERIA

Unless otherwise specified, figures are shown at approximately 10X magnification. The Ultrasonic Assembly and the Die Cast Assembly will be inspected without magnification.

NOTE *Even though the pictorials shown in this document are of the SC product family, they are representative of all types of receptacle adapters.*



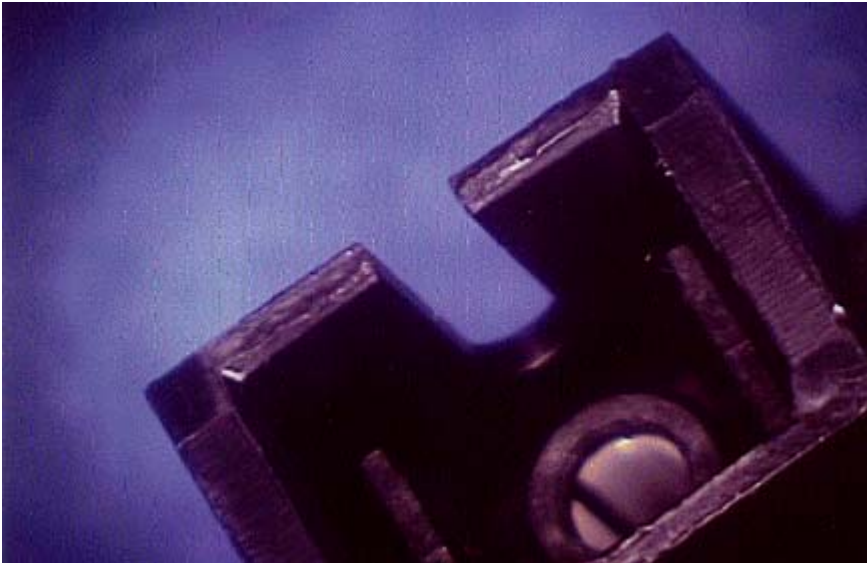
ACCEPTABLE

Tool Marks

Figure 1

NOTE

If less than 50% of the lead in chamfer has been damaged due to tool marks, the part is considered ACCEPTABLE.



NOT ACCEPTABLE

Tool Marks

Figure 2

NOTE

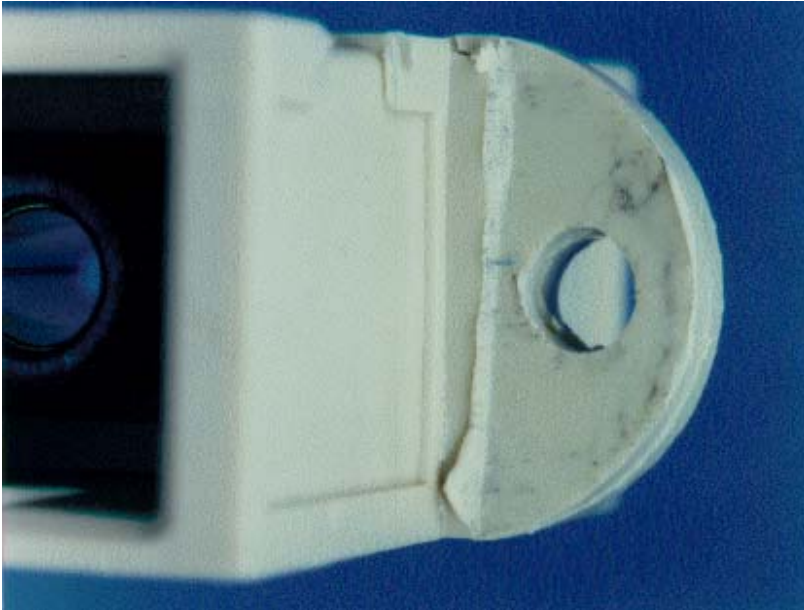
If 50% or more of the lead in chamfer has been damaged due to tool marks, the part is considered NOT ACCEPTABLE



