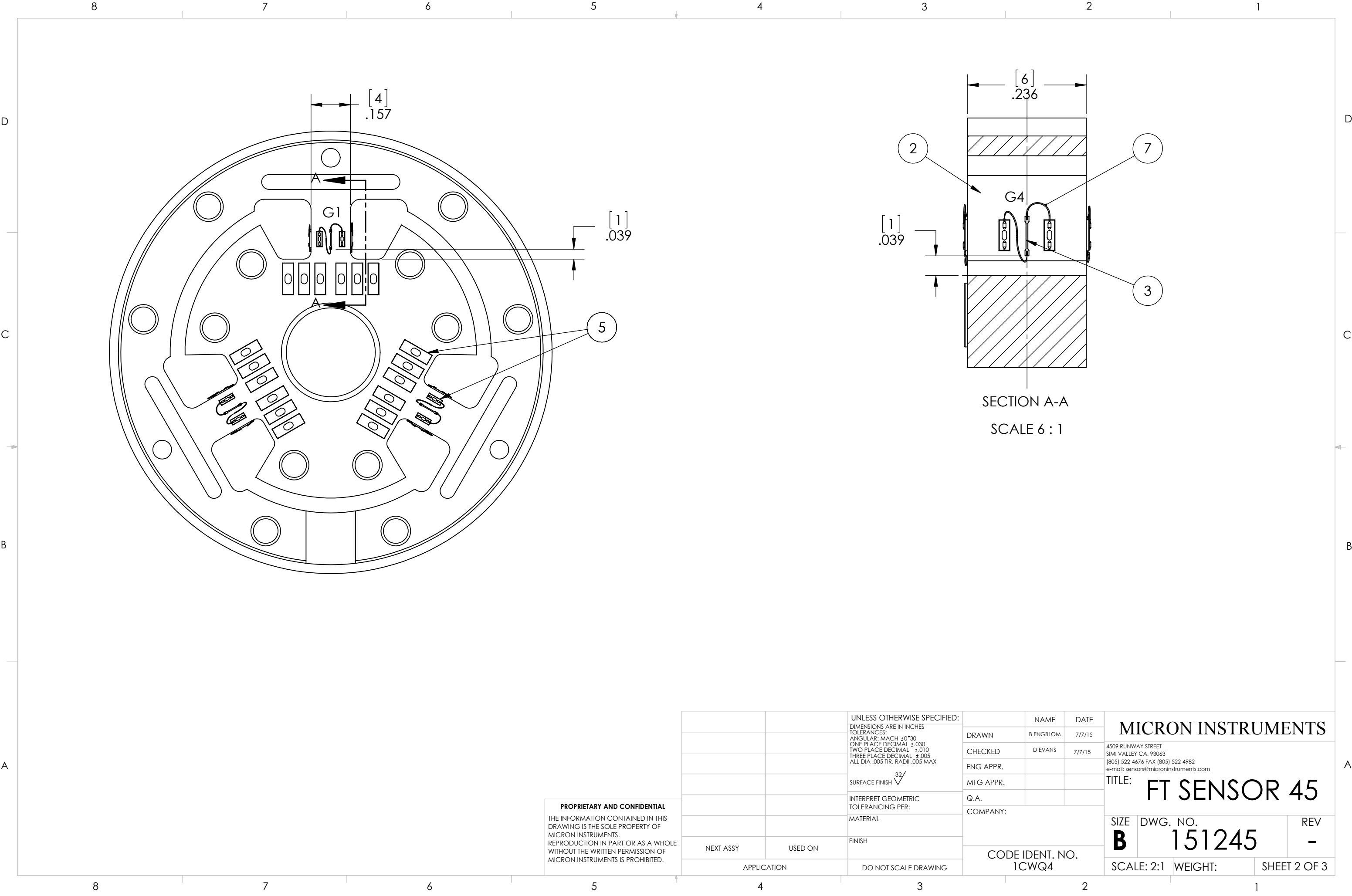


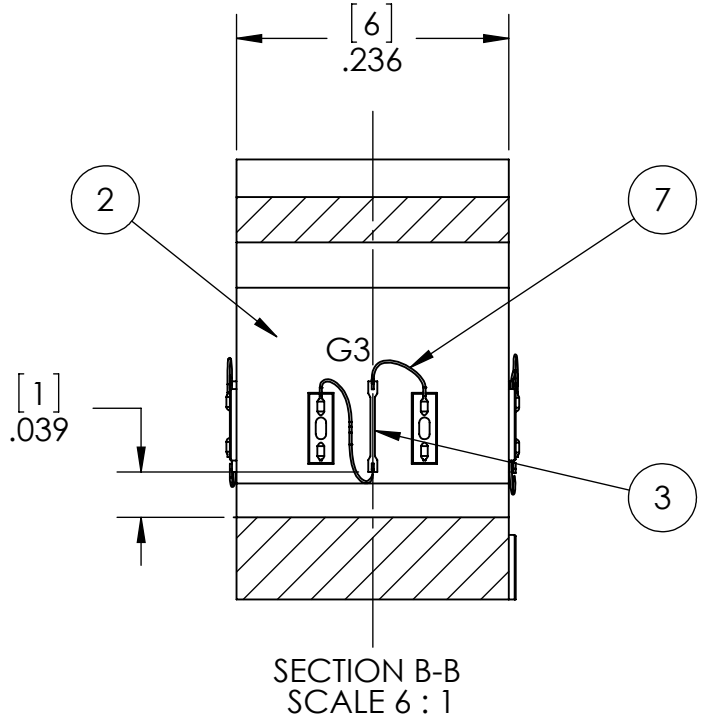
