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**Receptacle Adapter Ultrasonic and One-Piece Die Cast  
Assembly Operations**

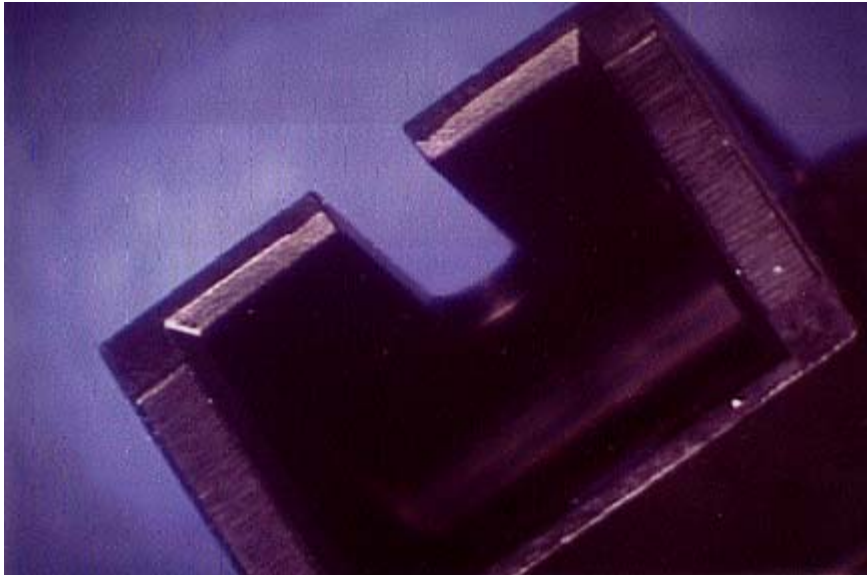
**1. SCOPE**

This specification covers the acceptable requirements and the not acceptable conditions for the Receptacle Adapter Ultrasonic and One-Piece Die Cast Assembly Operations.

**2. INSPECTION CRITERIA**

Unless otherwise specified, figures are shown at approximately 10X magnification. The Ultrasonic Assembly and the Die Cast Assembly will be inspected without magnification.

**NOTE** *Even though the pictorials shown in this document are of the SC product family, they are representative of all types of receptacle adapters.*



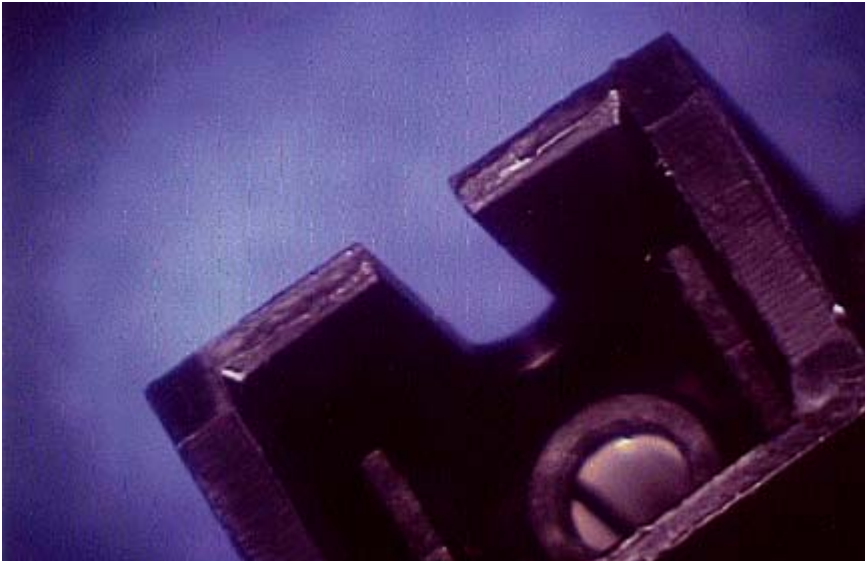
**ACCEPTABLE**

Tool Marks

Figure 1

**NOTE**

*If less than 50% of the lead in chamfer has been damaged due to tool marks, the part is considered ACCEPTABLE.*



