

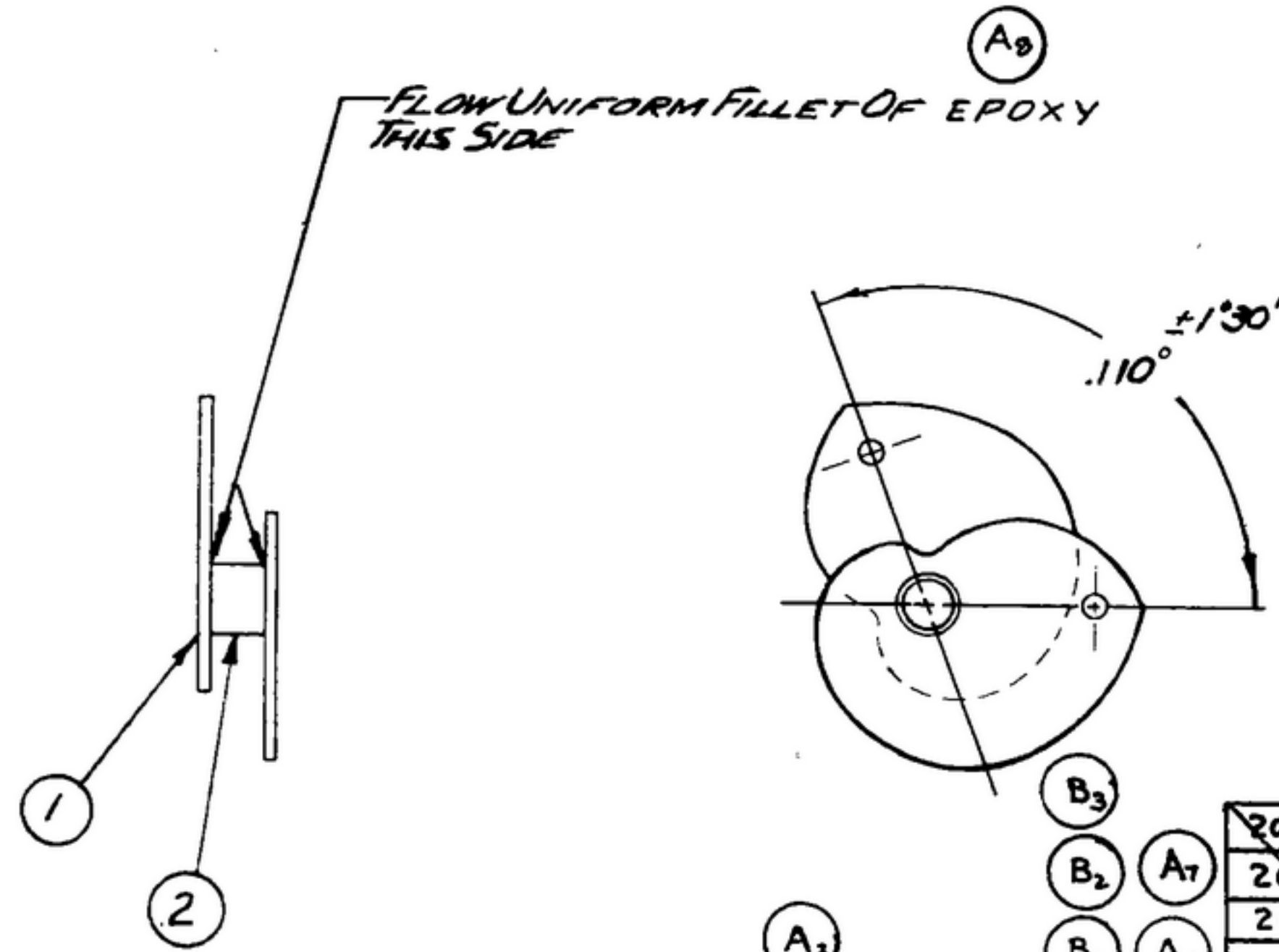
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REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
SYM	PR10042-S		
A ₈	A ₁ SOLDER WAS USED AS A BOUNDING AGENT IN NOTE 1 A ₂ ITEM 2 WAS SM-C-248974 A ₃ ADDED IRIDITE #7 TO FINISH NOTE A ₄ WAS TORQUE WITOUT A SOLDER JOINT FAILURE A ₅ NOTE 3 REFERRED TO SOLDER PER QQ-S-571 & A COMMERCIAL FLUX A ₆ DELETED NOTE 4 (REMOVAL OF ACID FLUX A ₇ ADDED ITEM 3, 4 & 5 A ₈ EPOXY WAS SOLDER	9 OCT 59	4142B-PC 59-AI-51 REV'D PME
B ₃	B ₁ WAS IIP 205 112 B ₂ WAS IIP 205 113 B ₃ WAS IIP 205 114	17 MAY 60	4142B-PC 59 REV'D PME
C ₁	C ₁ ADDED NOTE 4	22 FEB 61	4142B-PC 59 REV'D PME



NOTES

- (A₁) 1 PRESS HUB (2) IN CAMS (1) SNUG AGAINST SHOULDERS & BOND WITH EPOXY AS SHOWN
- (A₄) 2 CAMS MUST WITHSTAND 6 FT. LBS TORQUE WITHOUT AN EPOXY JOINT FAILURE
- (A₅) 3 BOND WITH EPOXY CONSISTING OF EPON 828 (SHELL CHEMICAL CO. CHICAGO ILL OR EQUAL) CURING AGENT BF3-400 (HARSHAW CHEMICAL CO. CLEVELAND OHIO OR EQUAL) AND HEAVY GRADE TITANIUM DIOXIDE (TITANIUM PIGMENT CORP, NATIONAL LEAD CO N.Y., N.Y. OR EQUAL
- (C₁) (A₆) 4 REAM I.D. OF HUB TO .2492 ± .0002 DIA AFTER ASS'Y

FINISH: CHEMICAL POLISH PER IRIDITE #7 METCOTE PROCESS BY ALLIED RESEARCH PRODUCTS INC, BALTIMORE, MD, OR EQUAL. (* SAME AS 572167)
* COLLINS 580 0034 00

QTY	ITEM	REQD	PART NO.	DESCRIPTION	MATL	MATL SPEC	NOTE
5	AS REQ'D			FILLER			3
4	AS REQ'D			ACTUATOR			3
3	AS REQ'D			EPOXY			3
2	1		SM-B-283272	HUB - CAM			
1	1		SM-D-178928	CAM			

LIST OF MATERIAL

COLLINS PART NO. 558 0303 002

DRAWN <i>Hammer</i>		CHECKED <i>Ham</i>	APPROVED	-COLLINS-RADIO CO. -CEDAR-RAPIDS, IOWA 14214 - PH- 51-93		DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY SM-B-248954
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° SHEARED 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.				SIGNAL CORPS		
558-0308-003 -		SM-C-248959 SC-DL-248775		REVIEWED <i>PME</i>		
-COLLINS NO. -		NEXT ASSY		APPROVED <i>HLV</i> <i>PME</i>		
APPLICATION			DATE <i>5 DEC 55</i>	SCALE <i>1/1</i>		