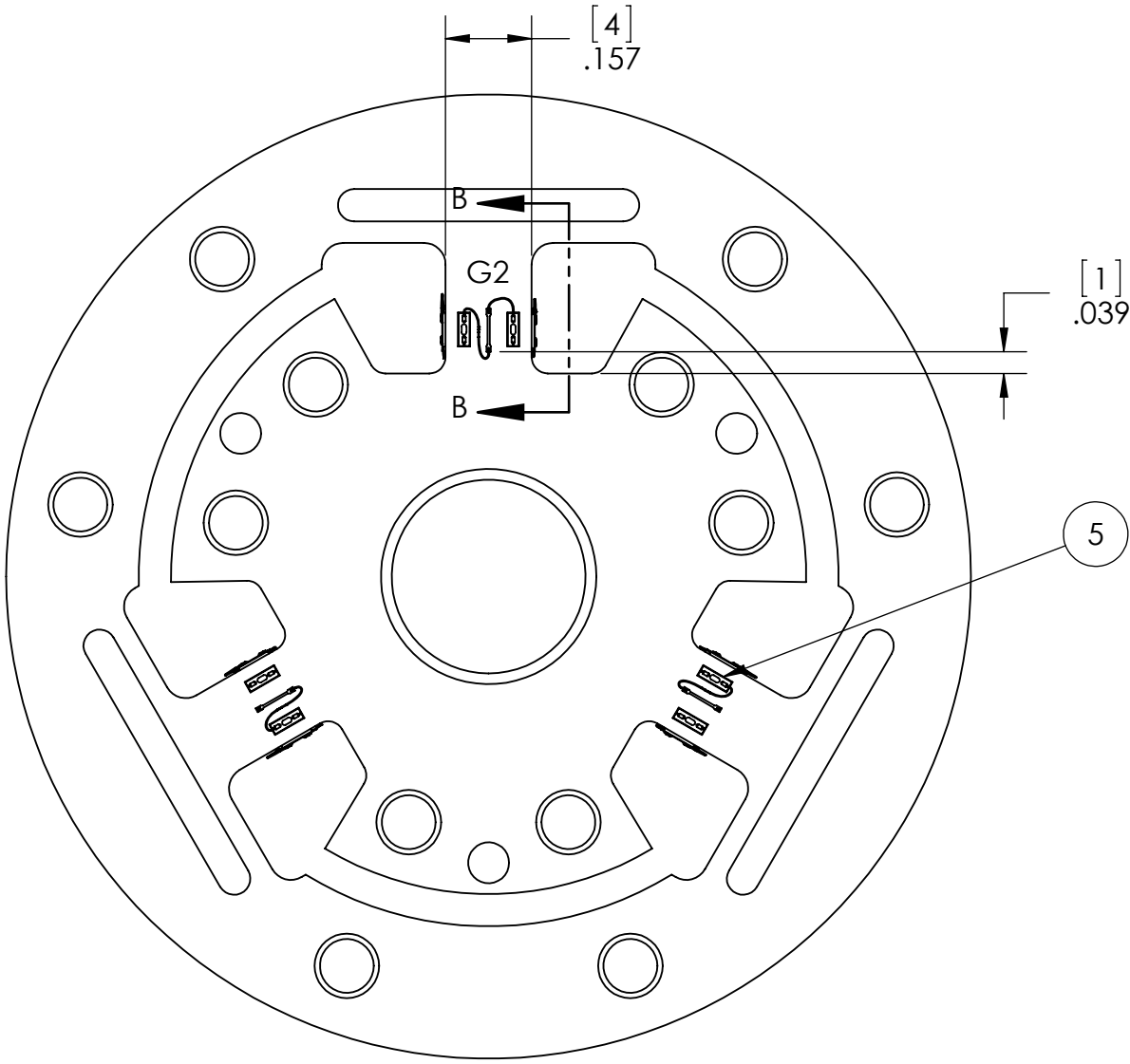
CIRCUIT TYP  
BEAM A, B, & C

- ① APPLY SERIAL NUMBER TO THIS SURFACE.
