

REVISIONS							
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
	Ø	ORIGINAL RELEASE FOR PRODUCTION	4-21-65		HCA		
A		SIDE VIEW, NOTE 4, 4 IT, 1 ADDED.	4-29-65	13990	2F.		JIS/LL

**MACHINING:**

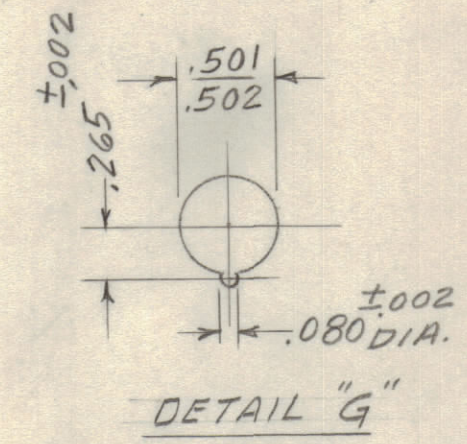
- MILL ALL EDGES.
- HOLES MUST BE DRILLED, UNLESS OTHERWISE SPECIFIED.
- LATERAL BOW OF PANEL MUST BE KEPT TO .031 TOLERANCE.
- PANEL MUST BE FREE OF ALL MACHINING MARKS, GOUGES AND SCRATCHES. IF NECESSARY, SAND FRONT OF PANEL WITH NO. 120 GRIT SANDPAPER.

**FINISH NOTES:**

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

PRIME AND PAINT PER CUSTOMER'S SPECIFICATIONS.

4. MOUNT ITEM 1 AFTER FINISHING

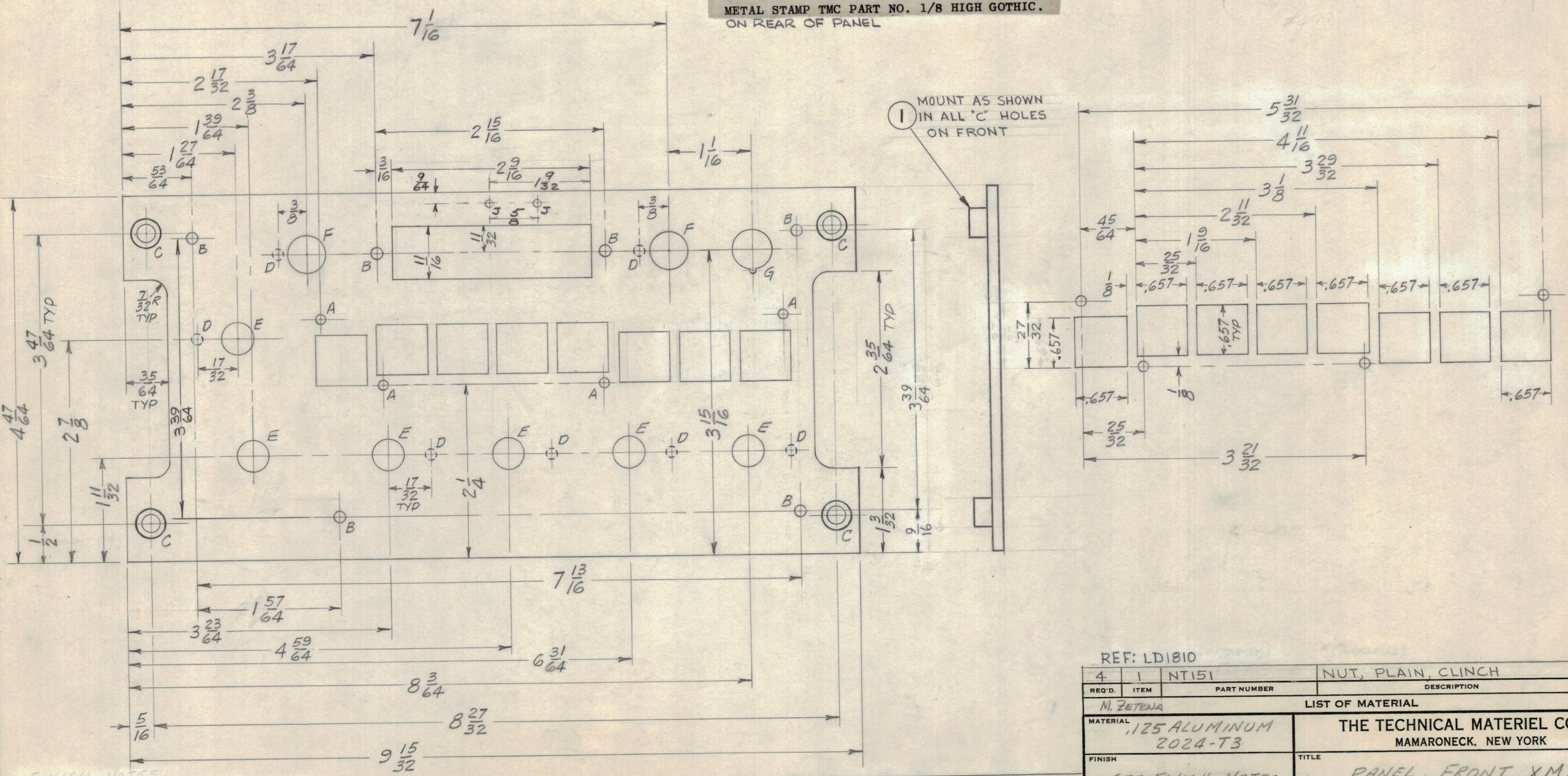


HOLE LEGEND

LETTER	DESCRIPTION	QUANTITY
A	.125 DIA	4
B	5/32 DIA	6
C	.250 DIA. & .375 DIA. C BORE 1/32 DEEP ON REAR	4
D	5/32 DIA. x 1/16 DEEP ON REAR	7
E	13/32 DIA	5
F	1/2 DIA	2
G	SEE DETAIL	1
H	3/8 DIA	1
J	#47 DRILL (.078 DIA.)	2

METAL STAMP TMC PART NO. 1/8 HIGH GOTHIC. ON REAR OF PANEL

1 MOUNT AS SHOWN IN ALL "C" HOLES ON FRONT



**FINISH NOTES**

- S404 - IRIDITE 14-2 AL COAT
- S114 - ZINC CHROMATE PRIMER
- S115 - GREEN #24325 AS PER FEDERAL STANDARDS #595 (FRONT AND EDGES ONLY)

NOTES

QTY./UNIT	MODEL USED ON	ASSY. NO.
	LRCM-1	AX568
SCALE	CODE	

REF: LD1810

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
4	1	NT151	NUT, PLAIN, CLINCH	

M. ZETENA

MATERIAL	TITLE
1125 ALUMINUM 2024-T3	PANEL, FRONT, XMTR

THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK

DRAWN	DATE	FINAL APPROVAL	DATE
H. Austin	4/20/65	M. Zetena	4/20/65

ELECT. DES.	DATE	MECH. DES.	DATE
	4/22/65		4-22-65

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES

TOLERANCES

DECIMALS	FRACTIONS
.X ± .05	± 1/64
.XX ± .01	ANGLES ± 0° 30'
.XXX ± .005	

MS4522 A

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