**NOT ACCEPTABLE**

Tool Marks

Figure 2

**NOTE**

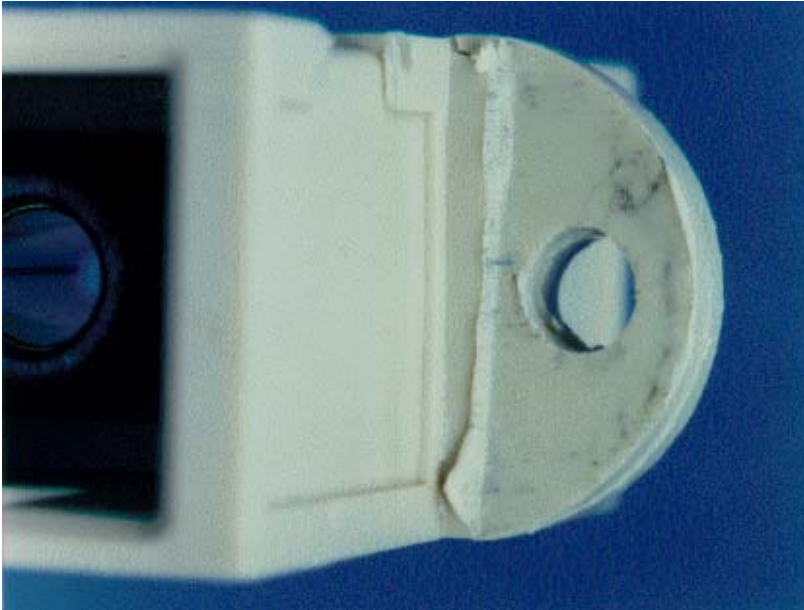
*If 50% or more of the lead in chamfer has been damaged due to tool marks, the part is considered NOT ACCEPTABLE*