ACCEPTABLE

Tool Marks on Flange

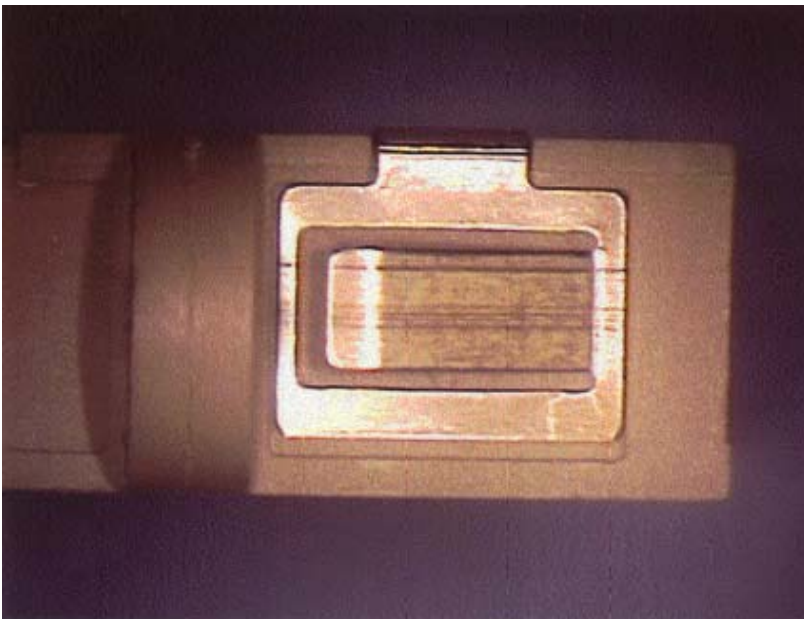
Figure 3



NOT ACCEPTABLE

Tool Marks on Flange

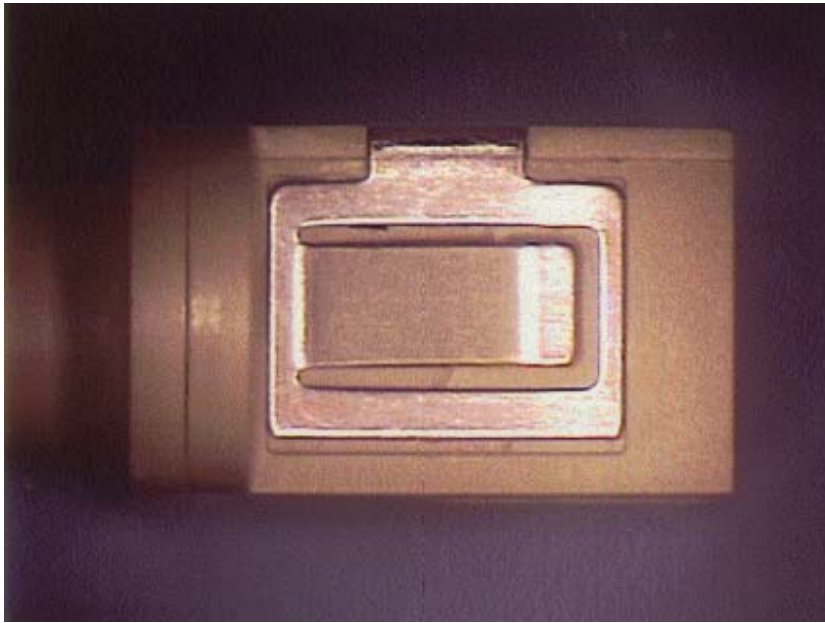
Figure 4



ACCEPTABLE

Position of Ears on
Retention Clip

