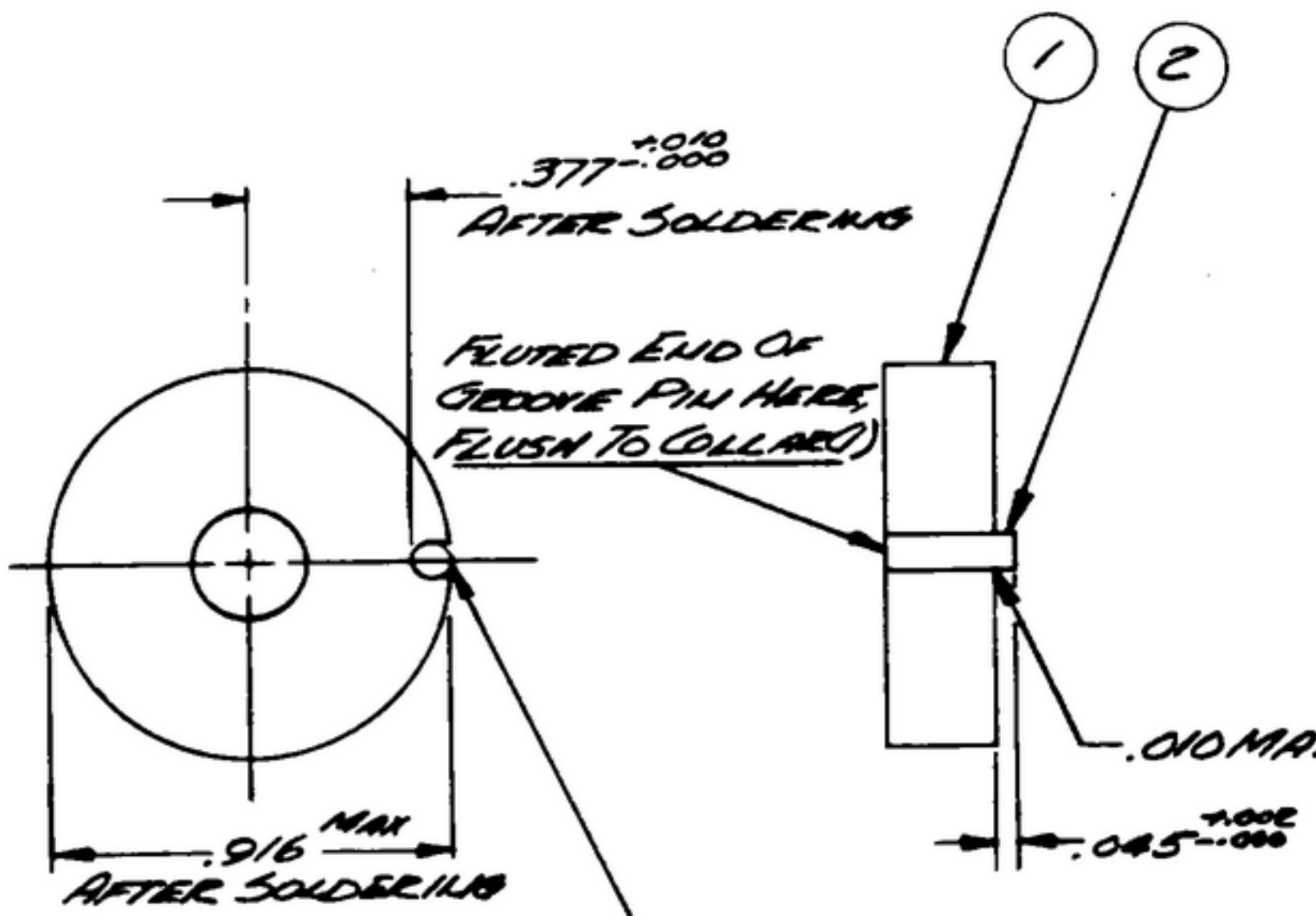


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\* FOR INFORMATION ONLY. CONTRACTOR MAY AT HIS OPTION DEVIATE FROM THESE PROCESS DETAILS.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A1	NOTE 1 READ, "--- QQ-5-561, CLASS 4 OR G USING FLUX PER U.S. NAVY SPEC 51F4."	18 AUG 64	15283-PP-63 REVD EC-2



NOTES  
 (A1) 1. SILVER SOLDER SHALL BE PER SPEC QQ-5-561, USING FLUX PER O-F-499.

FLOW SILVER SOLDER AROUND PIN. DO NOT ALLOW SOLDER TO BUILD UP (SEE NOTE 1).

FINISH: E300 PER SPEC. MIL-F-14072  
 \* COLLARS 588-0025-88

COLLING PART NO.	ITEM	QTY	PART NO.	DESCRIPTION	MATL	MATL SPEC
<del>589 0243 002</del>	<del>2</del>	<del>1</del>	<del>SM-B-283159</del>	<del>PIN</del>		
<del>588 0820 002</del>	<del>1</del>	<del>1</del>	<del>SM-B-248872</del>	<del>COLLAR - STOP</del>		

LIST OF MATERIAL ~~COLLING PART NO. 588-0221-002~~

DRAWN <i>LAPISH</i>		CHECKED <i>EG</i>	APPROVED	COLLING RADIO CO. SIGNAL CORPS 14214-PH-51-93		DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY
UNLESS OTHERWISE SPECIFIED: DECIMAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±.008 FRACTIONAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±1/64 MACHINED ANGLES MAY VARY ±1° SWEARED ANGLES MAY VARY ±.25° BROKEN ANGLES MAY VARY ±1° ECCENTRICITY BETWEEN ANY DIAMETERS ON THE SAME CENTERLINE SHALL NOT EXCEED .010 TOTAL INDICATOR READING. ALL DIMENSIONS ARE FINISH DIMENSIONS INCLUDING APPLIED FINISH AND ARE GIVEN IN INCHES.		REVIEWED <i>PME</i>		APPROVED <i>HLV</i> <i>PME</i>		
SM-D-144678		DATE <i>3 MARCH 58</i>		SCALE <i>2/1</i>		
SM-C-248960 SC-DL-144500		COLLAR STOP ASSY		SM-B-248873		
SM-C-248961 SC-DL-248725		APPLICATION				