**ACCEPTABLE**

Tool Marks on Flange

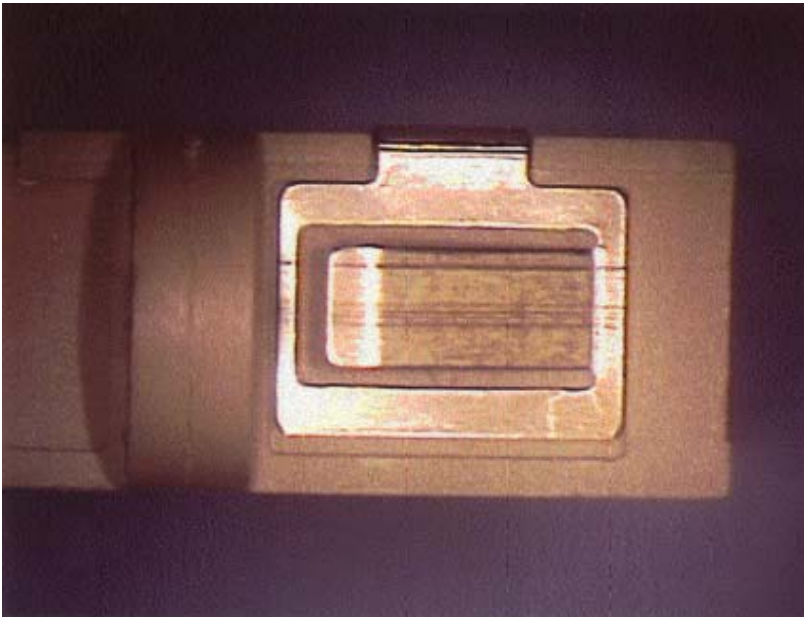
Figure 3



**NOT ACCEPTABLE**

Tool Marks on Flange

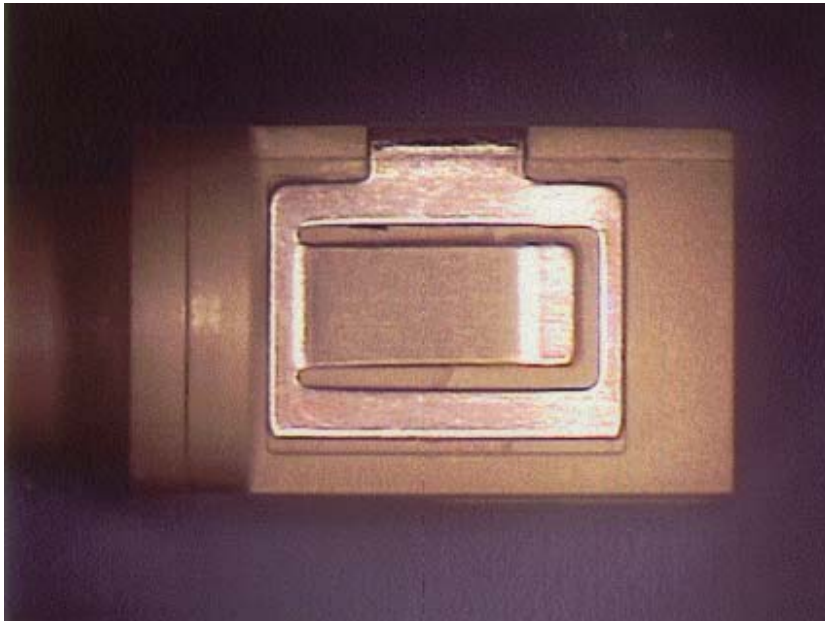
Figure 4



**ACCEPTABLE**

Position of Ears on  
Retention Clip

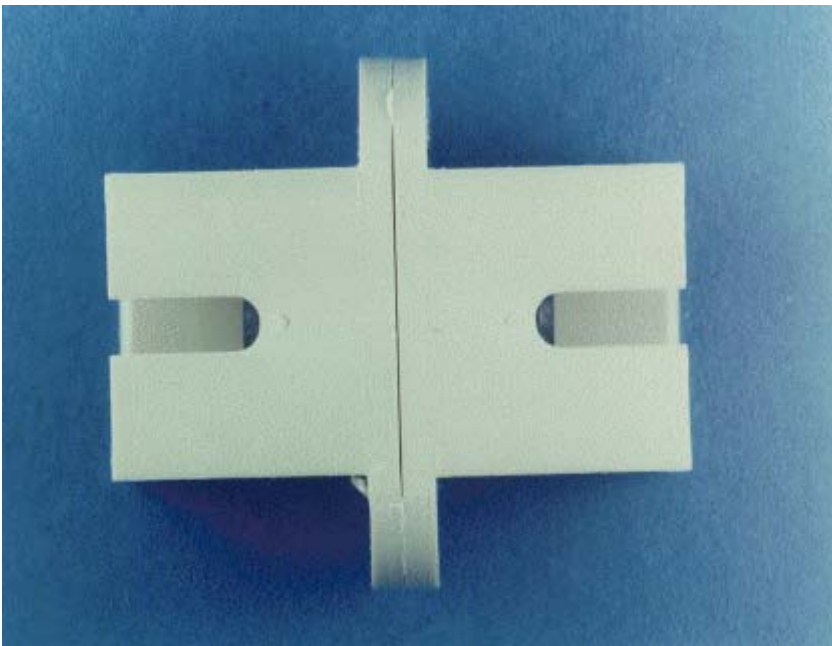
Figure 5



**NOT ACCEPTABLE**

Position of Ears on  
Retention Clip

Figure 6



**ACCEPTABLE**

Direction of Keyway  
(Both in Same Direction)

