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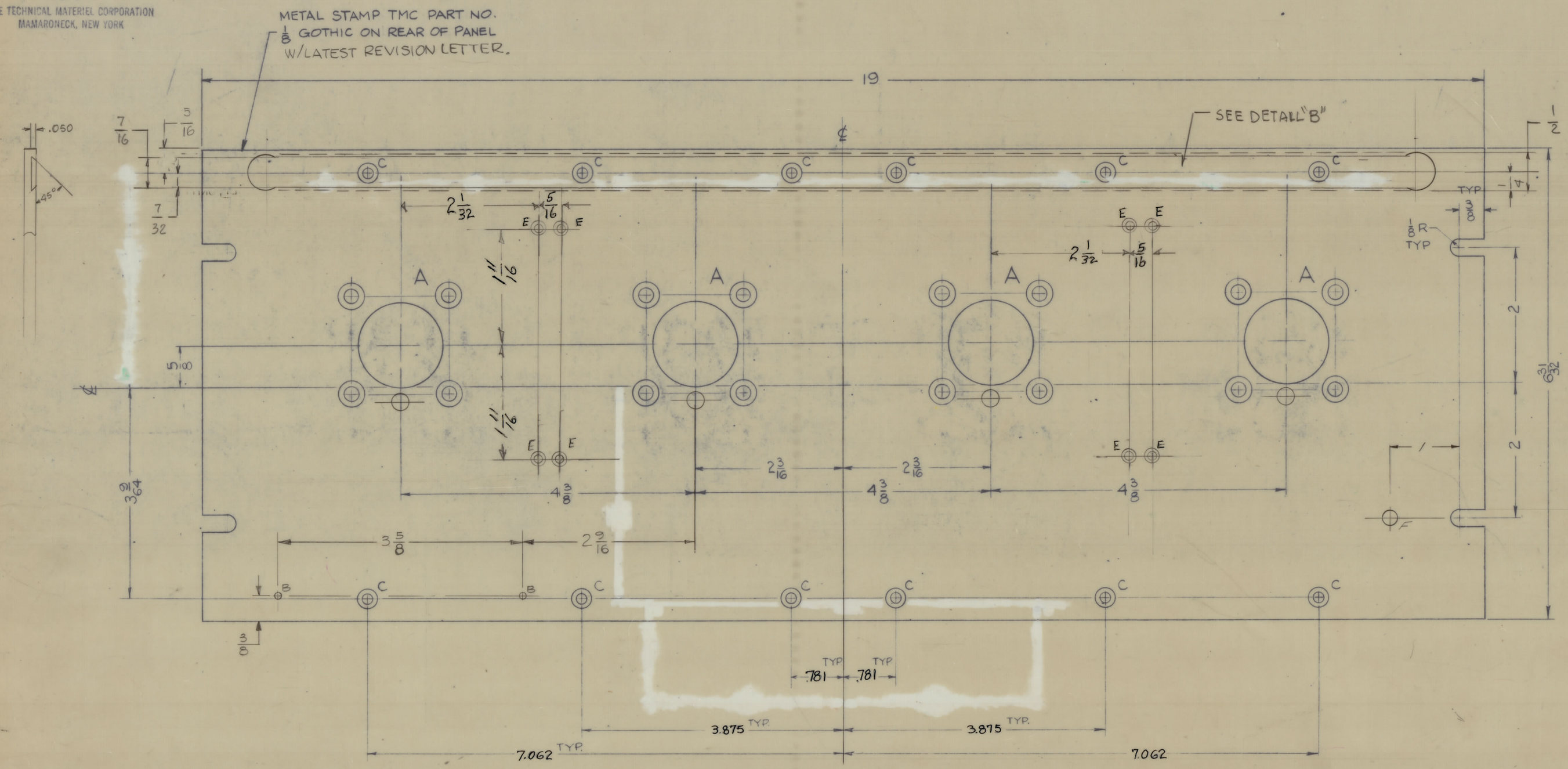
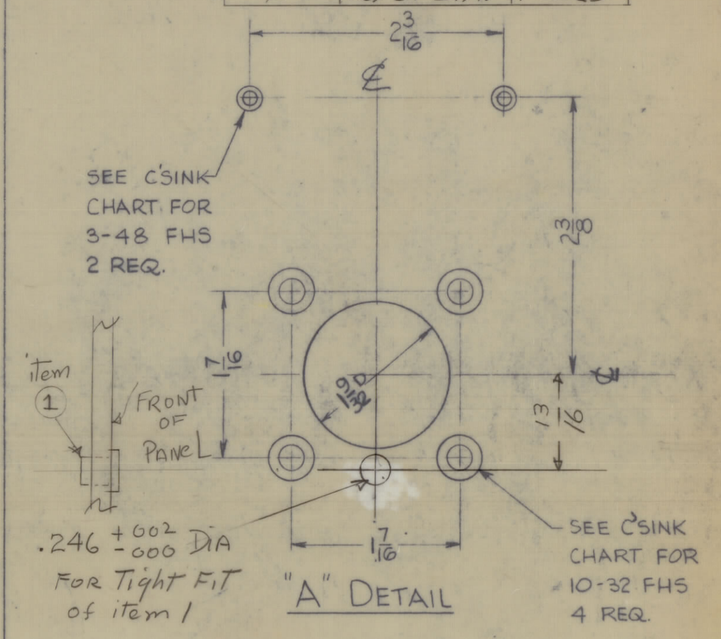
MAMARONECK, NEW YORK



