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

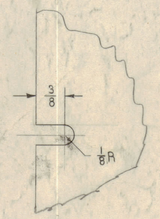
A ~ 5/32 (.156) D.	2 REQ.
B ~ 13/64 (.203) D.	4 REQ.
C ~ 13/32 (.406) D.	1 REQ.
D ~ 5/8 (.625) D.	2 REQ.
E ~ 1/4 (.250) D.	4 REQ.
F ~ SEE DETAIL	
G ~ DRILL & C'SINK FOR 6-32 FHS	4 REQ.
H ~ NO. 47 DRILL	4 REQ.
J ~ 11/64 (.172) DIA.	2 REQ.

FINISH -

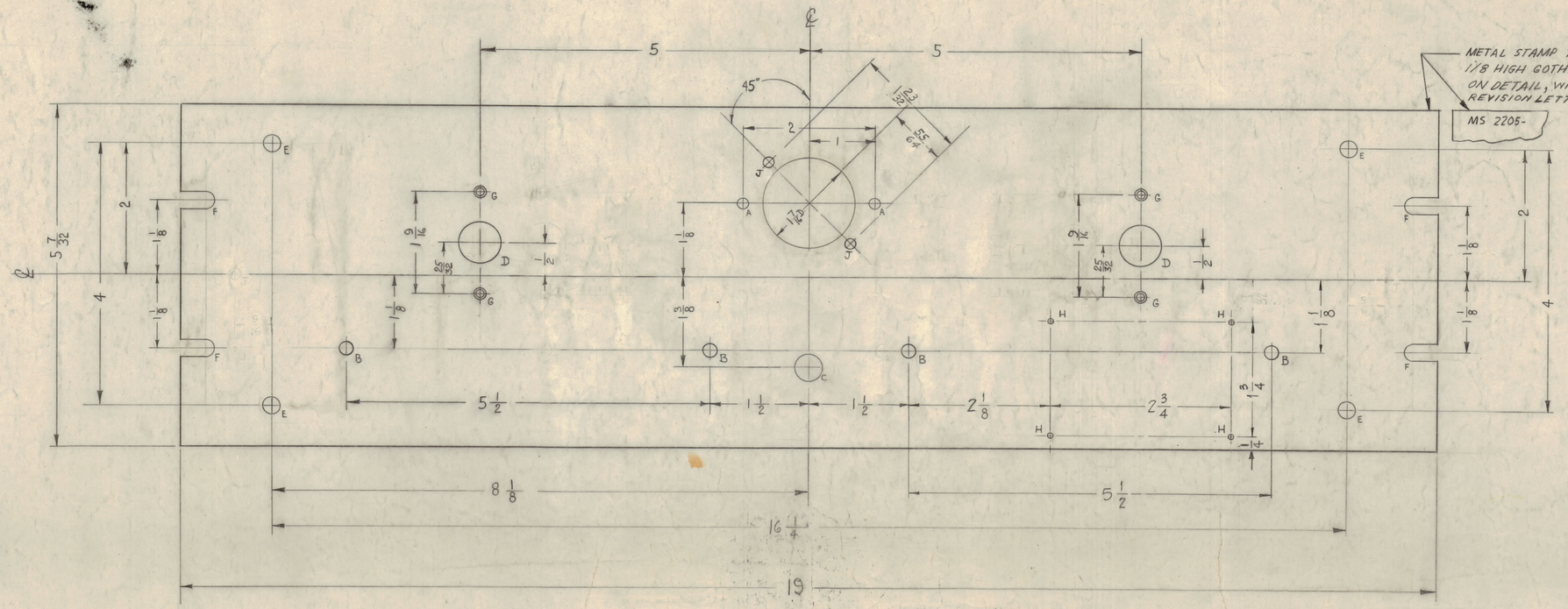
S404 - YELLOW IRIDITE
S114 - ZINC CHROMATE PRIMER
S115 - TMC SMOOTH GREY ENAMEL
OR PPIME & PAINT TO CUST. SPEC. } FRONT & EDGES ONLY

MACHINING

1 - LATERAL BOW OF PANEL MUST BE KEPT TO .031 TOL.
2 - MILL ALL EDGES
3 - HOLES MUST BE DRILLED
4 - PANEL MUST BE FREE OF ALL MACHINING MARKS, GOUGES, AND SCRATCHES. IF NECESSARY, SAND FRONT OF PANEL WITH NO. 120 GRIT SANDPAPER.



"F" DETAIL
4 REQ.



FRONT VIEW SHOWN

METAL STAMP TMC PART NO., 1/8 HIGH GOTHIC, AS SHOWN ON DETAIL, WITH LATEST REVISION LETTER, ON REAR OF PANEL

MS 2205-

MS 2205 D

NOTICE TO PERSONS RECEIVING THIS DRAWING

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THE TECHNICAL MATERIEL CORPORATION
MAMARONECK, NEW YORK

REF ~ ENGRAVING, TMC NO. LD-732

ISSUE	ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
D		12 #32 HOLES 1/4 & 5/64 HOLES 4 #8 DELETED 4 #4 HOLES BUSHED & 3 #4 HOLES	3-17-67	17985	L.A.K.		
C	1	2 J HOLES 3/16 DIA. DELETED	10/26/61	5767	wh	RU	
B	1	2 Ⓓ Holes Added	2-14-61	4027	RU		
A	1	Ⓗ Holes Added	11-30-60		U.C.S.		

TOLERANCES

ALL OTHERS: DEC. DIM. ± ; FRAC. DIM. ± 1/64 ; ANGULAR DIM. ±

SCALE: FULL

DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.

REQ PER UNIT	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
1	CLL-1			2-2-60

USED ON

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
		3/16	THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
		STOCK SIZE		
		ALUMINUM	FRONT PANEL MACHINING	
		MATERIAL / WEIGHT PER PC.	CLL-1	
		2024-T3		
		TYPE & TEMPER	DRAWN / ELEC. DES. APP. / MECH. DES. APP.	
			CHECKED / FINAL APPROVAL	
		HEAT TREAT. SPEC.	MS 2205 D	
		SEE NOTE		
		FINISH & SPEC. NO.		

FORM—111