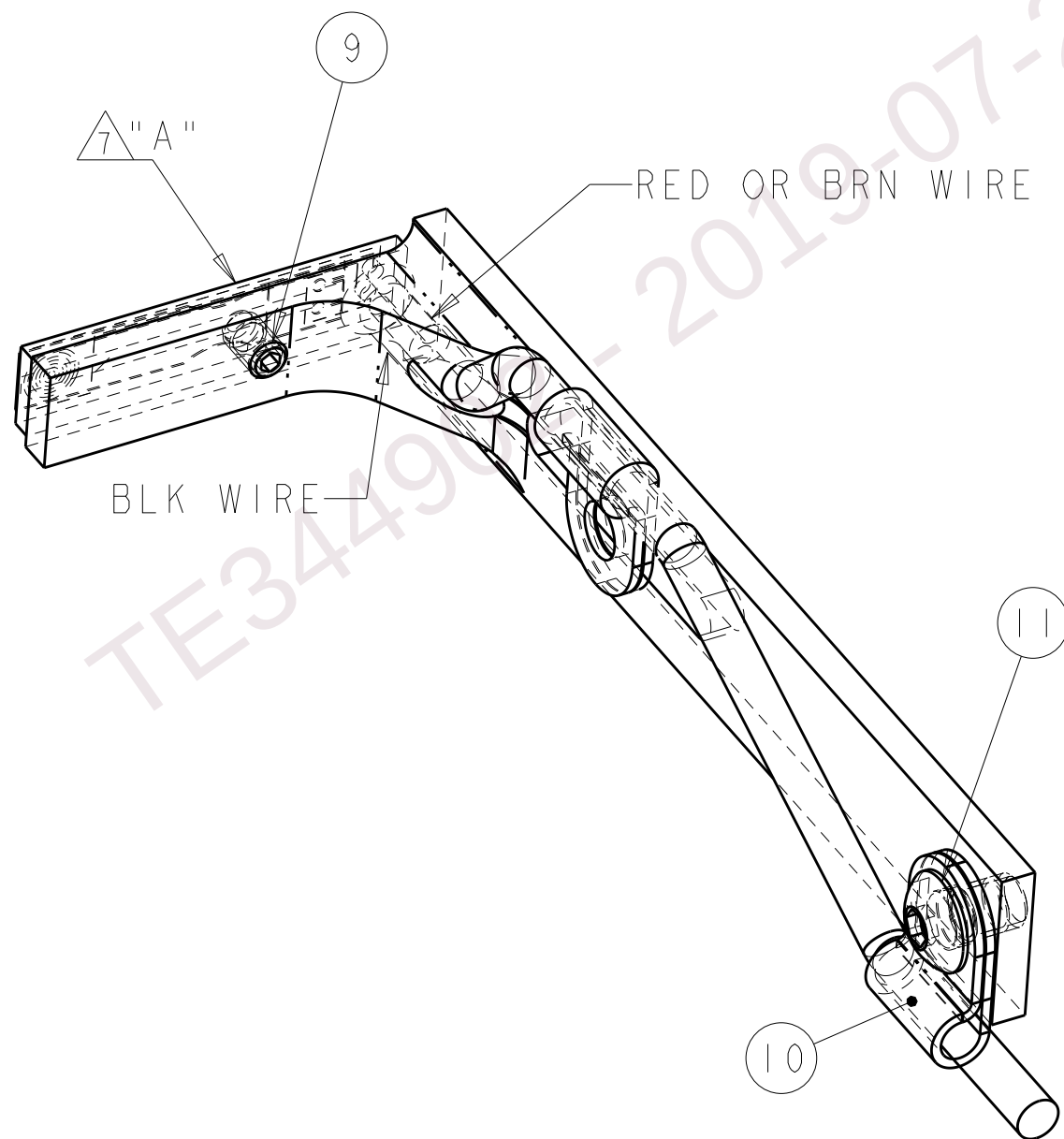
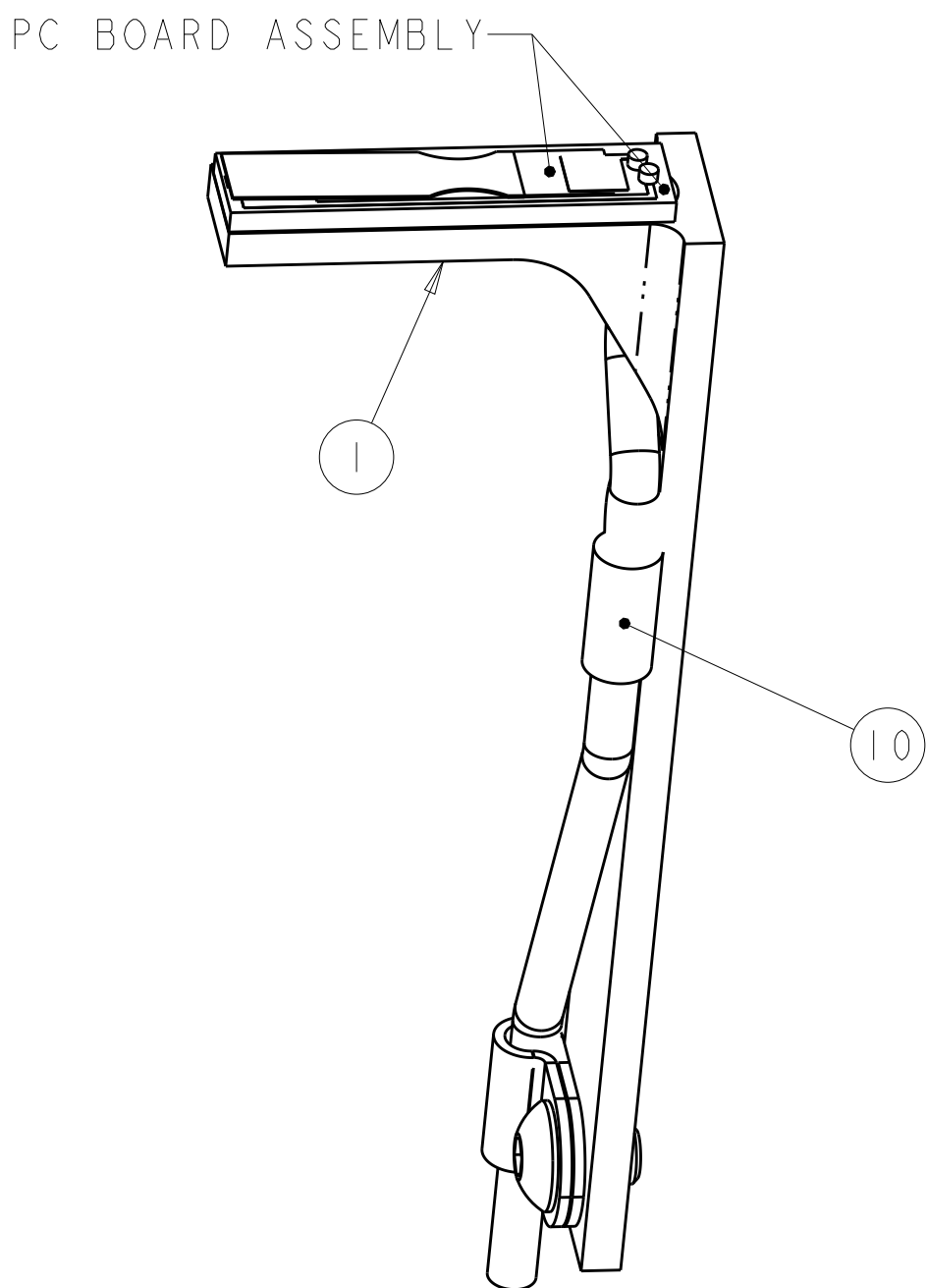
