

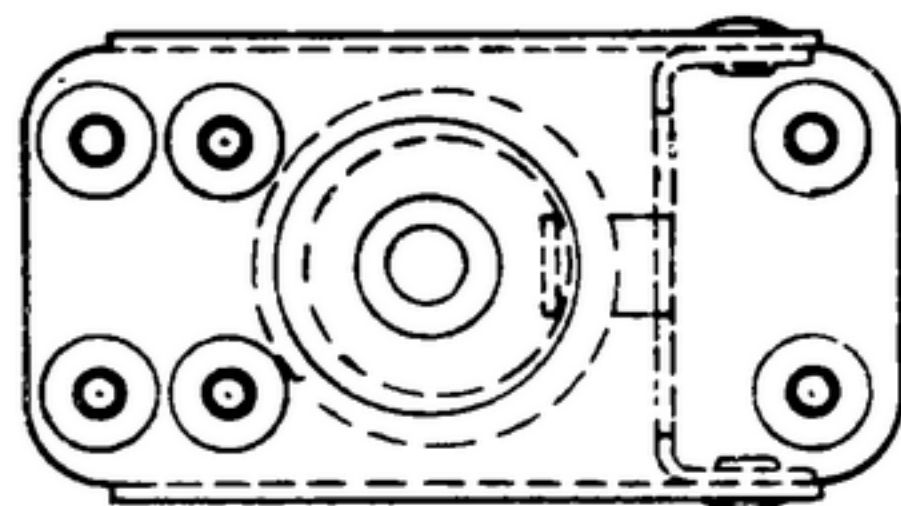
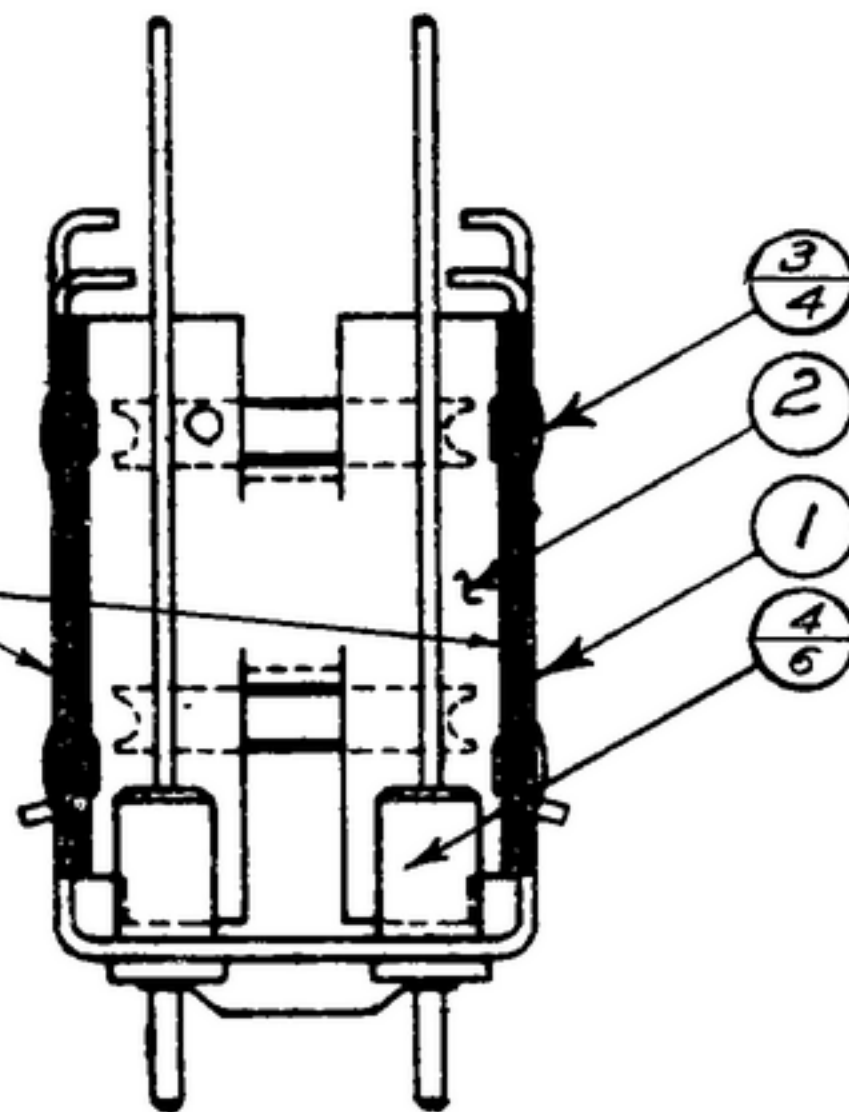
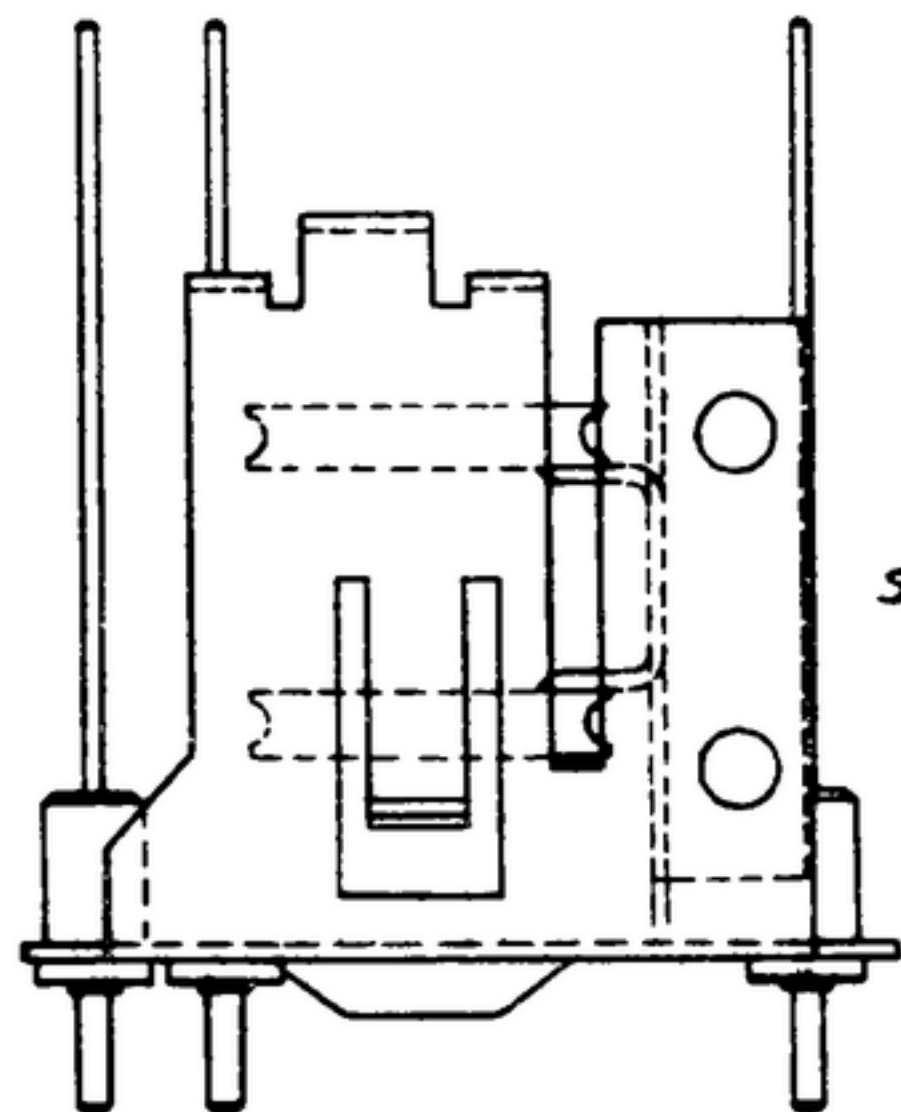
NOTICE: WHEN GOVERNMENT DRAWINGS, SPECIFICATIONS, OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY FOR ANY OMISSION, UNAUTHORIZED REVISION, OR THE FACT THAT THE GOVERNMENT MAY HAVE FORWARDED, FURNISHED, OR IN ANY WAY SUPPLIED THE SAID DRAWINGS, SPECIFICATIONS, OR OTHER DATA IS NOT TO BE REGARDED BY REPLICATION OR OTHERWISE AS IN ANY MANNER LICENSING THE HOLDER OR ANY OTHER PERSON OR CORPORATION, OR CONVEYING ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THERETO.

