

DO NOT SCALE FROM THIS PRINT

DESIGNED & DIMENSIONED IN MILLIMETERS [INCHES]

ZCC-X-XX
 SIZE -1: SEE TABLE 1
 -2: SEE TABLE 1
 WELD TAB STYLE -TH: THROUGH HOLE

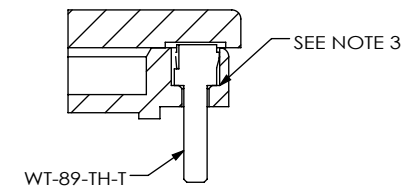
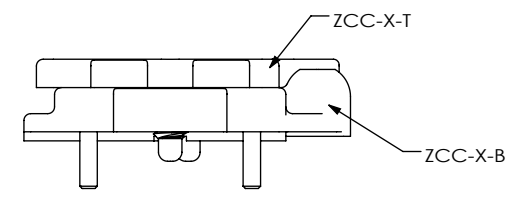
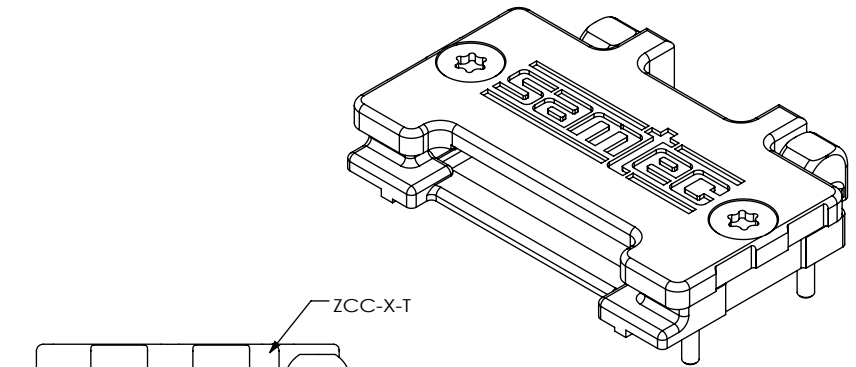
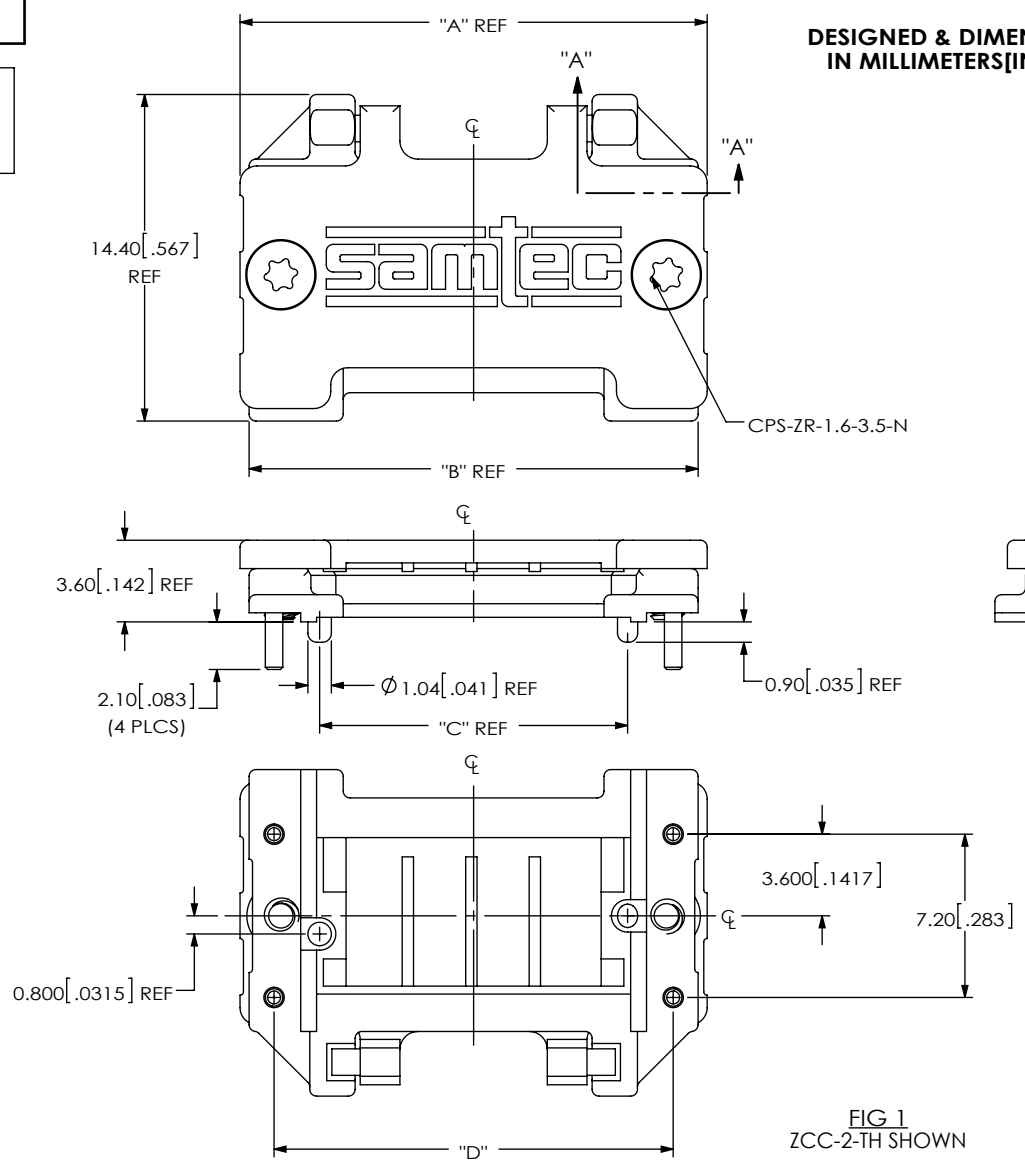