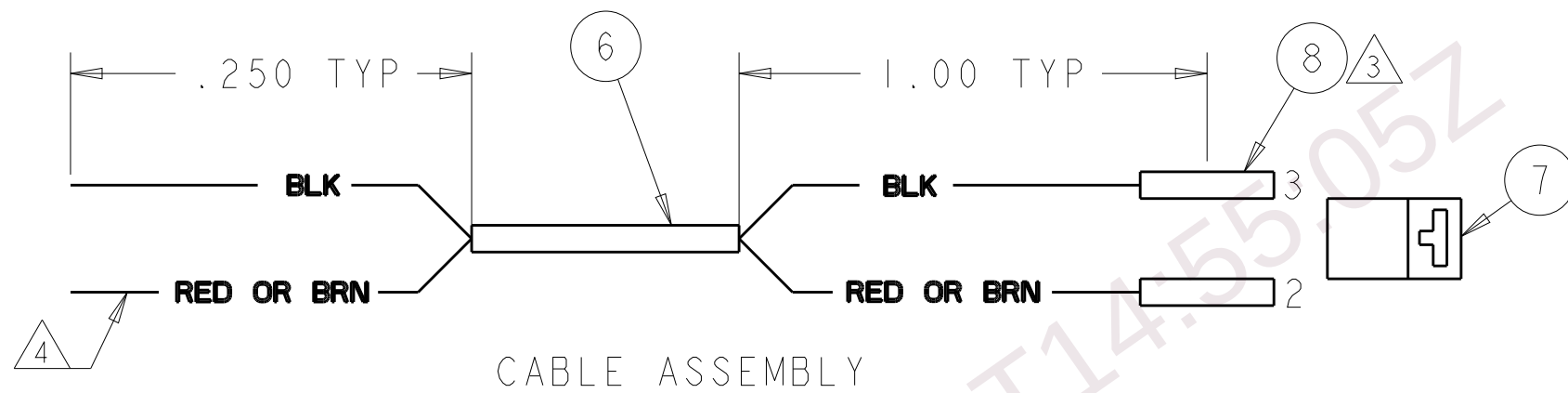
