

* APPLY TO SMALL SIZE TERMINAL ONLY.

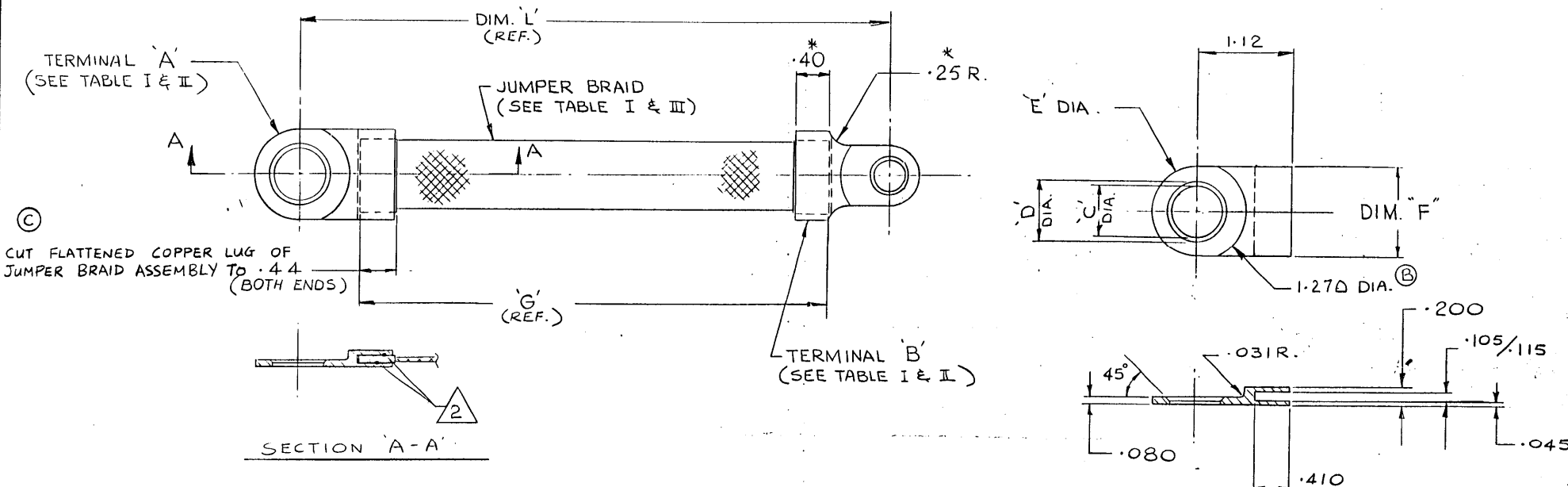


TABLE I :- JUMPER ASS'T.

COMPONENT ASS'Y. NO.	TERMINAL 'A' PART NO	TERMINAL 'B' PART NO	JUMPER BRAID PART NO	DIM. 'L' (REF.)
-001	-103	-101	-121	6.5
-003	-103	-103	-121	6.5
-005	-103	-105	-123	8.54

TABLE II :- TERMINAL 'A' & 'B' SIZE

PART NO	DIM. 'C'	DIM. 'D'	DIM. 'E'	DIM. 'F'
* -101	$\frac{.378}{.388}$	$\frac{.438}{.458}$	.687	.875
-103	$\frac{.504}{.515}$	$\frac{.575}{.595}$	.875	.875
-105	$\frac{.631}{.643}$	$\frac{.725}{.745}$	1.062	1.062

TABLE III :- JUMPER BRAID DETAIL
(MADE FROM VENDOR'S PART)

TABLE III :- JUMPER BRAID DETAIL (MADE FROM VENDOR'S PART)			
PART NO	VENDOR'S PART NO.	VENDOR'S NAME	DIM. 'G'
-121	6820-6	JANCO CORP.	5.12
-123	6820-8	JANCO CORP.	7.12

NOTES :

