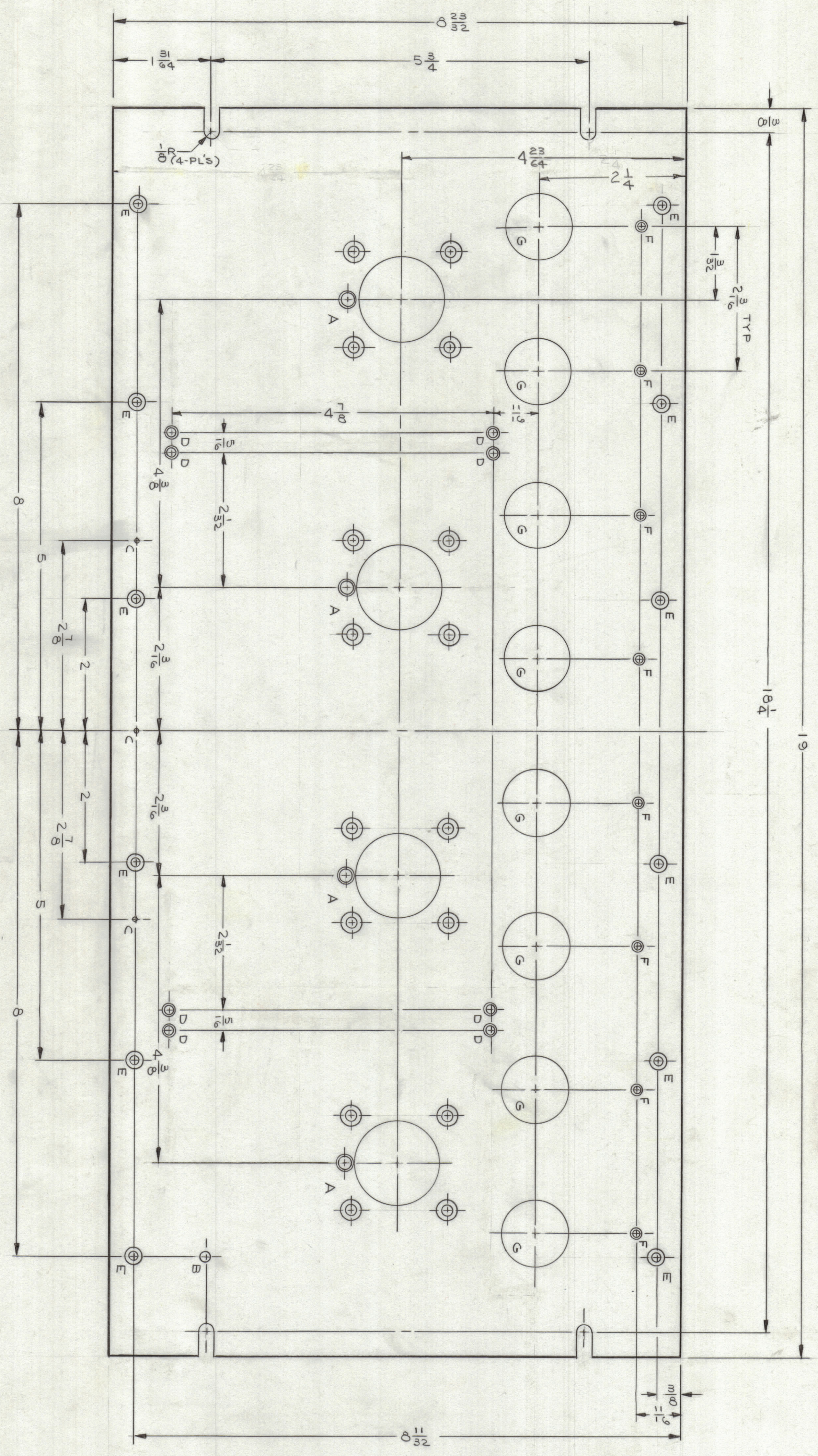
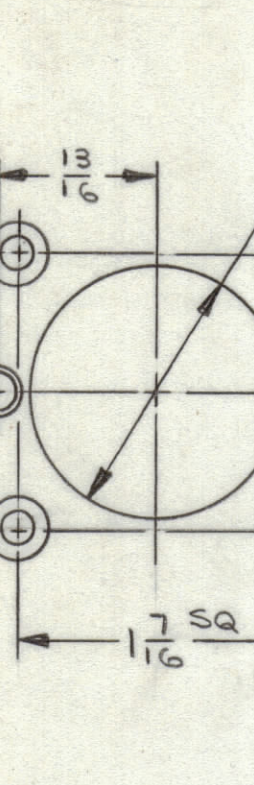


ZONE	REV	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPR.
1	1	ORIGINAL RELEASE PER FEED	7/16				



HOLE	DESCRIPTION	REQ'D
A	SEE DETAIL	4
B	13/64 DIA	1
C	.078 DIA	3
D	.130 DIA & C/SINK 82° X .230 DIA (#4 FHMS)	8
E	.144 DIA & C/SINK 82° X .254 DIA (#6 FHMS)	12
F	.104 DIA & C/SINK 82° X .204 DIA (#5 FHMS)	8
G	1" DIA	8

1.96 DIA & C/SINK 82°
X .330 DIA (#10 FHMS)
(4-PL'S)



MACHINING:

1. MILL ALL EDGES.
2. HOLES MUST BE DRILLED, UNLESS OTHERWISE SPECIFIED.
3. LATERAL BOW OF PANEL MUST BE .002 O.D. TOLERANCE.
4. PANEL MUST BE FREE OF ALL MACHINING MARKS, COUGES AND SCRATCHES. IF NECESSARY, SAND FRONT OF PANEL WITH NO. 120 GRIT SANDPAPER.

FINISH NOTES:

1. S404 - IRIDITE 14-2 AL-COAT. FRONT AND EDGES ONLY
2. S114 - ZINC CHROMATE PRIMER
3. S115 - SMOOTH GRAY ENAMEL

NOTES

THE CONTENT OF THIS DRAWING AND THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIAL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.

QTY/UNIT	1	QDP-9E254A	ASSY. NO.
SCALE	1/1	MODEL USED ON	

REV.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
4	1	BB115	BEARING, OILITE	

DATE	BY	CHKD	APPR.
7/18/66	JL		
7/16/66			
7/16/66			

DATE	BY	CHKD	APPR.
7/16/66			
7/16/66			