

NOTICE: THESE DIMENSIONS AND SPECIFICATIONS ARE GIVEN FOR THE PART AS SHOWN IN THIS DRAWING. THE CONTRACTOR SHALL BE RESPONSIBLE FOR THE PROPER INTERPRETATION OF THESE DIMENSIONS AND SPECIFICATIONS.

THIS DRAWING HAS BEEN FORWARDED BY THE ENGINEERING AND DATA DEVELOPMENT DIVISION IN CONNECTION WITH THE PROGRESS OF THE DEVELOPMENT OF THE EQUIPMENT DESCRIBED HEREIN.

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

Table with 4 columns: REVISIONS, DATE, APPROVAL. Includes revision numbers and descriptions.

- NOTES
1. PART MAY BE SUPPLIED BY OAK MANUFACTURING CO., CHICAGO, ILL OR EQUAL.
2. .1161D x .1870D x .031 THK PHENOLIC LT5-E-1 PER JAN-P-13. SHALL BE FUNGUS RESISTANT OR TREATED WITH FUNGUS RESISTANT MATL PER MIL-V-173, TYPE I.
3. 7/16 OD x 3/16 ID MATL #1 INDIA MICA. THICKNESS OF WASHER AVERAGE WITH VARIATION .007 TO .025.
4. PART MAY BE SUPPLIED BY CENTRAL SCREW CO., CHICAGO, ILL OR EQUAL.
5. .125 ID x .312 OD x .027 THK.
6. .147 ID x .312 OD x .032 THK.
7. NO. 8 LARGES 172 ID x .437 OD x .036 THK.
8. .203 ID x .500 OD x .060 THK.
9. PART MAY BE 1/4 HEX x 3/32 THK, DOUBLE CHAMFER, CRCS AS SUPPLIED BY PNEOLL MANUFACTURING CO., CHICAGO, ILL OR EQUAL.
10. 1/4 HEX x 3/32 THK, DOUBLE CHAMFER.
11. 3/16 HEX x 1/16 THK, DOUBLE CHAMFER.
12. PART MAY BE FLAT, 1/2 HEX x 3/32 THK, DOUBLE CHAMFER, AS SUPPLIED BY P.D. MALLORY CO., INDIANAPOLIS, INDIANA, OR EQUAL. FINISH: M352 PER SPEC MIL-F-14072.
13. PART MAY BE SUPPLIED BY PNEOLL MANUFACTURING CO., CHICAGO, ILL (PHILLIPS-CROSS-RECESSED) OR EQUAL.
14. A-40 NC-2A x 7/8 LG, PAN HEAD IN ACCORDANCE WITH BUREAU OF STANDARDS HANDBOOK H2B, PASSIVATED PROCESS E5.01 PER MIL-P-12011.
15. 5-48 NC-2A x 1/4 LG, BRASS, PAN HEAD IN ACCORDANCE WITH BUREAU OF STANDARDS HANDBOOK H2B.
16. PART MAY BE NO. 1720-02 INT LOCK FOR 3/8 SCREW, 410 STEEL, 371/391 ID x .5071, 493 OD x .022 THK AS SUPPLIED BY SHANERPROOF INC., CHICAGO, ILL OR EQUAL.
17. LIQUID STAKE SCREWS (76, 66, 70, 75) WITH VARNISH (69) #226, SUPPLIED BY GENERAL ELECTRIC CORP., SCHENECTADY, NY OR EQUAL.
18. 6 FLUTE, 8-36 NF-2B x 3/16 LG, FINISH: M262 PER SPEC MIL-F-14072.
19. SOLDER TERMINALS (33) TO BE PLACED NEAREST TOP OF CHASSIS ON BOTH SIDES OF SHIELD AS SHOWN.
20. LUBRICATE SHAFT BUSHING (21) WITH LUBRICANT (20) PER SPEC MIL-L-7870.
21. SOLDER CENTER PIN OF TUBE SOCKET (53) TO STRAP (4).
22. INSTALL SWITCH SHAFT WITH ALL ROTOR NOTCHES IN LINE.
23. REMOVE END PLAY WITH WASHERS (3).
24. ALL RETAINER RINGS TO BE ASSEMBLED WITH BURR SIDE AWAY FROM BEARING SURFACE.
25. DIMENSIONS SHOWN ON THIS DRAWING DEFINE LIMITS FOR INTERCHANGEABILITY GAGING AND ARE TO BE USED AS A BASIS FOR ACCEPTING OR REJECTION OF THE COMPLETE ASSEMBLY.
26. ALL SOFT SOLDER PER SPEC MIL-S-6872 USING FDS IN CORE SOLDER PER SPEC QQ-S-571 COMP SN 60.
27. IN ALL SPLIT BALLOONS TOP FIGURE IS MATERIAL LIST ITEM INDICATOR & BOTTOM FIGURE IS QUANTITY.
28. PART MAY BE SUPPLIED BY CENTRAL SCREW CO., CHICAGO, ILL, OR EQUAL.
29. COAT WITH VARNISH (69), PER SPEC MIL-V-173 TYPE I.
30. FINISH: P213 PER SPEC MIL-F-14072. FINAL PAINT FILM #1415, GLASS ENAMEL PER SPEC IT-C-595 TO MEET THE APPLICABLE REQUIREMENTS OF SPEC MIL-F-14072. PAINT THE ENTIRE HEAD (EXCLUDING UNDERSIDE).
\*COLLINS-580-008500.
31. ASSEMBLY SHALL BE WIRED ACCORDING TO WIRING ASSY SM-E-24904 TO PROVIDE CIRCUIT AS SHOWN ON SCHEMATIC DIAGRAM SM-J-24919.
32. FINISH: M352 PER SPEC MIL-F-14072. SCREW SHALL BE GAGED WITH A CLASS 2 BASIC 60 RING RATED PLATING.