THIS DOCUMENT HAS BEEN PURCHASED BY THE GOVERNMENT AND MAY BE REPRODUCED AND USED IN CONNECTION WITH ANY GOVERNMENT PROCUREMENT OR MAINTENANCE OPERATION.

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

REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
<del>A<sub>3</sub></del>	<del>A<sub>1</sub>-DELETED VARNISH NOTE 1; A<sub>2</sub>-ITEM 5 WAS VARNISH; A<sub>3</sub>-REPLACED COLLINS PART NO'S WITH SWE PART NO'S.</del>	<del>17 NOV 59</del>	<del>42428-PC-59-A1-51 REV'D. PME</del>
B	(1)-ADDED NOTES 6 & 7; (2)-ADDED PART NO. 05SI11216-65 & PART NO. SM-B-249069-1 WAS SM-B-283266-1; ADDED NOTES 6,7.	9 DEC 60	42428-PC-59 REV'D. PME



NOTES: (A<sub>1</sub>)

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

(A <sub>2</sub> )	<del>YOS130317-7</del>	5	As Req'd	SOLDER SOFT	QQ-S-571	2
(B <sub>2</sub> )	<del>05SI11216-65</del>	3	4	SM-B-249270 TERMINAL-INSL.		
		2	1	SM-B-249069-1 RIVET-TUBULAR		6,7
		1	1	SM-G249082 LINK ASSY		
(A <sub>3</sub> )		1	1	SM-G249077 FRAME-ANT. COIL		

SWE PART NO.	ITEM	REQD	PART NO.	DESCRIPTION	MATL	MATL SPEC	NOTES
LIST OF MATERIAL							

COLLINS NO.	QTY	NEXT ASSY	USED ON
558-0440-004-1		SM-D-249089	SC-DL-248775

DRAWN ECS CHECKED Rhm 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-IOVA  
 14214-PH-51-93

SIGNAL CORPS  
 REVIEWED PME  
 APPROVED HLV  
PME

DATE 17 DEC 55 SCALE 2/1

DEPARTMENT OF THE ARMY  
 SIGNAL CORPS ENGINEERING  
 LABORATORIES

FORT MONMOUTH NEW JERSEY

SM-B-249069