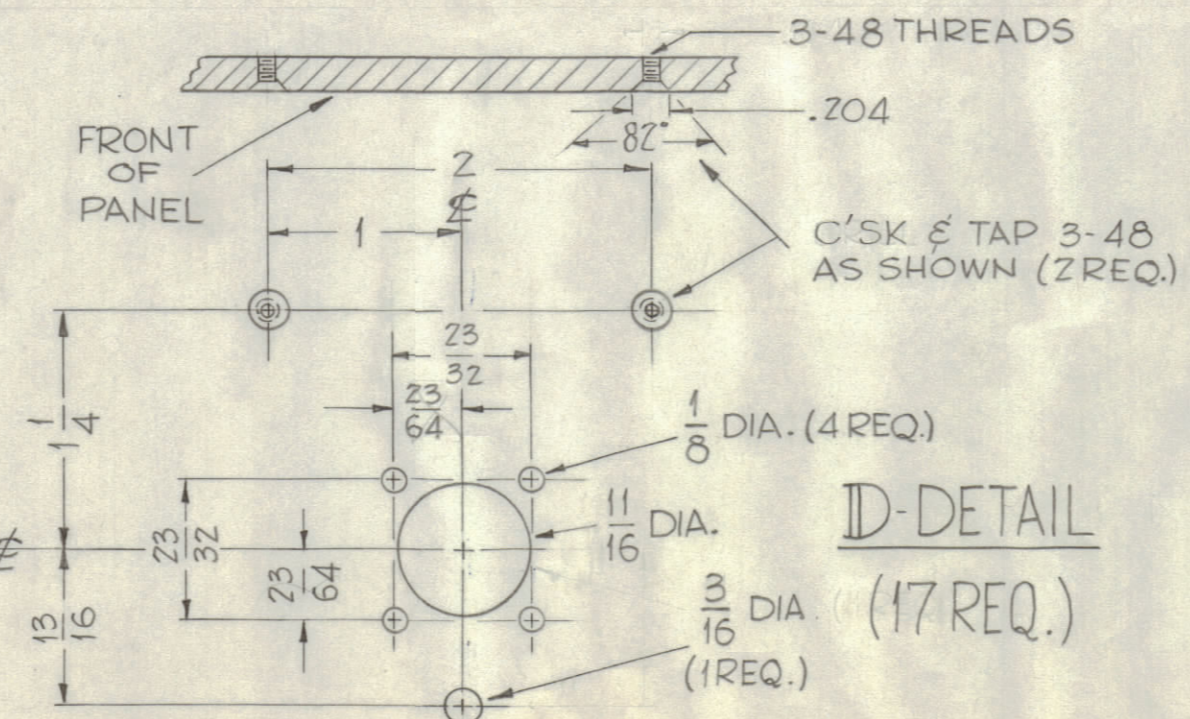


MS-2420

- HOLES ~
- A ~ DRILL & TAP 6-32 THRU 12 Req.
  - B ~ 17/64 DIA. 5 Req.
  - C ~ 9/64 DIA. 8 Req.
  - E ~ NO. 47 DRILL 4 Req.



**MACHINING** ~

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

**FINISH** ~

- S404 - YELLOW IRIDITE
- S114 - ZINC CHROMATE PRIMER } FRONT & EDGES ONLY.
- S115 - TMC SMOOTH GREY ENAMEL }

ORIGINAL RELEASE FOR PRODUCTION		DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
ISSUE ZONE		DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER
TOLERANCES		SCALE: FULL - DO NOT SCALE				
DEC. DIM. ± 1/64						
FRAC. DIM. ± 1/64						
ANGULAR DIM. ±						
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES						

REQ. PER UNIT	MODEL	SECTION	ASSY. NO.	DATE
1	QDP-6S17			9-20-60
USED ON				

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
3/16 THICK		THE TECHNICAL MATERIEL CORP.	
STOCK SIZE		MAMARONECK, NEW YORK	
ALUMINUM		PANEL, FRONT	
MATERIAL		(MODEL QDP-6S17)	
2024 - T3		John C. Biele	
TYPE & TEMPER		DRAWN	
		ELEC. DES. APP.	
		MECH. DES. APP.	
		CHECKED	
		FINAL APPROVAL	
		SEE NOTES	
		FINISH & SPEC. NO.	