

IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.  
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

RELEASED

LEGEND		
SYM	HOLE SIZE	REQ.
A	1/4 D. (.171)	6
B	1/2 D. (.500)	4
C	DRILL & C'SINK SO #4 FLAT HEAD SCREW IS 1/64 BELOW SURFACE	4
D	DRILL & COUNTERSINK FOR #6 FLAT HD. SCR.	13
E	3/16 x 1/4 SLOT	7
F	3/16 (.187)	7
G	1/8 (.125) D	1
J	1/8 (.125) D	1
K	#18 (.076) D	2

FOR CANADIAN UNITS ONLY

ON FFRD-3M ONLY

NOTE-DRILL & C'SINK ALL D HOLES SO NO. 6 FLAT HEAD SCREW IS 1/64 BELOW SURFACE.

NOTE - OUTSIDE DIMENSIONS ARE TO BE HELD WITHIN TOLERANCES SPECIFIED.

NOTE - MS-163-1 AS SHOWN. MS-163-2 FOR CANADIAN UNITS SEE DETAILS BELOW FOR ADDED HOLES.

NOTE: 1/16" INSIDE RADIUS ON ALL BENDS. ALL BENDS 90°.

BLANK SIZE 23 15/16 X 4 3/16

ISSUE	ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
J	1	S4041R101F WAS S181	12/1/52	1001	AB	EW	WJC
H	1	"J" HOLE MOVED	8/14/52	8	ES	WJC	WJC
G	1	"D" HOLE MOVED	11-10-52	7	ES	WJC	WJC
F	1	NOTE ADDED RE CANADIAN UNITS	5/14/52	6	ES	WJC	WJC
E	1	BLANK SIZE ADDED	5/14/52	5	ES	WJC	WJC
D	1	"J" HOLE ADDED	5/14/52	4	ES	WJC	WJC
C	4	G Hole Added	4/18/52	3	ES	WJC	WJC
B	2	ITEM 2 WAS SH-107-13	5/15/52	2	ES	WJC	WJC
A	1	DIM. CHANGED	7/1/52	1	WJC	WJC	WJC

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TOLERANCES		SCALE:
ALL OTHERS	DEC. DIM. ± .005 FRAC. DIM. ± 1/64 ANGULAR DIM. ± 1°	DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.

MODEL	PROJECT NO.	ASSY. NO.	DATE
1 FFRD-3M			5-6-55
1 FFRD-8	104	A-229	12-2-52
1 FFRD-7	104	A-229	12-2-52
1 FFRD-6	104	A-229	12-2-52
1 FFRD-5	104	A-229	12-2-52

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
7	2	NT-108-2	NUT, SPEED
X	1	MS-163	HEAD FRAME (NO DRAWING)
.064		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
ALUM.		HEAD FRAME	
MATERIAL		WEIGHT PER PC.	
529-H32		WJC 12/2/52	
TYPE & TEMPER		ELEC. DES. APP. MECH. DES. APP.	
HEAT TREAT. SPEC.		CHECKED	
S4041R101F		FINAL APPROVAL	
FINISH & SPEC. NO.		A-318 J	

A-318 J