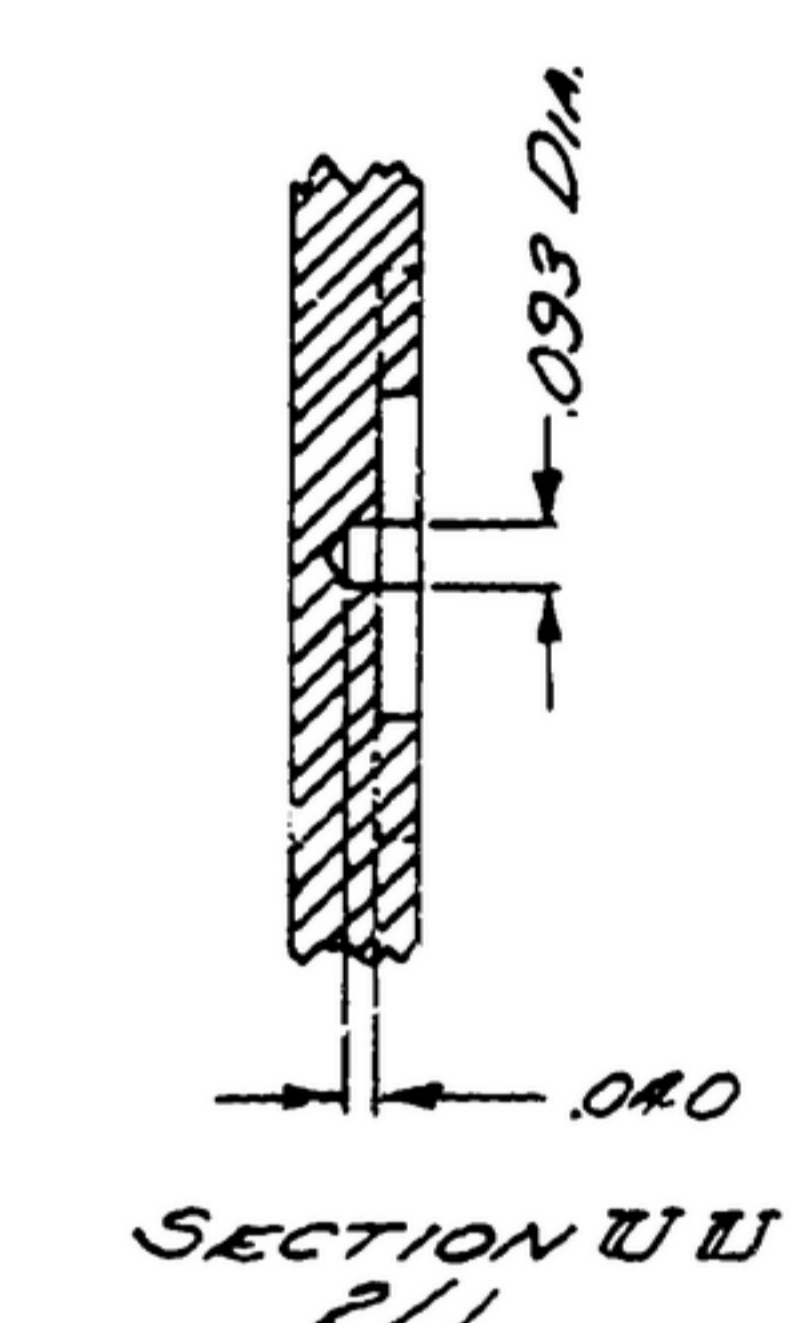
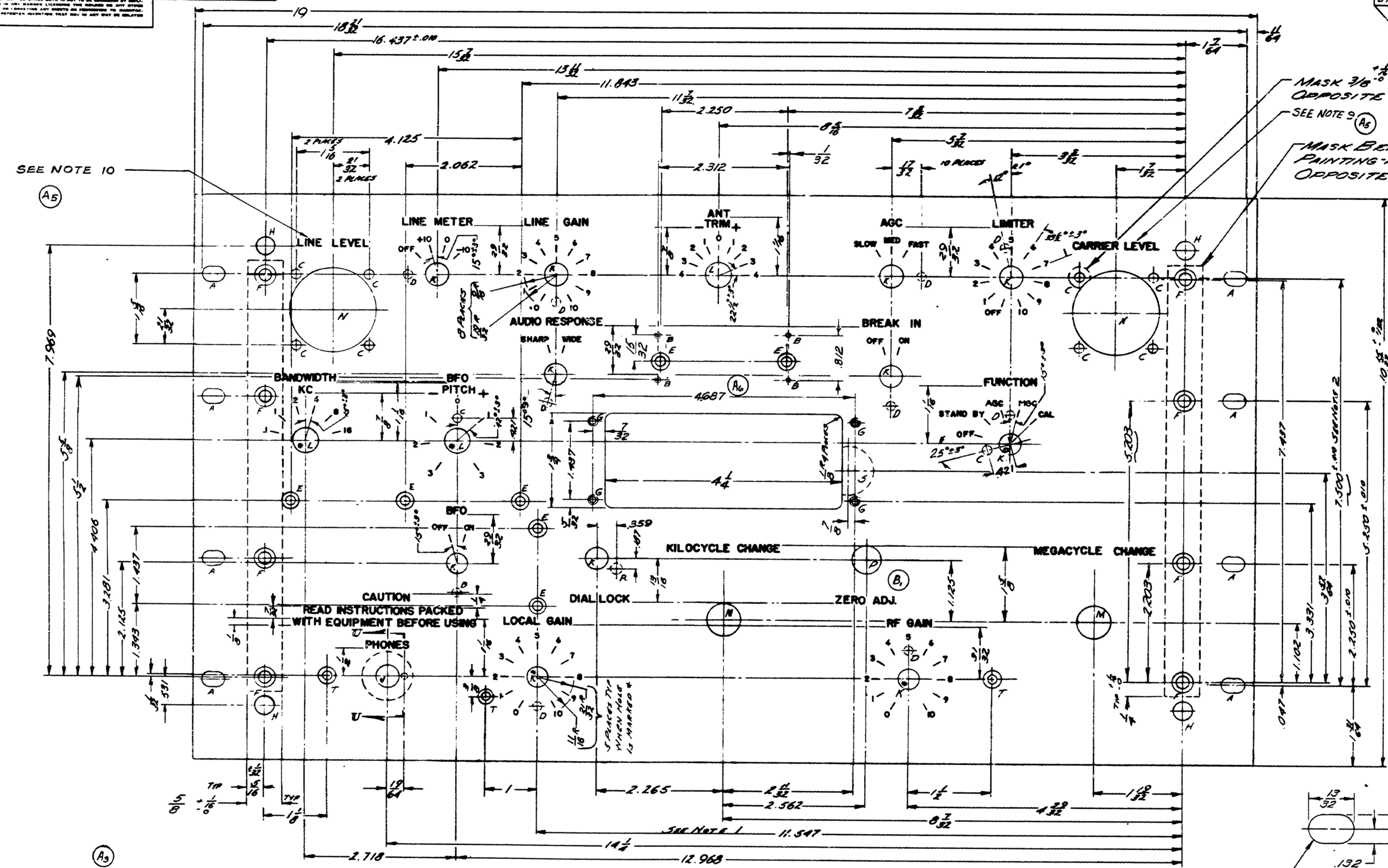


