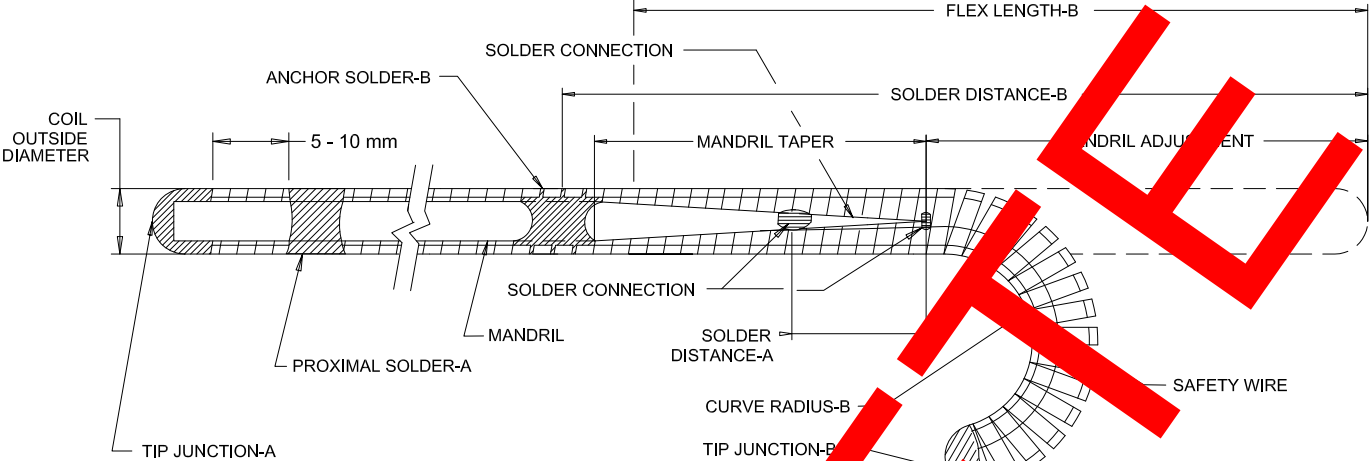


COOK INCORPORATED

MANUFACTURING INSTRUCTIONS - CONFIDENTIAL

COMPLEX GUIDES MI_59



INSTRUCTION

- WHEN SOLDERING USE TORCH TIP 2 OR 3 AND REFER TO QSI04_12 SECTION 3 FOR PROPER SOLDERING METHOD.
- IF TORCH TIP 3 IS USED, ENSURE TORCH IS AT LOWEST SET OR SETTING POSSIBLE AND QSI04_12 IS FOLLOWED TO PREVENT ANCHORING OR DAMAGE TO THE WIRE GUIDE.