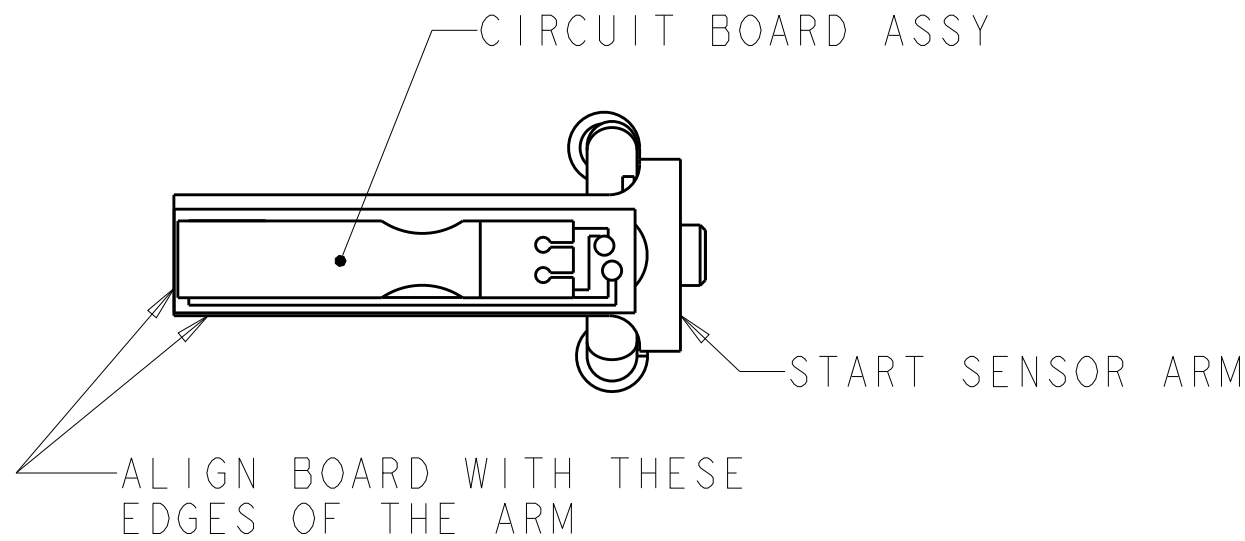
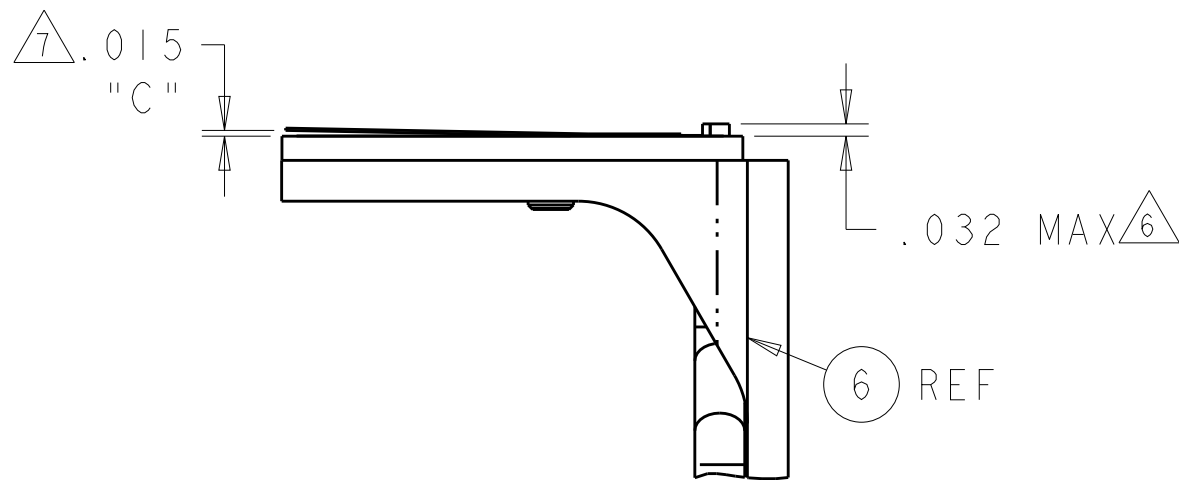