NOTE: WHEN SPECIFIED DIMENSIONS, SPECIFICATIONS, OR OTHER DATA ARE GIVEN FOR ANY PART OF THIS DRAWING IN CONNECTION WITH A PARTICULAR HOLE, THE MOST RELEVANT DIMENSION SHALL BE THE ONE WHICH GOVERN THE POSITION OF THE HOLE. THE DIMENSIONS SHALL BE GIVEN IN INCHES UNLESS OTHERWISE SPECIFIED. DIMENSIONS SHALL BE GIVEN IN DECIMALS OF AN INCH UNLESS OTHERWISE SPECIFIED. DIMENSIONS SHALL BE GIVEN IN FRACTIONS OF AN INCH UNLESS OTHERWISE SPECIFIED. DIMENSIONS SHALL BE GIVEN IN WHOLE NUMBERS UNLESS OTHERWISE SPECIFIED. DIMENSIONS SHALL BE GIVEN IN DECIMALS OF AN INCH UNLESS OTHERWISE SPECIFIED. DIMENSIONS SHALL BE GIVEN IN FRACTIONS OF AN INCH UNLESS OTHERWISE SPECIFIED. DIMENSIONS SHALL BE GIVEN IN WHOLE NUMBERS UNLESS OTHERWISE SPECIFIED.