Main parts list table with columns: QTY, PART NO., PART NO., DESCRIPTION, MATL, QTY, UNIT, SPEC, NOTES. Includes items like WASHER, SCREW, NUT, BRACKET, etc.

Continuation of parts list table with columns: QTY, PART NO., PART NO., DESCRIPTION, MATL, QTY, UNIT, SPEC, NOTES. Includes items like RING-RETAINER, NUT-LOCATING, BOLT-SHADE, etc.

COLLINS-580-008500

Table with columns: DRAWN, CHECKED, APPROVED, and other administrative fields.

Table with columns: LIST OF MATERIAL, and other administrative fields.

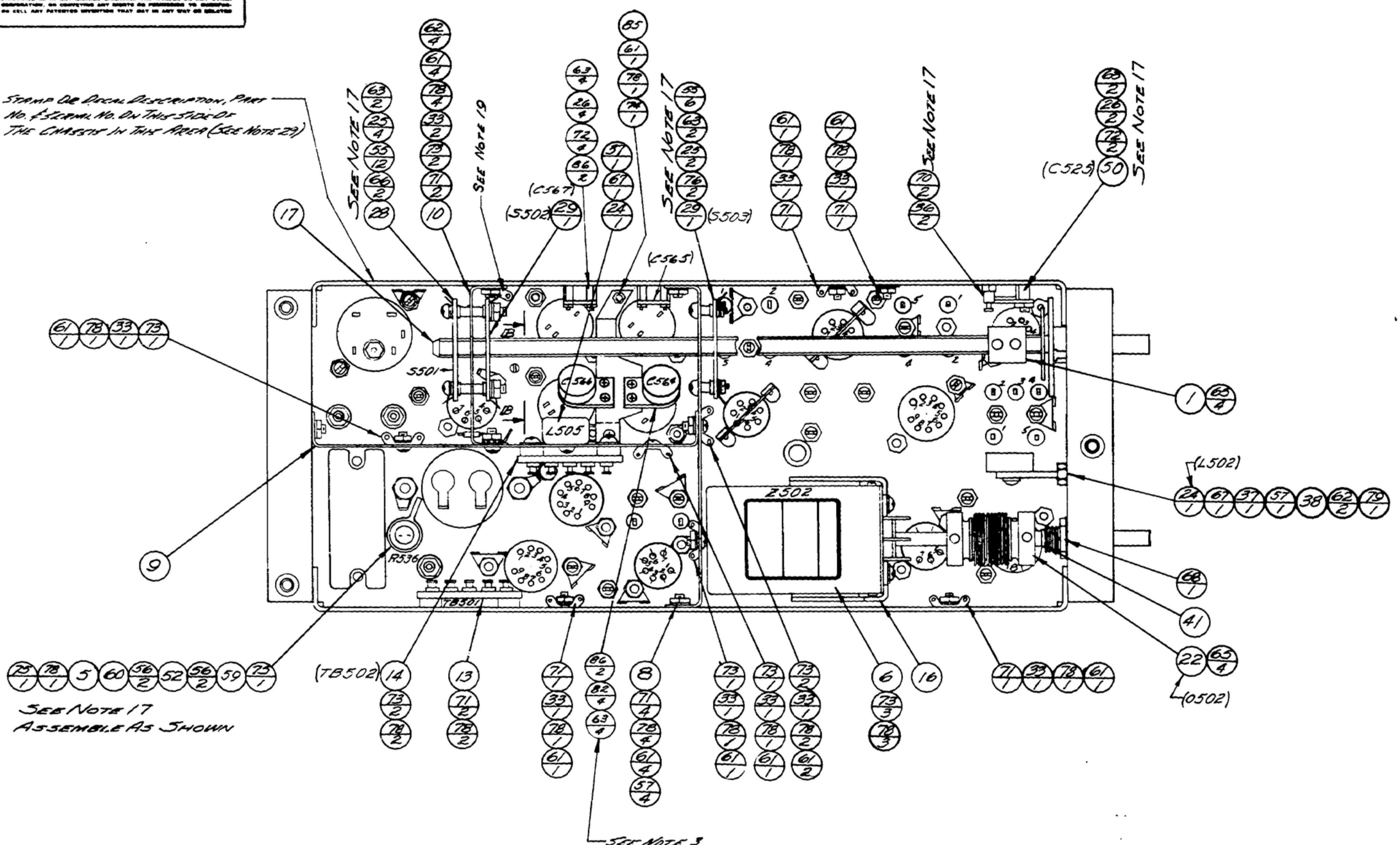
NOTICE: THESE DIMENSIONS, SPECIFICATIONS, OR OTHER DATA ARE USED FOR THE PURPOSE OF IDENTIFYING THE PARTS OF THIS DRAWING ONLY. THEY DO NOT CONSTITUTE A WARRANTY OR GUARANTEE OF THE QUALITY OF THE PARTS OR THE PERFORMANCE OF THE EQUIPMENT TO WHICH THEY ARE APPLIED. THE CONTRACTOR SHALL BE RESPONSIBLE FOR THE QUALITY OF THE PARTS AND THE PERFORMANCE OF THE EQUIPMENT TO WHICH THEY ARE APPLIED.

