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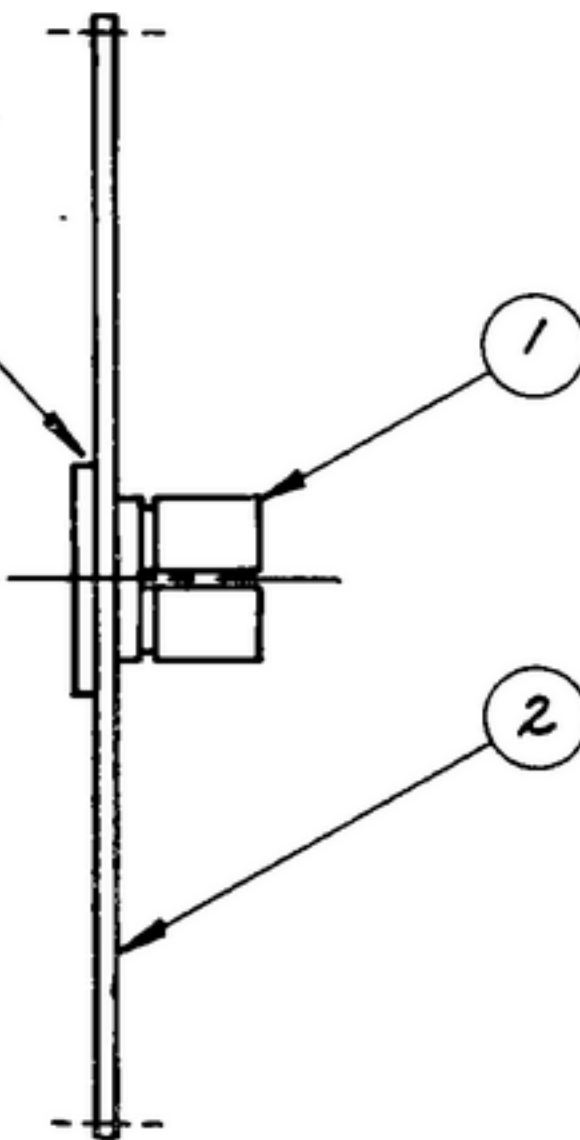
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REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
* S.W.E. APPROVAL			
SYM PR10042-5	A₁-NOTE 1 WAS "SOLDER CLASS 4 OR 6, USING FLUX PER SPEC 51F4 A₂-ADDED APPL; SM-D-343600 A₃-ADDED ITEMS 3 & 4	9 OCT 59	42428-PC-59 -A1-51 REF'D PME
B₁ CA84781	B₁-10S11330-7 WAS 10S130020	17 MAY 60	42428-PC-59 REF'D PME

FLOW UNIFORM FILLET OF SILVER SOLDER. THIS SIDE ONLY



FINISH: E300 PER SPEC 580 0025 00
~~* COLLINS 580 0025 00~~

- NOTES:
- (A₁) 1. SILVER SOLDER TO BE PER SPEC QQ-S-561, CLASS 4 USING FLUX PER SPEC O-F-499.
 - 2. WOBBLE AT 1 R SHALL NOT EXCEED .008 TIR.
 - 3. MAXIMUM .008 DISH TIR PERMISSIBLE ON GEAR ONLY WHEN CONVEX SIDE IS TOWARD SLOTTED END OF HUB.
 - 4. PRESS GEAR ON HUB WITH C'SUNK SIDE OF GEAR SNUG AGAINST SHOULDER OF HUB.

S.W.E. PART NO.	ITEM	REQD	PART NO.	DESCRIPTION	MATL	MATL SPEC	NOTES
10S130298	4	AS REQ'D		FLUX			1
10S11330-7	3	AS REQ'D		SOLDER, SILVER			1
	2	1	SM-B-248901	GEAR - SPUR			
	1	1	SM-B-178950	HUB			

LIST OF MATERIAL

~~COLLINS PART NO. 558 0293 002~~

DRAWN <i>Hamer</i>				CHECKED <i>Don</i>		APPROVED		COLLINS RADIO CO. CEDAR RAPIDS, IOWA 14214-PH-51-93		DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY	
UNLESS OTHERWISE SPECIFIED: DECIMAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±.008 FRACTIONAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±1/64 MACHINED ANGLES MAY VARY ±.1° SHEARED ANGLES MAY VARY ±.25° BROKEN ANGLES MAY VARY ±.1° ECCENTRICITY BETWEEN ANY DIAMETERS ON THE SAME CENTERLINE SHALL NOT EXCEED .010 TOTAL INDICATOR READING. ALL DIMENSIONS ARE FINISH DIMENSIONS INCLUDING APPLIED FINISH AND ARE GIVEN IN INCHES.				SIGNAL CORPS		REVIEWED <i>PME</i>		APPROVED <i>HLV</i> <i>PME</i>			
APPLICATION				DATE <i>5 DEC 55</i>		SCALE <i>2/1</i>					