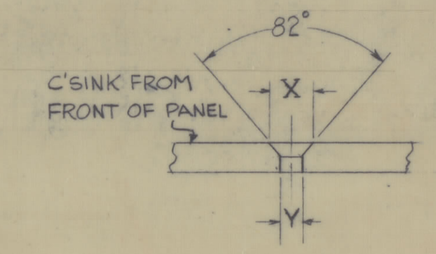
FRONT OF PANEL SHOWN

LEGEND

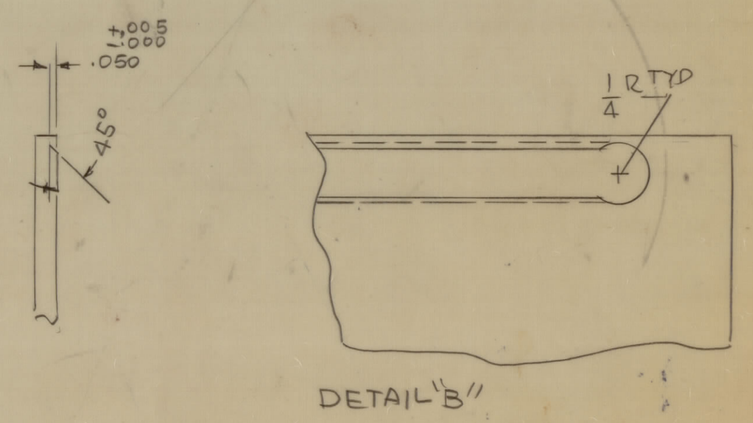
HOLE	DESCRIPTION	QUAN.
A	SEE DETAIL	4 REQD.
B	.078 DRILL	2 REQD
C	SEE CHART	12 REQD
D	13/64 DIA.	1 REQD
E	SEE CHART	8 REQD
F	13/64 DIA.	1 REQD



"A" DETAIL



HOLES	SCREW TYPE	X	Y
"A" DETAIL	10-32	.400 .410	.196
C	6-32 FHS	.294 .304	.144
E	4-40 FHS	.230	.120



DETAIL "B"

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

FINISH
S404 - YELLOW IRIDITE
S114 - ZINC CHROMATE PRIMER } FRONT & EDGES ONLY
S115 - TMC SMOOTH GREY ENAMEL }
OR
PRIME & PAINT PER CUSTOMER.

SYM	ZONE	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
C		8 "A" HOLES FOR .0348 THD. DEL. 6 C HOLES ON TOP RELOCATED SLOT 17" X 1/2 ADDED	4-10-84	22053	GDL		
B		RELOCATE 2 "B" HOLES-DELE 1	7/3/78	21663	WBB		
A	A	ADDED 1 (F) HOLE	6/3/69	19475	GE		
Ø		ORIGINAL RELEASE FOR PRODUCTION	3-9-66		HCA		

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES ON
FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± 1/2°

SCALE

MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.
REMOVE ALL BURRS & SHARP EDGES

Notes

REQ. PER UNIT	MODEL	SECTION	ASS'Y. NO.	DATE
1	QDP-E1A51625D2S4			3-2-66

USED ON

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
4	1	BB-115	BEARING OILITE, MARTINENGO	

3/16 THICK — STOCK SIZE
ALUMINUM — MATERIAL
2024-T3 — TYPE & TEMPER; HEAT TREAT. SPEC.
SEE NOTE — FINISH & SPEC. NO.

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK
PANEL, FRONT, MACHINING

DRAWN: [signature] CHECKED: [signature] FINAL APPROVAL: OCTAVIO [signature]
ELEC. DES. APP.: [signature] MECH. DES. APP.: [signature] SHEET: MS-4886 OF C

MS 4886 C

TMC FORM NO. 111

ML 3/9/66