- ② PREPARE SURFACES TO BE GAGED PER 480135 AS SHOWN.
- ③ PREPARE AND PLACE STRAIN GAGES SS-060-033-500 (\$4)PER 280125 AS SHOWN. GAGES ARE PLACED ON (4) SIDES OF BEAM (3) PLCS.
4. CURE GAGES IN VACUUM USING CURE SCHEDULE 1 PER 280107.
- ⑤ PREPARE AND PLACE (MST-060) & (MST-125) SOLDER TABS PER 240330 AS SHOWN.
6. CURE SOLDER TABS AT 200°F FOR ONE (1) HOUR.
- ⑦ ATTACH GAGE LEADS TO SOLDER TABS PER 240331 AS SHOWN. ROUTE MAGNET WIRE TO TABS AS DEPICTED IN SCHEMATICS.
8. CHECK GAGE CONTINUITY AND ISOLATION PER 490013. MINIMUM RESISTANCE TO CASE, 50MΩ@50 VDC.
9. ATTACH TEMPORARY TEST CABLE PER CIRCUIT SHOWN AND PERFORM TEMPERATURE COMPENSATION PER480131. TEMPERATURES ARE 68°F, 75°F,AND 176°F. USE 5VDC BRIDGE EXCITATION. BALANCE OUTPUT MAY VARY FROM AMBIENT OUTPUT BY NO MORE THAN ± 5mV OVER TEMPERATURE RANGE OF 68°F AND 176°F.
10. COVER GAGES AND GAGE LEADS WITH DOW CORNING 3140 RTV.
11. INSPECTION: VERIFY THAT ALL MANUFACTURING STEPS NOTED ABOVE HAVE BEEN COMPLETED. DATA PROVIDED IS BALANCE (NO LOAD)OUTPUT OF SENSOR AT 68°F, 75°F, 176°F, SUPPLY RESISTANCE VALUES AND THEIR LOCATIONS IN THE CIRCUIT.

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		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES: ANGULAR: MACH ±0°30 ONE PLACE DECIMAL ±.030 TWO PLACE DECIMAL ±.010 THREE PLACE DECIMAL ±.005 ALL DIA .005 TIR, RADII .005 MAX  SURFACE FINISH 32  INTERPRET GEOMETRIC TOLERANCING PER:  MATERIAL  FINISH		NAME	DATE	MICRON INSTRUMENTS  4509 RUNWAY STREET SIMI VALLEY CA. 93063 (805) 522-4676 FAX (805) 522-4982 e-mail: sensors@microninstruments.com  TITLE: FT SENSOR 45		
			DRAWN	B ENGBLOM	7/7/15			
			CHECKED	D EVANS	7/7/15	SIZE DWG. NO. REV B 151245 -		
			ENG APPR.					
			MFG APPR.					
			Q.A.		SCALE: 2:1 WEIGHT: SHEET 1 OF 3			
			COMPANY:					
			IIT					
NEXT ASSY	USED ON		CODE IDENT. NO. 1CWQ4					
APPLICATION		DO NOT SCALE DRAWING						





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			DRAWN		B ENGBLOM	7/7/15				
			CHECKED		D EVANS	7/7/15				
			ENG APPR.							
			MFG APPR.				TITLE:  FT SENSOR 45			
		SURFACE FINISH		32/√						
		INTERPRET GEOMETRIC TOLERANCING PER:		Q.A.				SIZE DWG. NO. REV B 151245 -		
		MATERIAL		COMPANY:						
		FINISH		CODE IDENT. NO. 1CWQ4				SCALE: 2:1 WEIGHT: SHEET 3 OF 3		
NEXT ASSY	USED ON									
APPLICATION		DO NOT SCALE DRAWING								