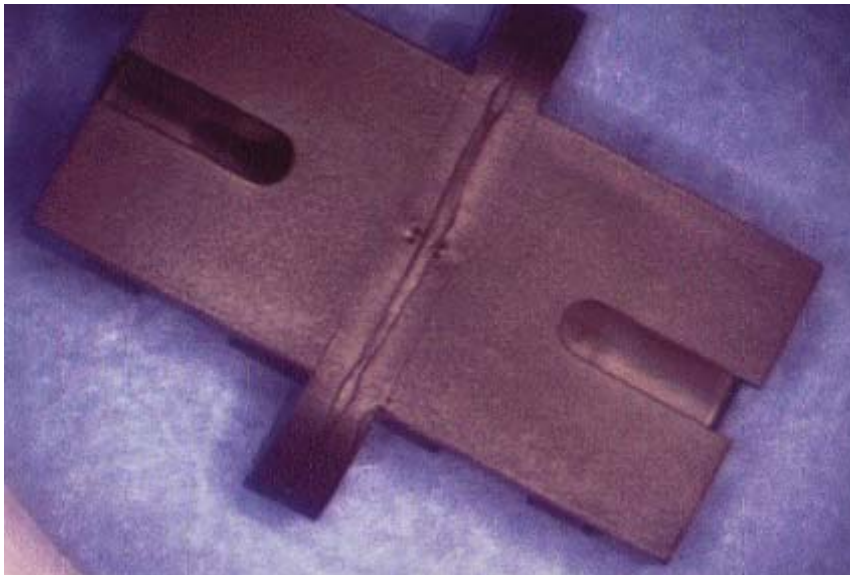
Figure 7



**NOT ACCEPTABLE**

Direction of Keyway  
(One in the Front,  
One in the Back)

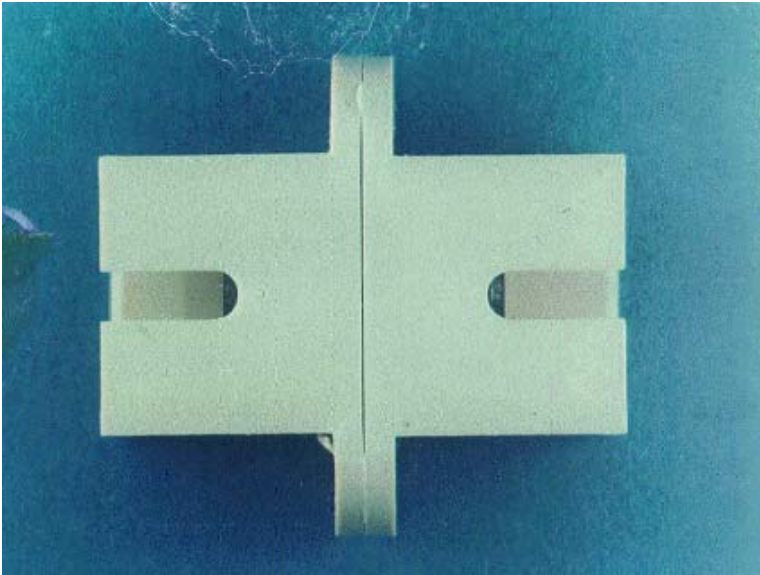
Figure 8



**NOT ACCEPTABLE**

Flash

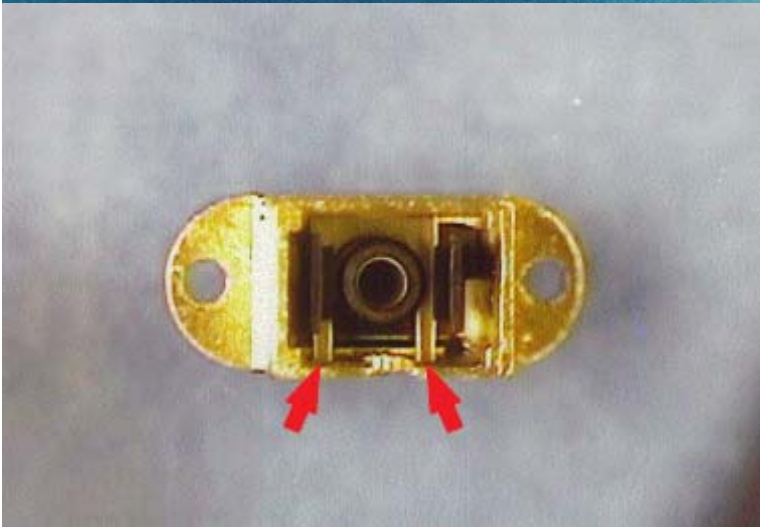
Figure 9



**NOT ACCEPTABLE**

Allowable Gap  
(Up to 0.010 inch  
Gap is Allowed)