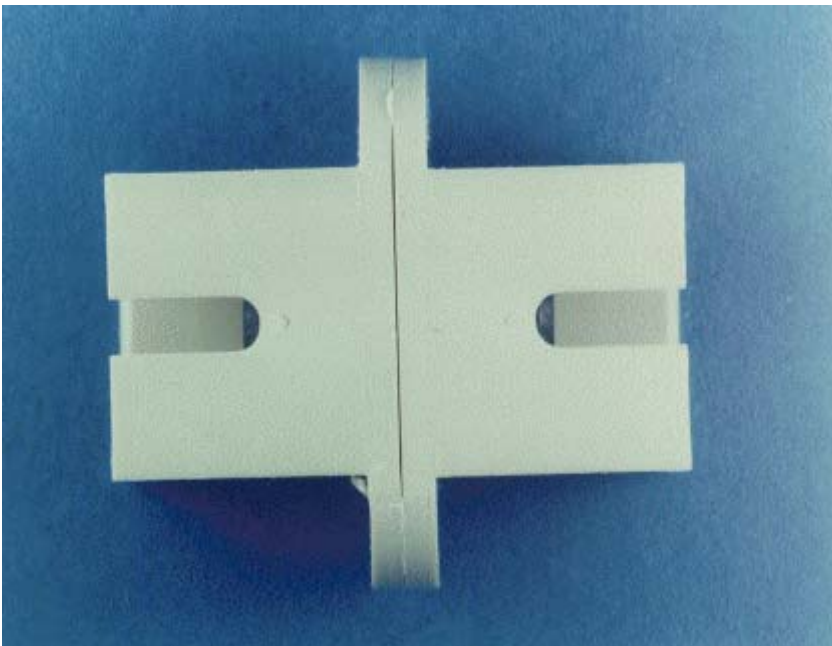
Figure 5



NOT ACCEPTABLE

Position of Ears on
Retention Clip

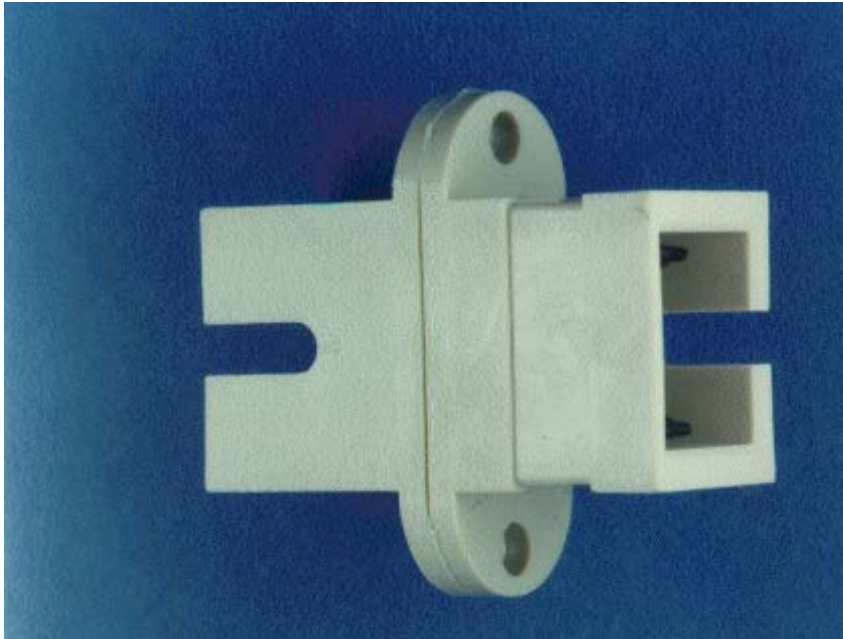
Figure 6



ACCEPTABLE

Direction of Keyway
(Both in Same Direction)

