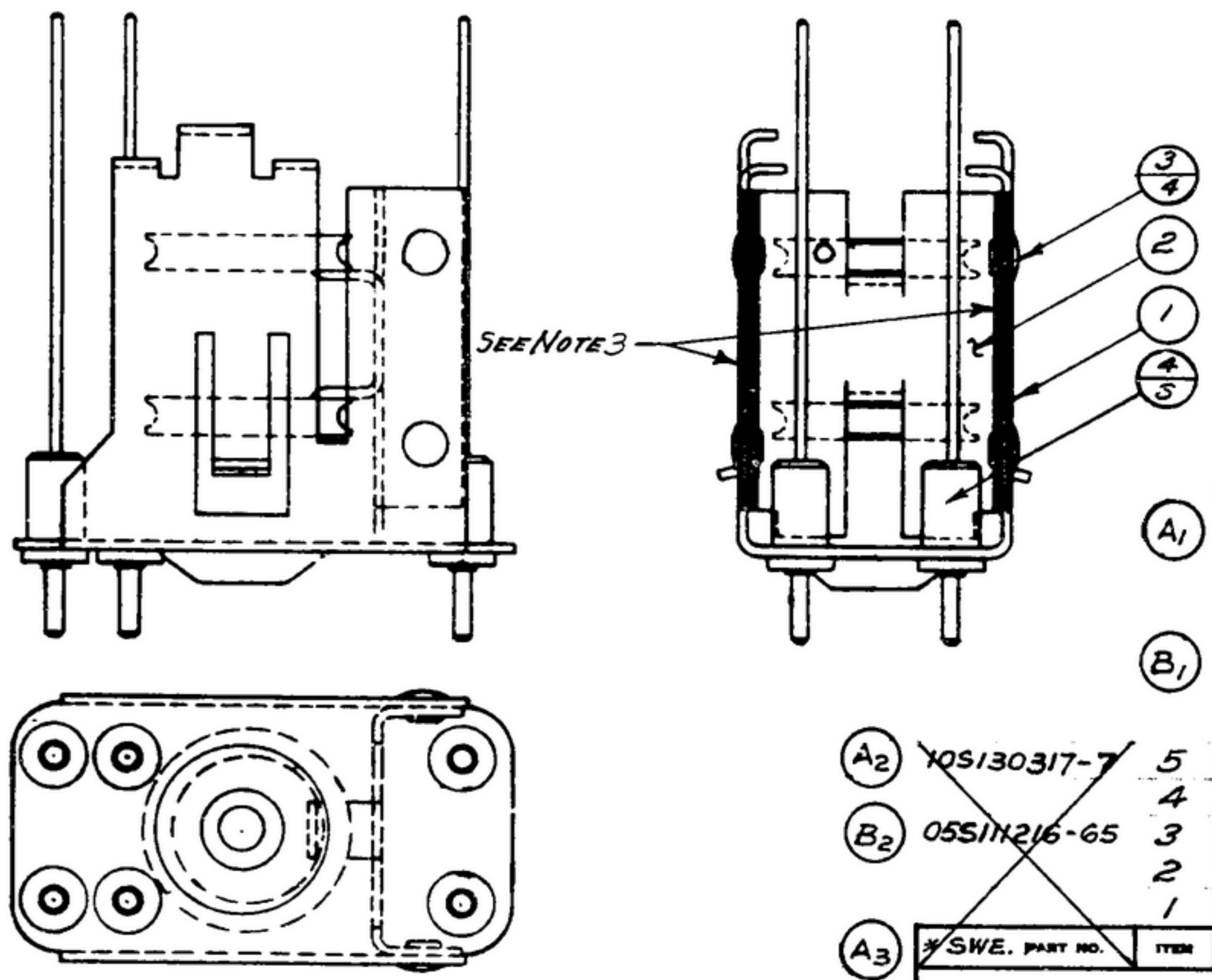


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* FOR INFORMATION ONLY, CONTRACTOR MAY AT HIS OPTION DEVIATE FROM THESE PROCESS DETAILS.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A3	A1 - DELETED NOTE 4 (VARNISH) A2 - ITEM 5 WAS VARNISH. A3 - REPLACED COLLINS PART NO'S. WITH SWE PART NO'S.	17 NOV 59	42428-PC-59-AI-51 REV'D. PME
B	(1) - ADDED NOTES # 6 & 7. (2) - ADDED PART NO. 05S111216-65 & PART NO. SM-B-249068-1 WAS SM-B-283266-1, ADDED NOTES NO'S. 6, 7.	9 DEC 60	42428-PC-59 REV'D. PME



NOTES:
 1. ASSEMBLE LINK ASSY (2) TO FRAME (1) AS SHOWN & ROLL.
 2. PRESS TERMINALS (4) INTO FRAME (1) AS SHOWN.
 3. SOLDER EDGE OF FRAME (1) TO LINK ASSY (2) AS SHOWN, USING COMP SNGO WARP SOLDER PER SPEC QQ-S-571, PER SPEC MIL-S-6872.
 5. IN ALL SPLIT BALLONS TOP FIGURE IS MATERIAL LIST ITEM INDICATOR & BOTTOM FIGURE IS QUANTITY.
 6. AS SUPPLIED BY NATIONAL RIVET AND MFG. CO. WAUPUN WIS. PART NO. AB-1-3-ST-MATL TYPE C1006, C1010 OR C1015 STEEL PER FED. SPEC. QQ-W-409 OR EQUAL.
 7. FINISH M262 PER SPEC MIL-F-14072.

A2	Y0S130317-7	5	As Reqd	SOLDER SOFT	SNGO WARP3 QQ-S-571	3
B2	05S111216-65	3	4	SM-B-249270 TERMINAL/INSULATED		6,7
			2	SM-C249081 LINK ASSY		
			1	SM-G249077 FRAME-ANT COIL		

*SWE. PART NO.	ITEM	REQD	PART NO.	DESCRIPTION	MATL	MATL SPEC	NOTES
LIST OF MATERIAL							
COLLINS PART NO. <i>558 0419 002</i>							

COLLINS NO.	QTY	NEXT ASSY	USED ON
<i>558 0439 004</i>	<i>1</i>	<i>SM-D-249088</i>	<i>SC-DL-248775</i>

APPLICATION

DRAWN *Hamer* CHECKED *Hamer* APPROVED

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.

COLLINS-RADIO CO.
 CEDAR RAPIDS, IOWA
14214-PH-51-93
 SIGNAL CORPS
 REVIEWED *PME*
 APPROVED *HLV*
PME
 DATE *14 DEC 55* SCALE *2/1*

FRAME ASSY

DEPARTMENT OF THE ARMY
 SIGNAL CORPS ENGINEERING
 LABORATORIES
 PORT MONMOUTH NEW JERSEY
SM-B-249068