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

REV	DESCRIPTION	DATE	APPROVAL
A7	A- REVISED NOT. 98 10 A1- W/AS P/338 ADDED (ALL SIDES) A2- W/AS 325 A3- ADDED NOTES TABULATION A4- REVISED NOTATIONS A5- CORRECT DECIMAL POINT A7- ADDED DIMENSIONS FOR SILE SCREENING	6 NOV 59	42428-PC-69 A1-51
B3	B1- ABOVE "ZERO ADJ." DELETE "C" HOLE E- .421 DIMENSION B2- IN HOLE GRAB "C" HOLE QTY. 10 UNAS QTY. 11 B3- SEE SHEET # 2.	3 MAR 60	42428-PC-69 A1-51



HOLE	SIZE	QTY	NOTE
A	SEE DETAIL A	8	
B	2.56 NC-RB	4	
C	.140 DIA.	10	
D	.140 DIA. 1/8 DEEP OPPOSITE SIDE	10	3
E	.171 DIA. C'SINK @ 82°±3° TO .343 DIA.	7	
F	.203 DIA. C'SINK @ 82°±3° TO .351 DIA.	8	
G	6-32 NC-RB	4	
H	.312 DIA.	4	
J	.390 DIA. C'BORE @ .875 DIA. 1/8 DEEP OPP. SIDE	1	3
K	.390 DIA.	11	
L	.468 DIA.	3	
M	.593 DIA.	2	
N	1.531 DIA.	2	
P	.515 DIA.	1	
R	.187±.005 DIA. 1/8 DEEP OPP. SIDE	1	3
S	SPOTFACE 7/16 R. 1/16 DEEP OPP. SIDE	1	3
T	.171 DIA. C'SINK .297 DIA. @ 82°±3°	3	

ALUMINUM ALLOY 5052, TEMPER H34, PER SPEC. QQ-A-318, .188 THICK.

FINISH: P513F PER SPEC. MIL-F-14072. (ALL SIDES)

* COLLINS 580 0080 00

- NOTES:
1. TOLERANCE APPLIES TO "E" HOLES ONLY "K" HOLES MAY VARY ± 1/64.
 2. TOLERANCE APPLIES TO SLOTTED HOLES ONLY. ALL OTHERS MAY VARY ± 1/64.
 3. WHEN DRILLING BLIND HOLES, DRILL MUST NOT BREAK THROUGH.
 4. GRADUATION MARKS ARE 9/32 LONG.
 5. PANEL MUST BE FLAT WITHIN .020 TIR.
 6. ALL SCREW THREADS PER BUREAU OF STANDARDS HANDBOOK H2B.
 7. NO TWO MARKS IN ANY ONE GROUP WILL VARY MORE THAN 5°.
 8. UNLESS OTHERWISE SPECIFIED, ALL GRADUATION MARKS ARE SPACED AT 30°±3°.
 9. CHARACTERS & INDEXING MARKS RECESSED .010 TO .015 DEEP ON FRONT OF PANEL IN ACCORDANCE WITH SPEC. MIL-M-13231, GROUP I. CHARACTERS TO BE 1/16 HIGH GOTHIC TYPE. MARKINGS TO BE FILLED WITH WHITE SEMI-GLOSS ENAMEL, COLOR CHIP #27875 PER FED. STD. 595. MARKINGS TO BE CENTRALLY LOCATED ± 1/32 UNLESS OTHERWISE SHOWN.
 10. ALL CHARACTERS TO BE 1/16 HIGH GOTHIC TYPE PER SPEC. MIL-M-13231, GROUP II. COLOR TO BE WHITE, COLOR CHIP #27875 PER FED. STD. 595. MARKINGS TO BE CENTRALLY LOCATED ± 1/32 UNLESS OTHERWISE SHOWN. COVER DESIGNATIONS WITH ONE COAT OF VARNISH PER MIL-V-173, TYPE II.