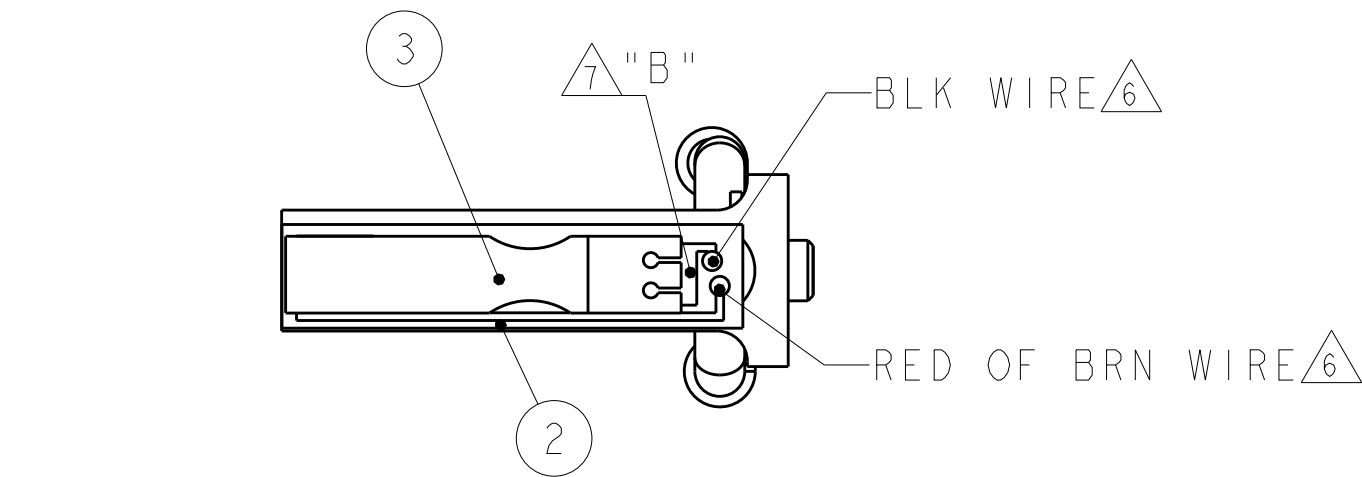