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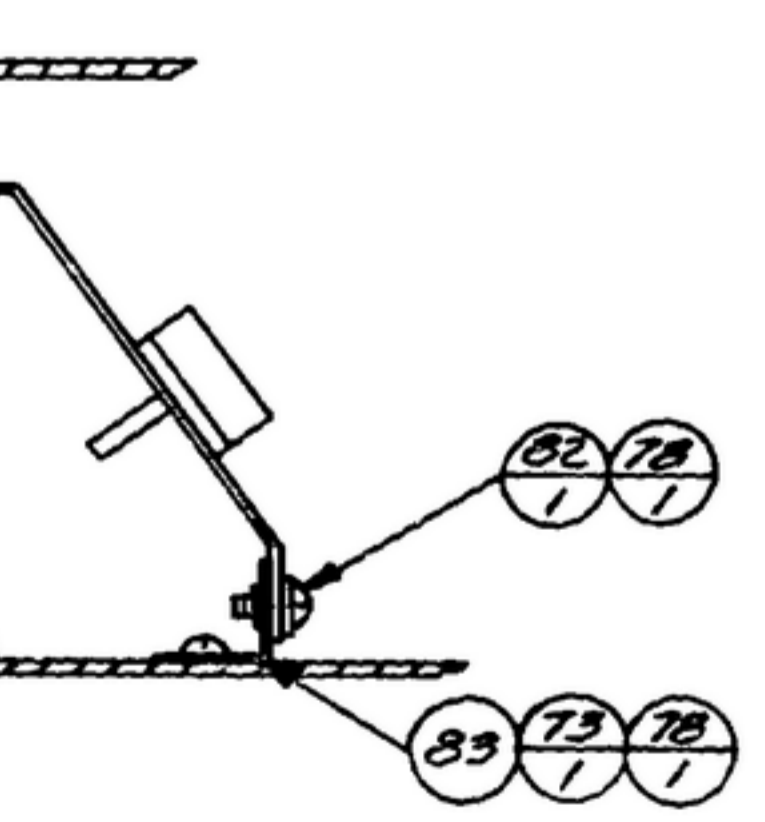
FOR INFORMATION ONLY. CONTRACTOR MAY AT HIS OPTION DEVIATE FROM THESE PROCESS DETAILS.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL

\* STAND-DE-ORCA DESCRIPTION, PART No. 132000, No. On This Side Of The Character In This Area (See Note 2)