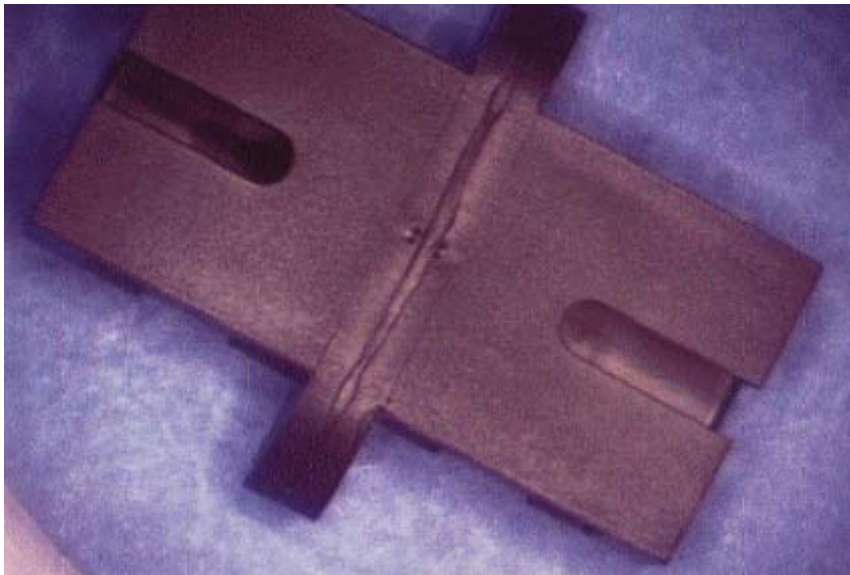
Figure 7



NOT ACCEPTABLE

Direction of Keyway
(One in the Front,
One in the Back)

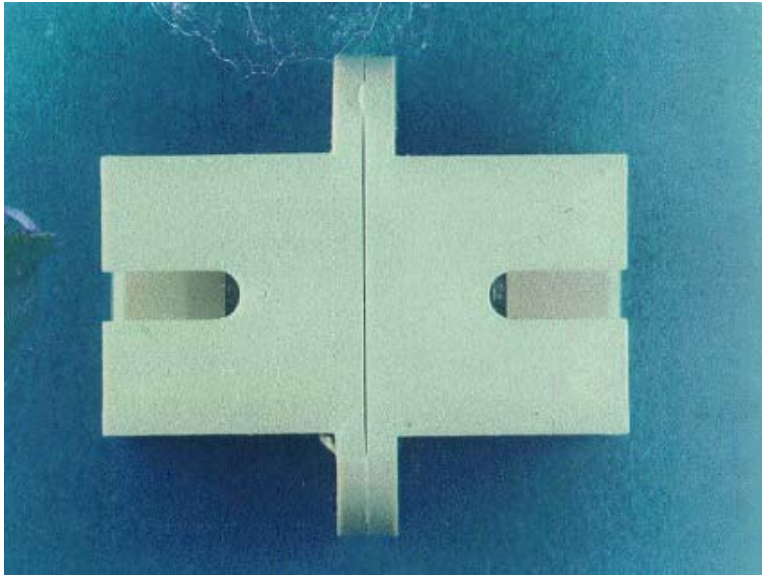
Figure 8



NOT ACCEPTABLE

Flash

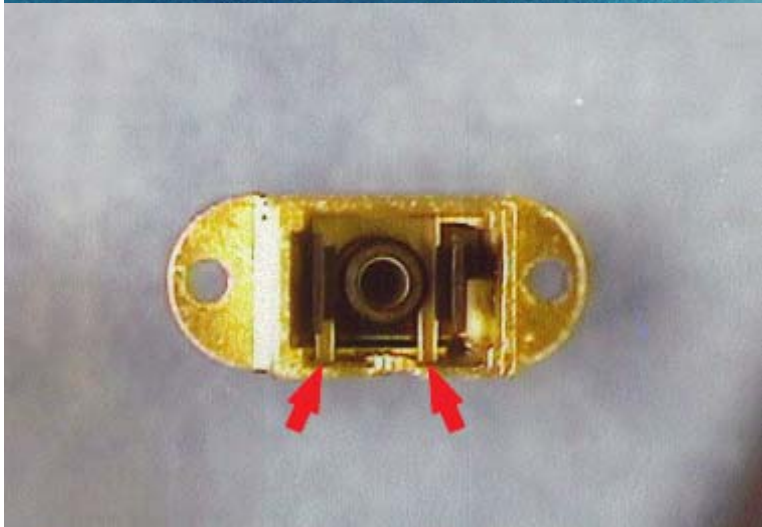
Figure 9



NOT ACCEPTABLE

Allowable Gap
(Up to 0.010 inch
Gap is Allowed)