COLLINS PART NO.	QTY	REVISION	DATE	DATE SPEC.
558-0038-004	3	SM-D-24881T		
558-0032-004	2	SM-D-24881T		
558-0031-004	1	REV SM-D-24881D	SILK SCREEN FRONT PANEL	

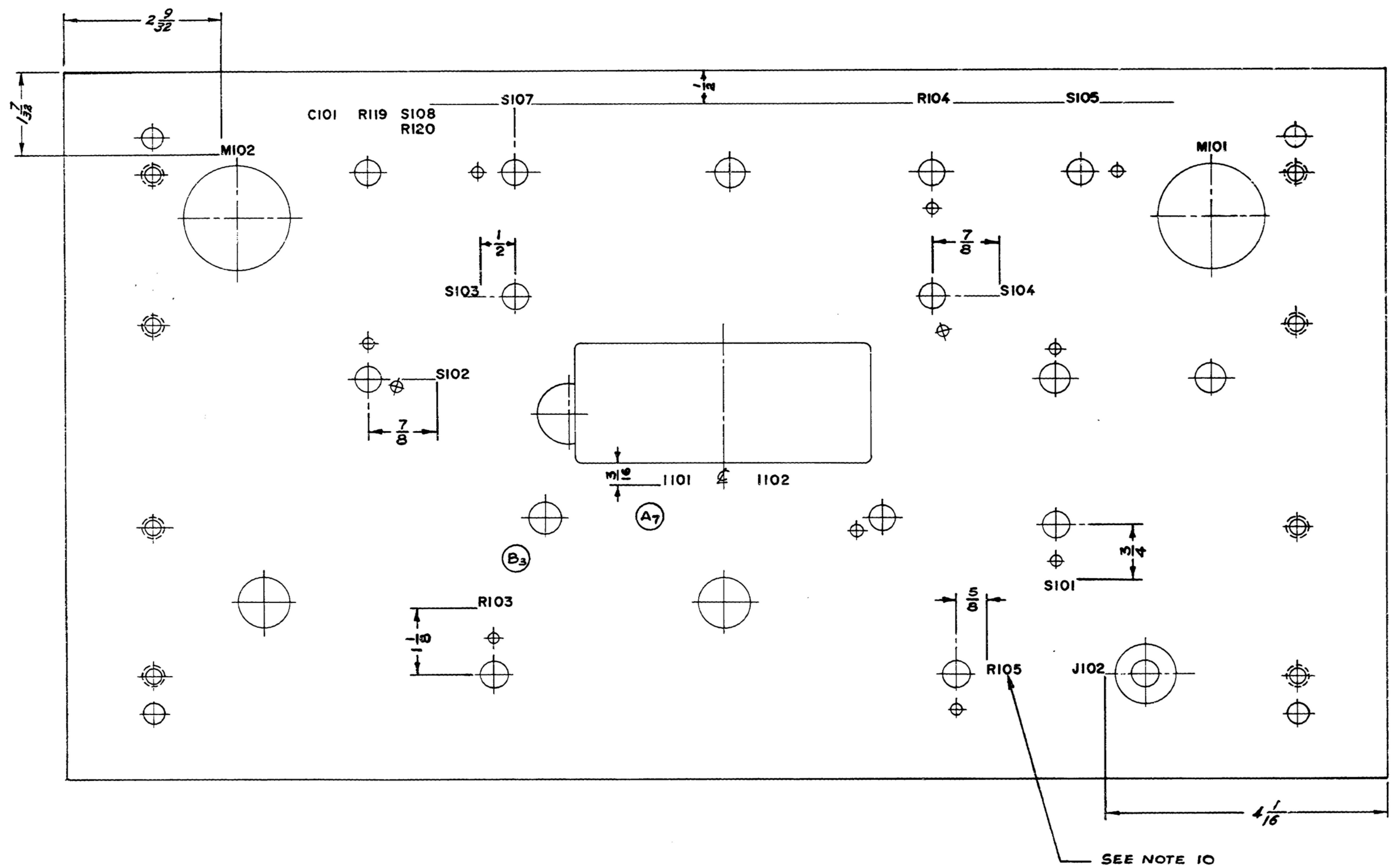
DRAWN HENRY		CHECKED Klein	APPROVED	COLLINS PART NO. 558-0038-004 REV. 14214-P.H. 51-93	DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY
UNLESS OTHERWISE SPECIFIED: DECIMAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±.005 FRACTIONAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±1/64 BREAKED ANGLES MAY VARY ±1° BROKEN ANGLES MAY VARY ±.06° ECCENTRICITY BETWEEN ANY DIAMETERS ON THE SAME CENTERLINE SHALL NOT EXCEED .010 TOTAL. PROJECTION READINGS ALL DIMENSIONS ARE UNLESS OTHERWISE SPECIFIED FINISH AND ARE GIVEN IN INCHES.		REVIEWED PME		APPROVED HLY PME	
APPLICATION		DATE 5 JAN 58		SCALE 1/1	PANEL-FRONT SM-D-283246 SHEET 1 OF 2 SHEETS