FIG 1
ZCC-2-TH SHOWN

SIZE	"A"	"B"	"C"	"D"
-1	15.80 [0.622]	15.00 [0.591]	8.78 [0.346]	12.80 [0.504]
-2	20.60 [0.811]	19.80 [0.780]	13.58 [0.535]	17.60 [0.693]

NOTES:

- REPRESENTS A CRITICAL DIMENSION.
- WELD TAB MINIMUM PUSHOUT FORCE: 2.22N[.5 LB].
- WELD TAB MUST BOTTOM OUT IN DIE CAST.
- LID TO BE SECURED WITH CPS-ZR-1.6-3.5-N SCREWS. TORQUE FOR SHIPPING: 4 IN-OZ. TORQUE FOR FINAL ASSEMBLY: 10 IN-OZ.
- PACKAGE ASSEMBLIES IN TRAYS.
- COMPONENTS MUST PASS INSPECTION PER COMPONENT DRAWINGS: ZCC-X-B, ZCC-X-T, WT-89-XX-X, CPS-ZR-X-X-X-X-X, K-CPS-ZR-XXX-XXX-XXX

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN MILLIMETERS. TOLERANCES ARE:
 DECIMALS ANGLES
 X.X: ±0.3 [.01] 2°
 X.XX: ±0.10 [.004]
 X.XXX: ±0.051 [.0020]

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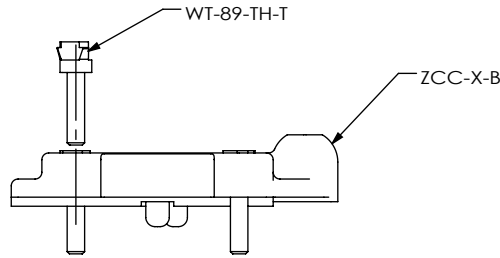
MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 3:1
 BASE: ZINC, BLACK NICKEL PLATED
 CLAMP: ZINC, BLACK NICKEL PLATED
 WELD TAB: BRASS
 SCREW: BRASS
 SCREW RETAINER: POLYIMIDE

520 PARK EAST BLVD., NEW ALBANY, IN 47150
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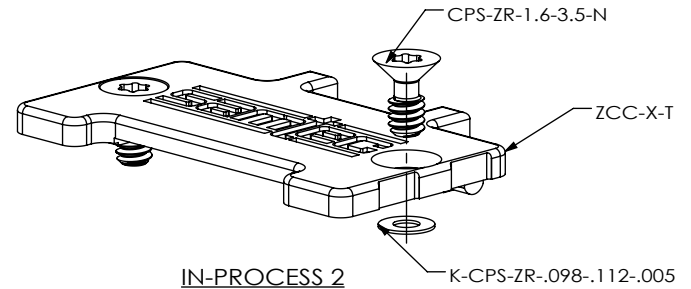
DESCRIPTION:
ZRDP CAGE ASSEMBLY

DWG. NO.
ZCC-X-XX

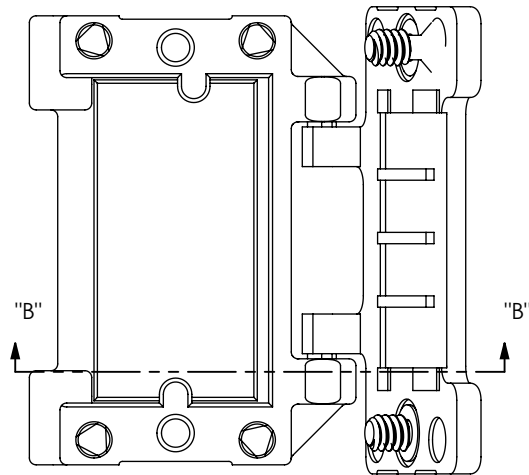
BY: D.SCHMELZ 7/24-2014 SHEET 1 OF 2



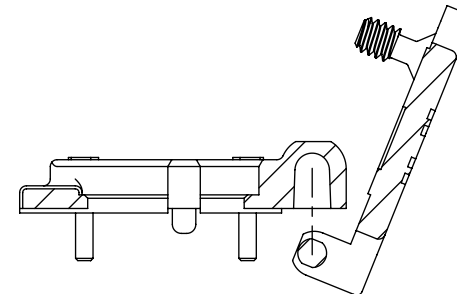
IN-PROCESS 1
INSERT WELD TABS
(ZCC-X-TH SHOWN)



IN-PROCESS 2
ATTACH SCREWS TO TOP HOUSING
USING KAPTON RETAINER WASHERS



IN-PROCESS 3
ASSEMBLE TOP & BOTTOM HOUSINGS
(SEE NOTE 4)



SECTION "B"-"B"

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DO NOT SCALE DRAWING

SHEET SCALE: 3:1



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DESCRIPTION:
ZRDP CAGE ASSEMBLY

DWG. NO.
ZCC-X-XX

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