PART NUMBER	REV	FIRST USED	LEVER MATERIAL	PAD MATERIAL	LEVER ATTACHMENT METHOD
1424647-1	G	1490502-1	702518-1 CV ALLOY	GOLD	SOLDER

USED ON
STRIPPING MODULE

DWG NO
1424647

THIS DRAWING IS A CONTROLLED DOCUMENT



1. IDENTIFY PART PER TEC-115-67-6 OR -11.
2. FABRICATE CABLE ASSY PER GATD QUALITY DOCUMENT ASG-3122.
3. STRIP BACK INSULATION .125 TO .156 FOR TERMINATION.
4. STRIP BACK INSULATION .125 FOR TERMINATION.
5. GENERAL CABLE PREFERRED MANUFACTURER.
6. SOLDER WIRES PER AMP SPEC 106-502 PARA 4.1A: 4.2A,B: 5.5: 5.8G: AND 5.10. WIRES ARE NOT TO EXTEND MORE THAN .032 ABOVE BOARD.
7. ASSEMBLY PROCEDURE:
REMOVE DIRT AND OIL FROM ALL MATING SURFACES PRIOR TO ASSEMBLY.

A) TEMPORARILY INSTALL THE SET SCREW, ITEM 10, INTO THE SENSOR ARM, ITEM 1, TO INSURE CORRECT ALIGNMENT PRIOR TO ASSEMBLING THE PCB, ITEM 2, TO THE SENSOR ARM, ITEM 1, USE 5 DOTS OR ONE DOT AND A LINE OF ADHESIVE, ITEM 4, TO ASSEMBLE THE PCB, ITEM 2, TO THE SENSOR ARM, ITEM 1, FOR A MINIMUM OF 30 MINUTES TO ALLOW THE ADHESIVE TO CURE. BE SURE TO FOLLOW ALL ADHESIVE MANUFACTURER'S RECOMMENDATIONS.

B) TIN THE PCB PAD. ALIGN RIGHT EDGE OF SWITCH LEVER, ITEM 3, TO RIGHT SIDE OF PCB MOUNTING PAD AND THE BOTTOM EDGE OF THE LEVER TO THE UPPER SIDE OF THE TRACE AT THE BOTTOM OF THE PCB, ITEM 2, CLAMP THE LEVER IN PLACE AND SOLDER PCB USING SOLDER.

C) REMOVE SET SCREW, ITEM 10, AND APPLY THREADLOCK, ITEM 5. REINSTALL AND ADJUST SWITCH LEVEL HEIGHT AS NECESSARY.

D) VERIFY PROPER SWITCH FUNCTION WITH CONTINUITY CHECK.

E) APPLY SMALL RUBBER BAND OR PLASTIC CAP OVER THE END OF THE SWITCH ASSEMBLY TO PREVENT DAMAGE TO LEVER DUE TO CARELESS HANDLING. PLACE ASSEMBLY IN AN APPROPRIATE SIZED PLASTIC ZIPPER BAG.
8. THE 3 CONDUCTOR 26 AWG JACKETED CABLE DISCARDED DURING PROXIMITY SWITCH ASSY (PN 1424440-3), MAY BE SUBSTITUTED FOR THIS CABLE. CUT OFF UNUSED BLUE WIRE FLUSH WITH JACKET ON BOTH ENDS.
9. LOCTITE 499 ADHESIVE MAY BE USED IN PLACE OF THREEBOND 1737, ITEM 4.

589	1	-	4-18024-4	SCR, BTN SKT HD CAP (M4 X 6.0)	11
	2	-	986220-1	CLAMP, CABLE, BLACK	10
	1	-	18032-1	SCR, SET, FLT PNT, M3 X 5.0	9
	2	-	104505-5	PIN, MTE	8
	1	-	103653-2	HOUSING, MTE, 3 POSN	7
	18.00	IN	1320487-1	CABLE, 24 AWG, 2 CNDTC	6
	AR	-	LOCTITE 242	THREAD LOCKER	5
	AR	-	THREEBOND 1737	ADHESIVE, INSTANT	4
	1	-	1490795-1	LEVER, SWITCH	3
	1	-	1490765-1	PCB	2
	1	-	1901582-1	ARM, START SENSOR	1
	- 1	U/M	PART NO	DESCRIPTION	ITEM NO

G	ECR-19-010213	01JUL2019	JS	JS
F	ECR-19-009350	13JUN2019	AW	DP
LTR	REVISION RECORD	DATE	DWN	APVD

FINISH	-	DWN	25SEP2007	MATERIAL	-	HEAT TREAT	-
DIMENSIONS:	IN	CHK	25SEP2007				
		APVD	25SEP2007				
NAME	START SENSOR ASSEMBLY						
SCALE	2:1	SIZE	A2	DRAWING NO	1424647	SHEET	1 OF 1
						REV	G