1. CUT COIL TO SPECIFIED LENGTH.
2. RELAX B-END OF COIL AS SPECIFIED AND MARK GUIDE WITH A BLACK MARKER AT SOLDER DISTANCE "B".
3. ON TFE GUIDES ONLY: INSERT A DUMMY MANDRIL AND REMOVE TFE WITH A TORCH AT SOLDER DISTANCE "B" REMOVE DUMMY MANDRIL.
4. INSERT MANDRIL INTO COIL LEAVING TAPER EXTENDING OUT OF B-END OF COIL.
5. IF TFE COATED, REMOVE A 5 mm SECTION OF TFE WITH A TORCH AT PROXIMAL SOLDER-A, 2.0 cm -0 mm FROM "A" END OF COIL.
6. INSERT SPECIFIED SAFETY WIRE INTO B-END OF COIL. MAKE SOLDER CONNECTION AT SOLDER DISTANCE-A ACCORDING TO ALLSTATE COMPLEX WIRE GUIDES SPECIFICATION.
7. ULTRASOUND SOLDER IN STANDARD CLEANING SOLUTION, RINSE AND DRY. REFER TO SPEC 90101 SECTION 1.
8. MAKE MANDRIL ADJUSTMENT AS SPECIFIED LEAVING 4 cm OF MANDRIL EXTENDING OUT OF A-END OF COIL.
9. MAKE ANCHOR SOLDER-B PULLING COILS SLIGHTLY APART TO ALLOW SOLDER TO FLOW TO THE MANDRIL.
10. ULTRASOUND IN STANDARD CLEANING SOLUTION. RINSE AND DRY. REFER TO SPEC 90101 SECTION 3, STEPS 2 AND 3.
11. FOR XXX[X]X-35-XXX-AUS[X], SEPARATE COILS AT PROXIMAL SOLDER-A AND PLACE "A" END OF COIL IN COIL COMPRESSION FIXTURE WITH ABOUT A 4 mm OFFSET BETWEEN COIL AND GAUGE BLOCK. MAKE PROXIMAL SOLDER-A AS SPECIFIED AT THE SEPARATED SECTION WHILE APPLYING AIR PRESSURE SET TO BETWEEN 5 PSI AND 9 PSI. RELEASE AIR PRESSURE AND SLIGHTLY REHEAT THE SOLDER JOINT TO RELEASE EXCESS TENSION. ENSURE EXCESS SLACK IS REMOVED FROM COILS BETWEEN SOLDER-A AND SOLDER-B.
12. FOR XXX[X]X-38-XXX-AUS[X], SEPARATE COILS AT PROXIMAL SOLDER-A AND PLACE "A" END OF COIL IN COIL COMPRESSION FIXTURE WITH ABOUT A 4 mm OFFSET BETWEEN COIL AND GAUGE BLOCK. MAKE PROXIMAL SOLDER-A AS SPECIFIED AT THE SEPARATED SECTION WHILE APPLYING AIR PRESSURE SET TO BETWEEN 5 PSI AND 30 PSI. RELEASE AIR PRESSURE AND SLIGHTLY REHEAT THE SOLDER JOINT TO RELEASE EXCESS TENSION. ENSURE EXCESS SLACK IS REMOVED FROM COILS BETWEEN SOLDER-A AND SOLDER-B.
13. CUT OFF COIL AND EXCESS MANDRIL 5 mm -10 mm FROM PROXIMAL SOLDER-A AT TIP JUNCTION "A".
14. ULTRASOUND SOLDERS IN STANDARD CLEANING SOLUTION, RINSE AND DRY. REFER TO SPEC 90101 SECTION 3, STEPS 2 AND 3 AND SECTION 2.
15. GRIND SOLDER SURFACES IF NECESSARY.
16. GAUGE SOLDER SURFACES.
17. MAKE TIP JUNCTION-B AND TIP JUNCTION-A AS SPECIFIED.
18. ON CURVED GUIDES ONLY: FORM CURVE RADIUS AS SPECIFIED.
19. PRODUCT TO 100% CHECK THAT COMPLETED XXX[X]X-35-XXX-AUS[X] GUIDES FIT INTO A 69CM-PURPLE-15GA-PUNCHED-STONE-BELT PACKAGING (RM2775) AND COMPLETED XXX[X]X-38-XXX-AUS[X] GUIDES FIT INTO A 69CM-RED_15GA-PUNCHED-STONE-BELT (RM2775) ALL WITHOUT SPILLING OUT.

NOTES

1. MARK WIRE GUIDES ARE BUILT TO NOT ROLL AND INTERTWINE LOOP AND TIE ENDS WITH YELLOW TIE.
2. 1.5 cm WIRE GUIDE LENGTHS MAY BE COMPRESSED BY HAND.
3. FOR XXX[X]X-35-XXX-AUS[X], SET AIR PRESSURE TO COMPRESS COIL WITHIN SPECIFIED RANGE. ADJUST AS REQUIRED TO REMOVE EXCESSIVE SLACK.
4. ASSEMBLER MUST HAVE DOCUMENTATION IN THEIR TRAINING FILE ON CT71 BEFORE SOLDERING.

CHANGE REQUEST REVISION DATE

CR 96-900	5-13-96	CR 10-2652	9-27-10
CR 97-1302	6-16-97	CR 10-386	10-06-10
CR 98-803	4-17-98	CR 12-2095	18Jul2012 (SH 18Jul2012)
CR 01-1813	9-12-01	CR 13-2686	07Jun2013 (SH 13Sep2013)
CR 03-1660	8-14-03	CR 13-3700	01Nov2013 (SH 05Nov2013)
CR 04-131	1-23-04	CIN-14-4722;	16Jan2015; JWH 16Jan2015