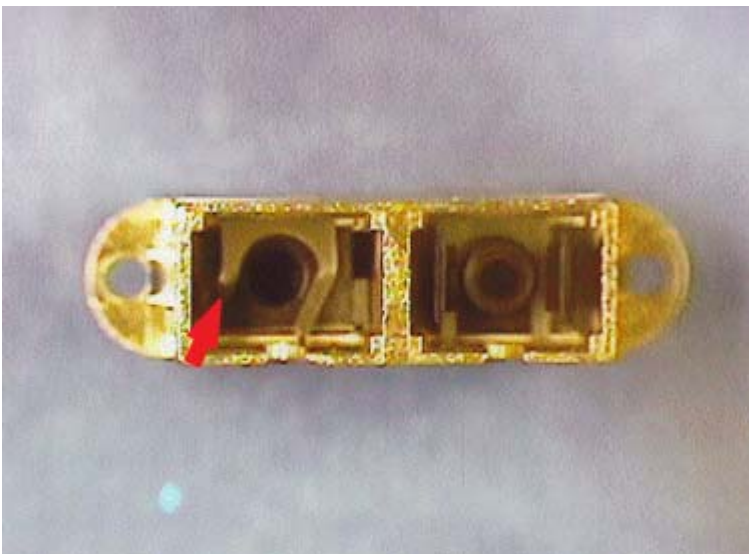
Figure 10



**ACCEPTABLE**

Correct Retaining Fork Placement  
(Viewed from the  
SC Side of Adapter)

Figure 11



**NOT ACCEPTABLE**

Damaged Retaining Fork Placement  
(Viewed from the  
SC Side of Adapter)

Figure 12

**NOTE**

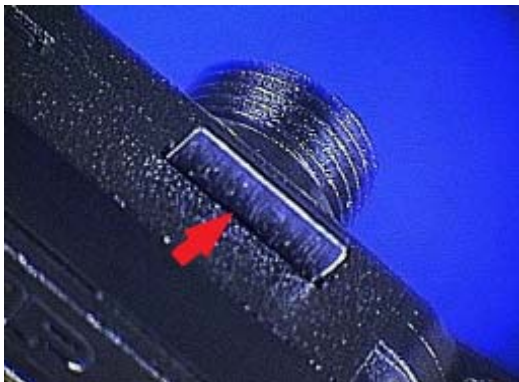
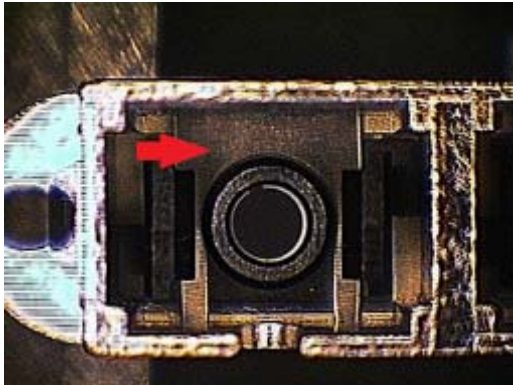
*The acceptable and not acceptable conditions in Figures 11 and 12 apply to both Simplex and Duplex Adapters.*



**ACCEPTABLE**

Fully Seated Retaining Fork

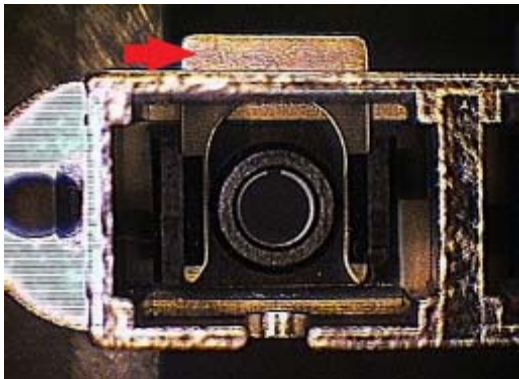
Figure 13



**NOT ACCEPTABLE**

Unseated Retaining Fork

Figure 14



**NOTE**

*The acceptable and not acceptable conditions in Figures 13 and 14 apply to both Simplex and Duplex Adapters.*