1. a) TERMINAL MATERIAL : BERYLLIUM COPPER ALLOY 172 TO QQ-C-533 OR QQ-C-530.
FINAL HEAT TREAT : CONDITION AT (165-190 KSI) TO PPS 30.07 (BEFORE SOLDERING).
- b) JUMPER BRAID MATERIAL : TINNED COPPER BRAID, QQ-B-575; 672 STRANDS OF #32 WIRE = 42,500 CIRCULAR MILLS; OR 1056 STRAINS OF #34 WIRE = 42,000 CIRCULAR MILLS.
2. ~~SOLDER TERMINALS TO BRAID WITH SILVER/TIN SOLDERING ALLOY - ENGELHARD "BRAZE-IT 430S" OR EQUIVALENT (6% SILVER, 94% TIN; SOLIDUS 430°F, LIQUIDUS 535°F) - ENSURE FULL CONTACT BETWEEN SOLDERING SURFACES.~~
3. ~~AFTER SOLDERING, TIN DIP ASSY. PER QQ-S-571. (THE MOLTEN TIN TEMPERATURE SHOULD NOT EXCEED 460°F).~~
- ~~ALTERNATIVE PROT. FINISH: TIN ELECTROPLATE 0.0003 TO 0.0005 INCHES THICK, TO BEST COMMERCIAL PRACTICE.~~
2. MANUFACTURING METHOD 'A'
- SOLDER TERMINALS TO BRAID WITH SILVER/TIN SOLDERING ALLOY : ENGELHARD "BRAZE-IT 430S" OR EQUIVALENT (6% SILVER, 94% TIN; SOLIDUS 430°F, LIQUIDUS 535°F). ENSURE MAXIMUM CONTACT BETWEEN SOLDERING SURFACES.
 - AFTER SOLDERING, TIN DIP ASSEMBLY PER QQ-S-571 (THE MOLTEN TIN TEMPERATURE SHOULD NOT EXCEED 460°F).
- MANUFACTURING METHOD 'B'
- SOLDER TERMINALS TO BRAID WITH SILVER/TIN SOLDERING ALLOY :
 - i) 5% SILVER, 95% TIN, SOLIDUS 430°F, LIQUIDUS 473°F.
 - OR ii) 6% SILVER, 94% TIN, ENGELHARD "BRAZE-IT 430S"; SOLIDUS 430°F, LIQUIDUS 535°F.
 - ENSURE MAXIMUM CONTACT BETWEEN SOLDERING SURFACES.
 - AFTER SOLDERING, TIN ELECTROPLATE 0.0003 TO 0.0005 INCHES THICK TO BEST COMMERCIAL PRACTICE.
3. MANUFACTURE AND INSPECT JUMPER ASSEMBLIES PER PPS 9.21
- a) THE WETTED SOLDER AREA BETWEEN TERMINAL LUG AND JUMPER BRAID SHALL BE GREATER THAN OR EQUAL TO 60%.
 - b) THE NUMBER OF BROKEN STRANDS PER JUMPER ASSEMBLY SHALL NOT EXCEED 10.

DO NOT SCALE DWG

NEXT ASS'Y	USED ON	NO RECD PER A/C	EFFY.
PART NO. CSP 421- SEE TABLE			

QUANTITY REQ. PER			ZONE	SHEET	CODE	PART NO.	DESCRIPTION	MATERIAL	MATL. SPEC.	FINAL HEAT TREAT	PROG. FINISH	
LIST OF MATERIAL												
F 19 EPOXY ZINC CHROMATE PRIMER P.P.S. 34.08			REQUIREMENTS - UNLESS OTHERWISE SPECIFIED				MOD NO.	THE DE HAVILLAND AIRCRAFT OF CANADA, LIMITED DOWNSVIEW  ONTARIO				
			GENERAL		LIMITS		DRAWN					
C 1 ALODINE P.P.S. 32.01			1. DIMS ARE IN INCHES		1. DECIMAL		CHECKED	DRAWING TITLE JUMPER, GROUNDING, FLAT BERYLLIUM COPPER TERMINAL				
			2. SURFACE ROUGHNESS 125 $\sqrt{\text{MAX}}$		1 PLACE $\pm .1$		APPROVED					
E 1 CADMIUM PLATE P.P.S. 33.01			3. REMOVE SHARP EDGES 0.15 MACHINE PARTS		2 " $\pm .03$		STRESS, M.&P. 20/1/86		DWG. SIZE D 71867 CSP 421			
			4. EDGT FINISHING OF PARTS IN ACCORDANCE WITH P.P.S. 37-02		3 " $\pm .01$							
A 1 ANODIZE P.P.S. 32.03			5. THREADS IN ACCORDANCE WITH MIL-S-7742		2. DIMENSIONS & TOLERANCES APPLY AFTER PLATING		CH. DRAFTN.		RELEASE P C			
					3. ANGLES $\pm 0^{\circ} 30'$							
CODE PROTECTIVE TREATMENT DE HAVILLAND PRODUCTION PROCESS SPECN.			PRODUCTION PROCESS STANDARDS (P.P.S.) AND OTHER STANDARDS LISTED ON DWG. IN ADDITION TO THOSE STANDARDS CALLED UP IN THE FIELD OF THIS DRAWING SHALL FORM PART OF THIS DRAWING FOR ALL MANUFACTURING AND QUALITY REQUIREMENTS.				TECH. DES.		SCALE 1:1 WGT. CALC. ACTUAL SHT. OF SHT			