

31-04

EQUIP. TYPE R390A/URR EXP. NO.

Col. 510 7010 004

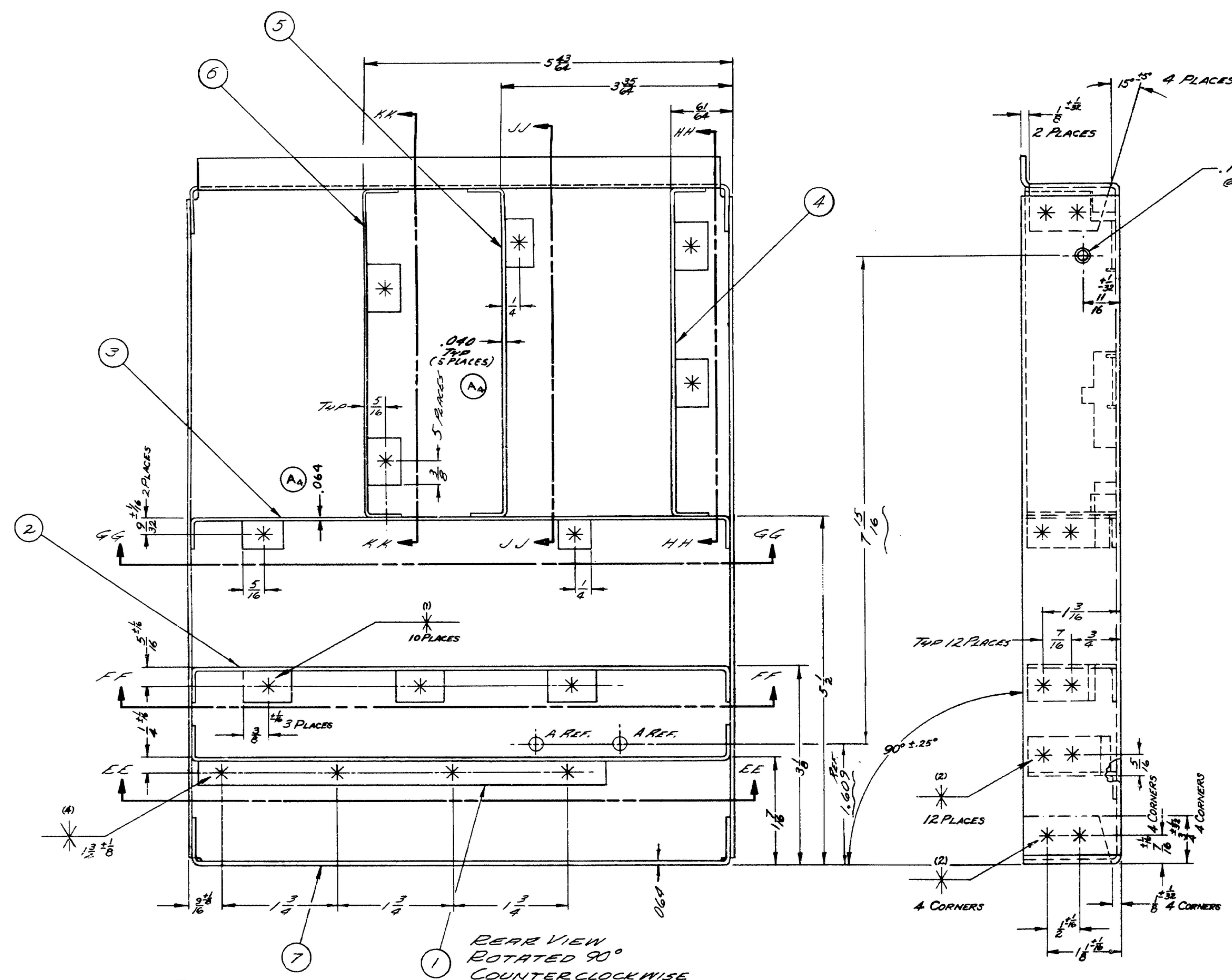
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\* FOR INFORMATION ONLY. CONTRACTOR MAY AT HIS OPTION DEVIATE FROM THESE PROCESS DETAILS.

