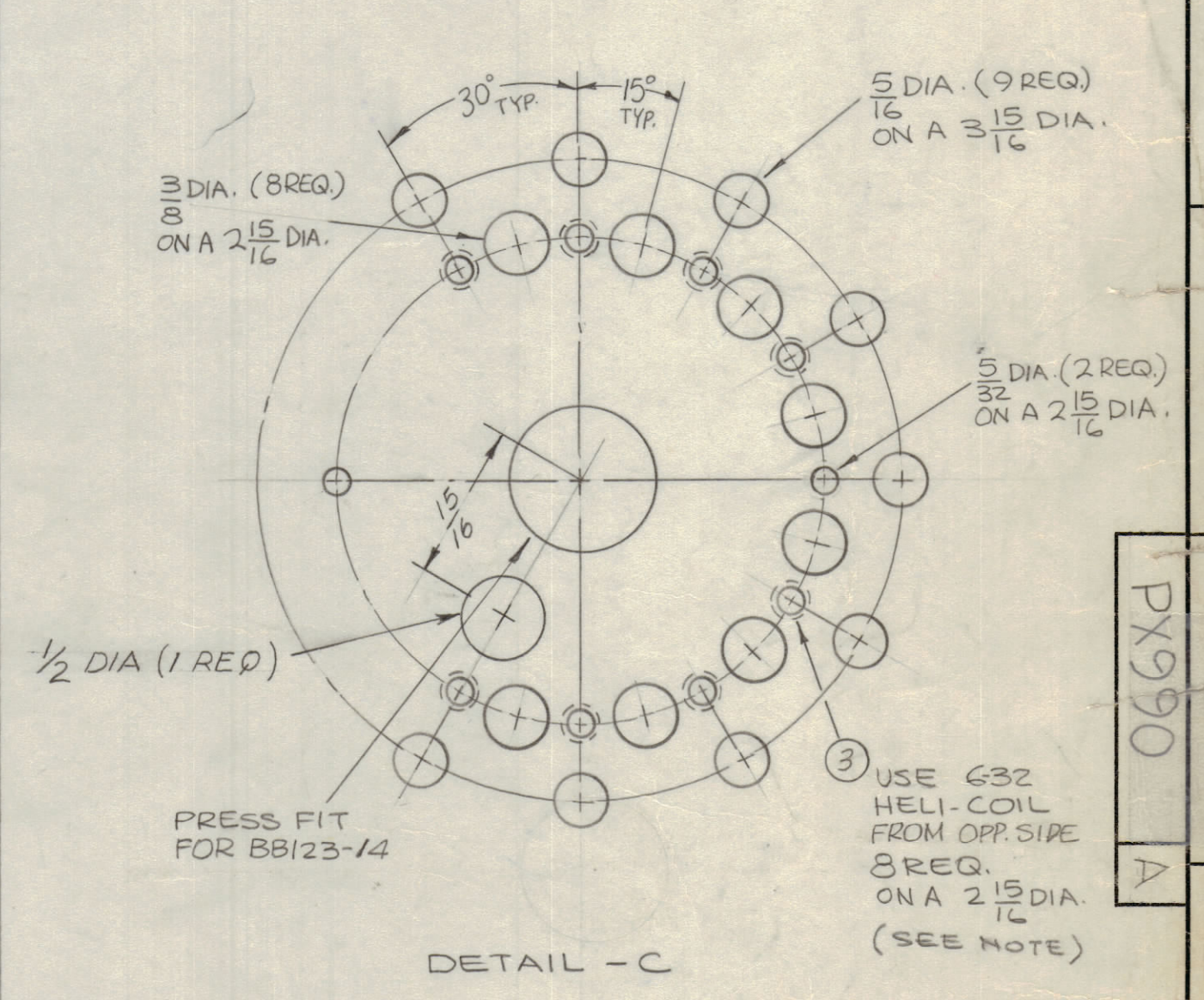
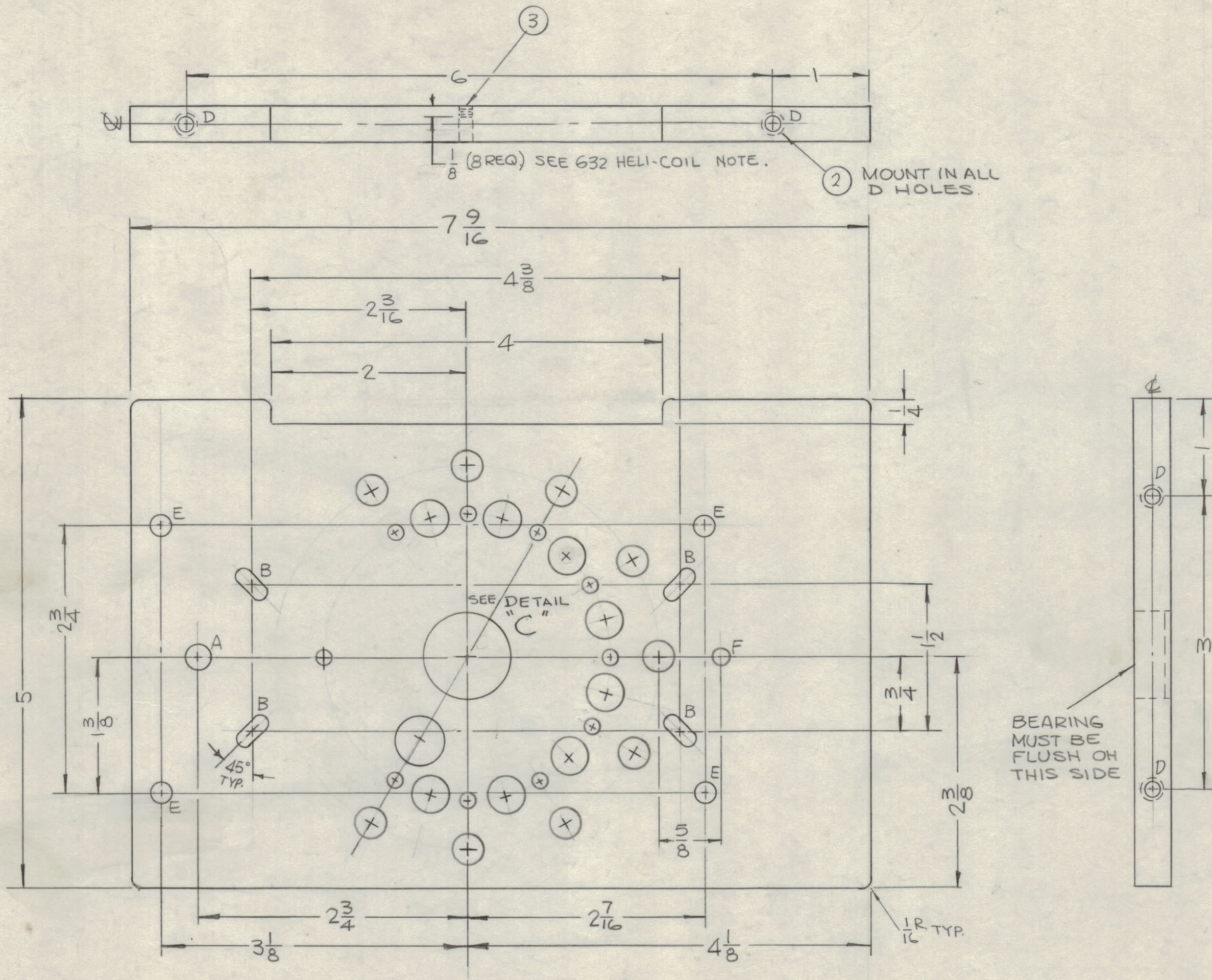


