



QA Technology Company, Inc.

A p p l i c a t i o n s N o t e

X Probe® Drill Sizes

(See document #ANQ034 for conventional socket hole sizes.)

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Page 1 of 1

QA Technology highly recommends that holes initially drilled in fixture plates be verified using pin gauge tools (PG-X39, PG-X50 and PG-X75A) due to the tolerances of purchased drill bits which can be undersized by as much as .0005” or more. The machine feed rate, RPM and material used, can also affect the hole size. Undersized holes will not pass Go/No-Go pin gauge testing. Undersized holes will not only create problems when inserting the termination pins but can also cause bent and/or stuck down plungers within the finished fixture. Therefore, QA Technology strongly suggests the use of pin gauges for hole size verification **before** attempting termination pin or probe installation during the assembly of the fixture.

| X Probe® Socketless Series | | | |
|-----------------------------------|--|---------------------------|--|
| Series | Fixture Plates | Hole Specifications | Suggested Drill Sizes IN BOLD (Decimal) |
| X39 Series | Probe Plate | 0.0315/0.0325 [0.80/0.83] | #66 (.033) |
| | Optional Spacer Plate | 0.034 [0.860] minimum | .85mm (.0335) #65 (.035) |
| | Back Plate (Wired Termination) | 0.0315/0.0325 [0.80/0.83] | #66 (.033) |
| | Back Plate (Wireless Termination) | 0.0315/0.0325 [0.80/0.83] | #66 (.033) |
| X50 Series | Probe Plate | 0.0415/0.0430 [1.05/1.09] | #58 (.042) #57 (.043) |
| | Optional Spacer Plate | 0.045 [1.14] minimum | 1.15mm (.0453) #56 (.0465) |
| | Back Plate (Wired Termination) | 0.038/0.039 [0.97/0.99] | #62 (.038) #61 (.039) 1.00mm (.0394) |
| | Back Plate (Wireless Termination) | 0.038/0.039 [0.97/0.99] | #62 (.038) #61 (.039) 1.00mm (.0394) |
| X75 Series | Probe Plate | 0.0545/0.0560 [1.38/1.42] | #54 (.055) 1.40mm (.0551) |
| | Optional Spacer Plate | .0625 [1.59] minimum | 1/16 (.0625) 1.6mm (.063) |
| | Back Plate (Wired Termination) | 0.0515/0.0525 [1.31/1.33] | #55 (.052) 1.35mm (.0531) |
| | Back Plate (Wireless Termination) | 0.038/0.039 [0.97/0.99] | #62 (.038) #61 (.039) 1.00mm (.0394) |