SEE NOTE 17 ASSEMBLE AS SHOWN



VIEW B-B

QTY	DESCRIPTION	UNIT	QTY	DESCRIPTION	UNIT

DRAWN <b>JENNETT</b>	CHECKED <b>SG</b>	APPROVED  	-SIGNAL CORPS- 1A214-LFH 51-93	DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY
588-0365-003	SMC 25015 SCAS 24873	REVIEWED <b>PME</b>	APPROVED <b>HLV</b> <b>PME</b>	
APPLICATION	NEXT ARMY	USED ON	DATE <b>5 MAR 56</b>	SCALE <b>1/1</b>

MECHANICAL ASSY, I.F.

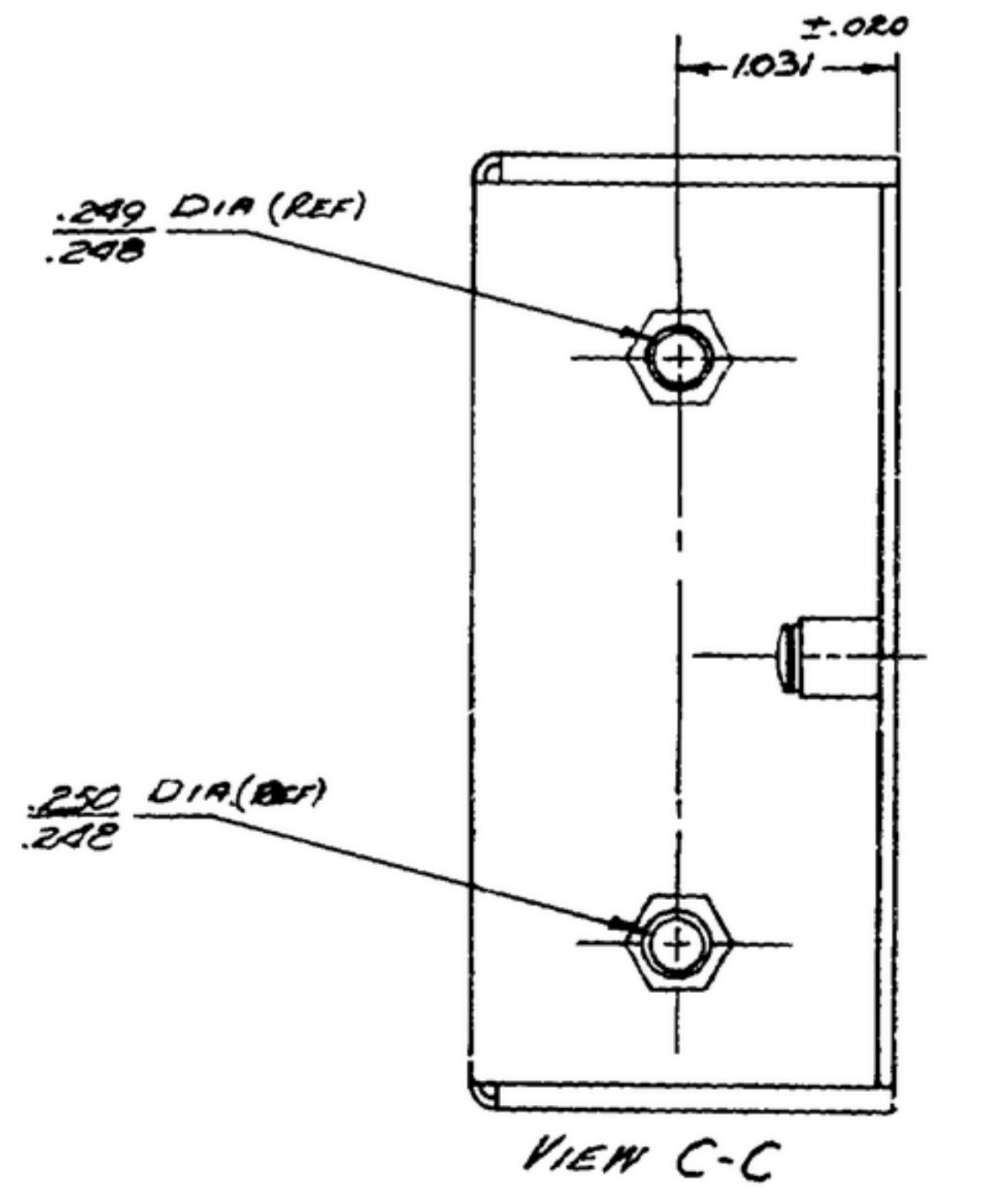