REVISIONS							
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
X6		6-32 HELICOIL WAS 440	11-18-66	X6	RME		228
Ø		ORIGINAL RELEASE FOR PRODUCTION	11-18-66	Ø	RME		
A		ADDED 1/2" HOLE 15/16" FROM CENTER	2769	19246	GE	JLD	FB



HOLE	DESCRIPTION	REQ.
A	1/4 DIA.	1
B	5/32 X 3/8 SLOT	4
C	SEE DETAIL	1
D	SEE HELICOIL 8-32	4
E	13/64 DIA.	4
F	11/64 DIA.	1

HELICOIL PROCEDURE FOR 8-32
 1-DRILL #16 (.174) TO .500 MIN DEPTH
 2-120° C'SINK .20-.23 DIA.
 3-TAP .360 MIN. DEPTH. USE HELICOIL TAP #2CPA
 4-INSTALL ITEM 2 3/4 TO 1-1/2 PITCH BELOW SURFACE
 5-BREAK OFF DRIVING TANG.

HELICOIL PROCEDURE FOR 6-32
 1-DRILL #25 (.149) TO .379 MIN. DEPTH.
 2-120° COUNTERSINK .17-.20 DIAMETER
 3-TAP .240 MIN. DEPTH, USE HELICOIL TAP #06CPA
 4-INSTALL ITEM 3 3/4 TO 1-1/2 PITCH BELOW SURFACE
 5-BREAK OFF DRIVING TANG.

NOTES
 THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.

REF: LD 2123-

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
8	3	NT139SC06-15	INSERT, SCREW THREAD	C DETAIL
4	2	NT139SC0825	INSERT, SCREW THREAD	D
1	1	BB123-14	BEARING CYLINDRICAL	C

F. BUDETTI		LIST OF MATERIAL	
MATERIAL 3/8 THICK SUPRA-MICA 500		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
FINISH NATURAL		TITLE WAFER, SWITCH PI SECTION	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN 8-23-66	DATE 11/11/66
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		CHECKED 9/25	DATE 11/11/66
FRACTIONS ± 1/64 ANGLES ± 0° 30'		ELECT. DES. 11/11/66	DATE 11/11/66
TOLERANCES		MECH. DES. 11/11/66	DATE 11/11/66
		FINAL APPROVAL PX990	DATE 11/11/66
		SHEET	REV. LTR.

QTY./UNIT	MODEL USED ON	ASS'Y. NO.
1	TLAA-25K	AS128
SCALE 1:1	CODE A	

PX990
A