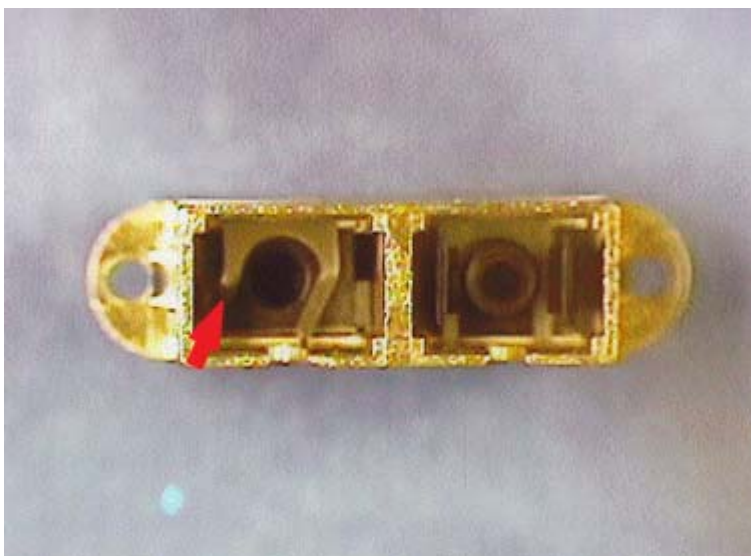
Figure 10



ACCEPTABLE

Correct Retaining Fork Placement
(Viewed from the
SC Side of Adapter)

Figure 11



NOT ACCEPTABLE

Damaged Retaining Fork Placement
(Viewed from the
SC Side of Adapter)

Figure 12

NOTE

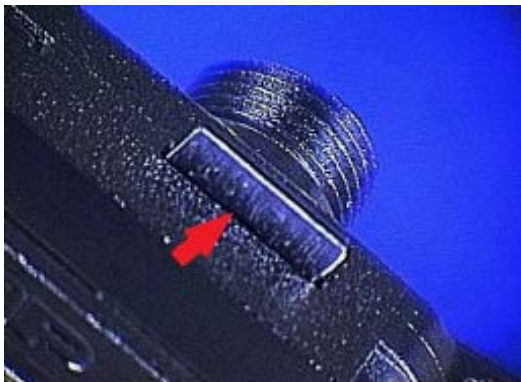
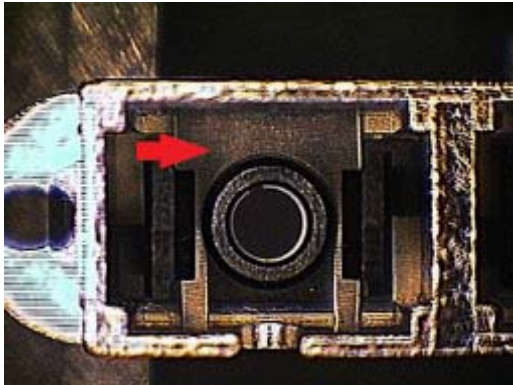
The acceptable and not acceptable conditions in Figures 11 and 12 apply to both Simplex and Duplex Adapters.



ACCEPTABLE

Fully Seated Retaining Fork

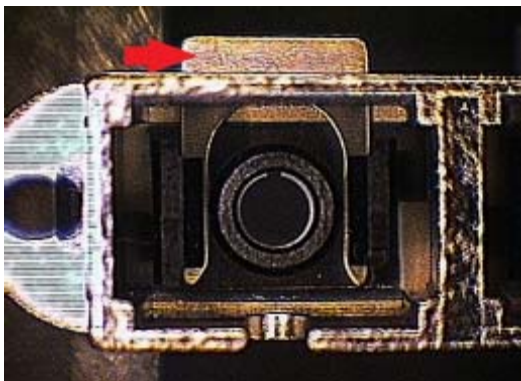
Figure 13



NOT ACCEPTABLE

Unseated Retaining Fork

Figure 14



NOTE

The acceptable and not acceptable conditions in Figures 13 and 14 apply to both Simplex and Duplex Adapters.