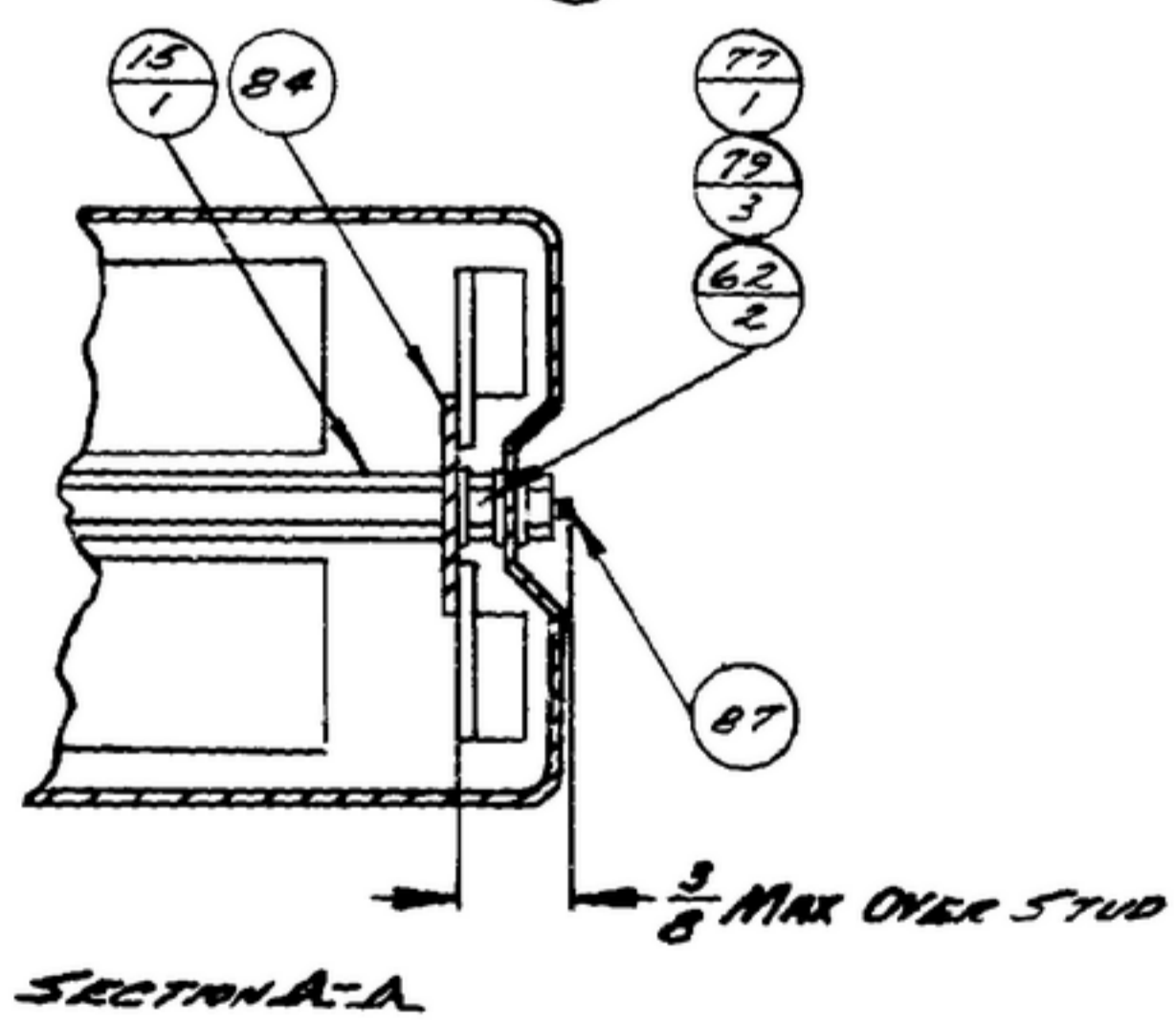
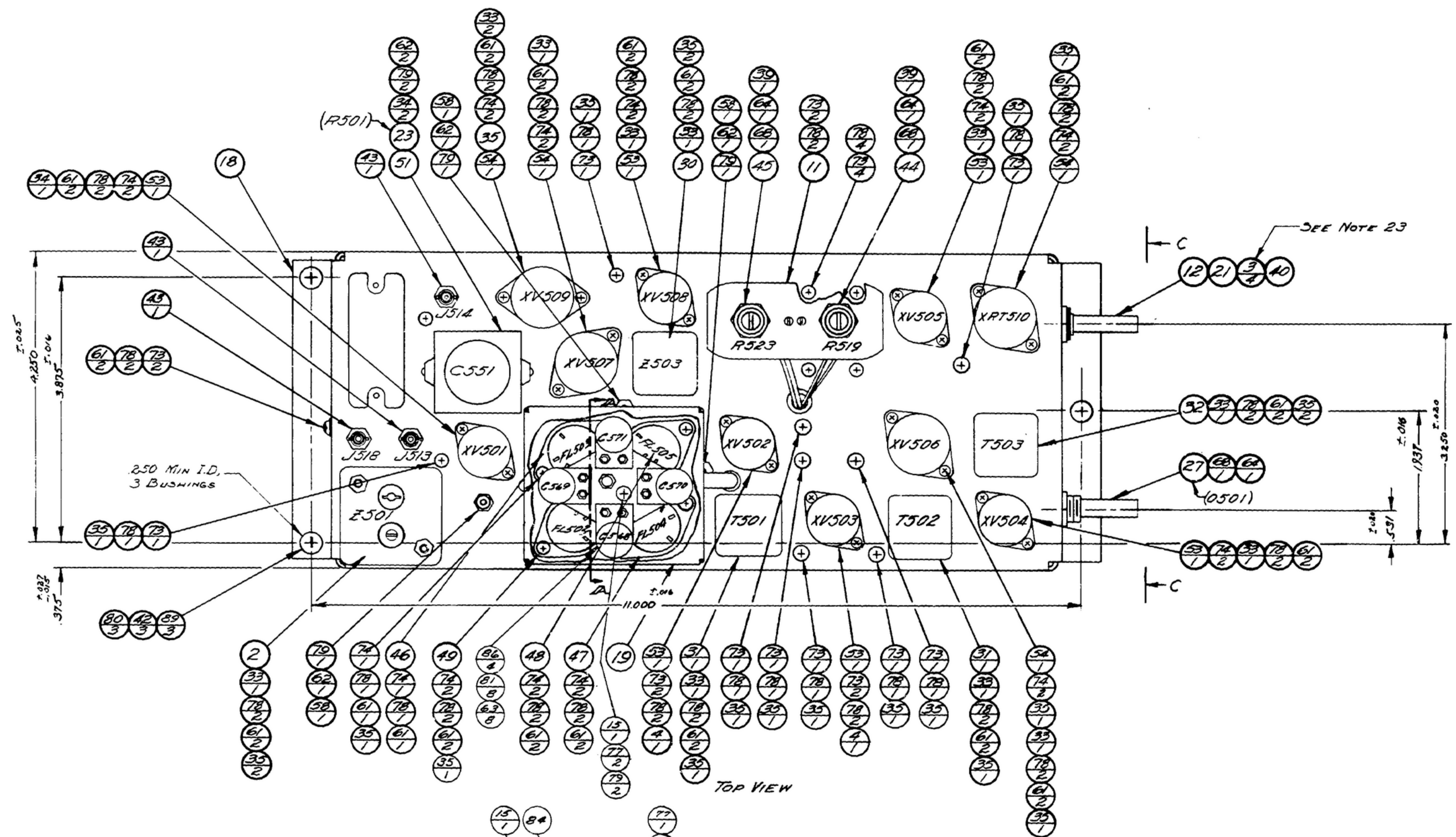
SM-D-24881B SHEET 2

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REVISIONS			
BY	DESCRIPTION	DATE	APPROVAL



TOP VIEW

SECTION A-A

VIEW C-C

DRAWN		CHECKED		APPROVED	
JENNETT		EG			
<small>UNLESS OTHERWISE SPECIFIED:            DECIMAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±.004            FRACTIONAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±1/64            MACHINED ANGLES MAY VARY ±1°            BORED ANGLES MAY VARY ±30°            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.</small>					
DRAWING NO. 532 0365 003		C.I.C. 209015		SCALE 1/1	
DATE 3 MAR 56		SCALE 1/1		DRAWING PART NO. 532 0365 003	



LIST OF MATERIAL					

DEPARTMENT OF THE ARMY  
 SIGNAL CORPS ENGINEERING LABORATORIES  
 PORT MONMOUTH NEW JERSEY  
 SM-D-246816  
 SHEET 3

MECHANICAL ASSY, IF