NOTICE: WHEN GOVERNMENT DRAWINGS, SPECIFICATIONS, OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A CONTRACT, THE USER ASSUMES ALL LIABILITY FOR ANY DAMAGE OR INJURY TO PERSONS OR PROPERTY, OR FOR ANY DEFECTIVE WORK, ARISING FROM THE USE OF SUCH DATA.

THIS DOCUMENT HAS BEEN PREPARED BY THE CONTRACTOR AND MAY BE SUPERSEDED AND USED IN CONNECTION WITH ANY GOVERNMENT CONTRACT WITHOUT NOTICE TO THE CONTRACTOR.

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

*SWE APPROVAL		REVISIONS		
BY	DATE	DESCRIPTION	DATE	APPROVAL
SYM PR10042 /10				
A7	6 NOV 59	SEE SHEET 1, FOR REVISIONS,		42428-PC-59 REVID.
B3	3 MAR 60	PICTORIALLY CORRECTED, 1,2 SEE SHEET 1, FOR REVISIONS		42428-PC-59 REVID. PME



QTY	DESCRIPTION	UNIT
LIST OF MATERIAL		
COLLINS PART NO. 558-0486-004		

DRAWN <i>RCHILL</i> CHECKED <i>RCH</i> APPROVED COLLINS-RAND-60-02848-0486-004 14214-PH-51-93 SIGNAL CORPS REVIEWED PME APPROVED HLY PME DATE 31 MAR 56 SCALE 1/1	DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY SM-D-283246 SHEET 2
UNLESS OTHERWISE SPECIFIED: DECIMAL DIMENSIONS INCLUDING HOLE SIZE MAY VARY ±.008 FRACTIONAL DIMENSIONS INCLUDING HOLE SIZE 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 READINGS. ALL DIMENSIONS ARE FROM DIMENSION HEADINGS UNLESS OTHERWISE SPECIFIED. FINISH AND ARE GIVEN IN INCHES.	APPLICATION 558-0486-004 - 1 SM-D-283246 SCDL-248775 COLLINS NO. QTY NEXT ASBY USED ON