† WHEN PART NUMBER APPEARS AS: 558 0454 9-6 MILITARY SOURCE INSPECTION IS REQUIRED.

* SWE APPROVAL		REVISIONS			
SYM	PR10042-10	SYM	DESCRIPTION	DATE	APPROVAL
		A1B	A1 WAS 525 A1 ADDED SIZE OF CHARACTERS REF. TO FED. STD 595 & SPEC MIL-V-173 TO NOTE 7 A2 MIL-W-6858 WAS MIL-W-6860 A4 .081 WAS .064 ADDED NOTATION 5 PLACES TYP & THK DIM. A5 DELETED ITEM B	6 NOV 59	4142B-PC 59-A1-S1 REV'D PME
		B	SEE SHEET 3 FOR REVISIONS	22 DEC 59	4142B-PC REV'D PME
		C	SEE SHEET 2 FOR REVISIONS	24 OCT 60	4142B-PC REV'D PME
		D	SEE SHEET 4 FOR REVISION	15 MAR. 61	4142B-PC 59 REV'D PME



- NOTES:
- BEND RELIEFS 1/8 MAX. WIDE x 3/32 DEEP UNLESS OTHERWISE SPECIFIED SHAPE OPTIONAL.
  - ALL INSIDE BEND RADII & RELIEF RADII 5/64 MAX. UNLESS OTHERWISE SPECIFIED.
  - SPOTWELD IN ACCORDANCE WITH SPEC MIL-W-6858. SYMBOLS IN ACCORDANCE WITH JAN-STD-19.
  - TOLERANCE APPLIES TO "C" DETAILS ONLY. OTHERS MAY VARY ± 1/64.
  - ALL CORNERS MAY HAVE 1/32 MAX. RADII UNLESS OTHERWISE SPECIFIED.
  - CHASSIS IS TO BE FLAT WITHIN 1/64 ON BOTTOM LIPS & BEND LIP.
  - SILK SCREENING TO BE BLACK, LOCATED AS SHOWN. ALL CHARACTERS TO BE 3/32 HIGH GOTHIC TYPE PER SPEC MIL-M-13231, GROUP II. COLOR TO BE BLACK, COLOR CHIP #2703B PER FED STD 595. MARKINGS TO BE CENTRALLY LOCATED ± 1/32 UNLESS OTHERWISE SHOWN. COVER DESIGNATIONS WITH 1 COAT OF VARNISH PER MIL-V-173-TYPE II.

ALUMINUM ALLOY, 5052, TEMPER H32, PER SPEC QQ-A-318  
FINISH: E513 PER SPEC MIL-F-14072.  
\* COLLINS 558-0454-004

QTY	REEL	PART NO.	DESCRIPTION	MATL.	MATL. SPEC.	NOTES
7	1	SM-D-24902-1	SILK SCREEN CHASSIS			
6	1		7 CHASSIS			
5	1					
4	1					
3	1					
2	1					
1	1	SM-D-249102-1	RFIB			

QTY	REEL	PART NO.	DESCRIPTION	MATL.	MATL. SPEC.	NOTES

DRAWN NUGEN		CHECKED PME		APPROVED		COLLINS-RADIS-00- SIGNAL CORP'S 14214-PH- 51-93		DEPARTMENT OF THE ARMY SIGNAL CORP'S ENGINEERING LABORATORIES	
558-0436-004		SM-D-249085		300L-840775		REVIEWED PME		FORT MONMOUTH NEW JERSEY	
COLLINS NO.		STY		NEXT ASSY		USED ON		SM-D-249102	
APPLICATION		DATE 20 JAN 56		SCALE 1/1		APPROVED HLY PME		SHEET 1 OF 5 SHEETS	

WHEN REFERRING TO THIS DRAWING STATE DRAWING NO., APPLICABLE ISSUE SYMBOL, IF ANY, AND DATE



10-7

EQUIP. TYPE P-390A/4/RR EXP. NO.

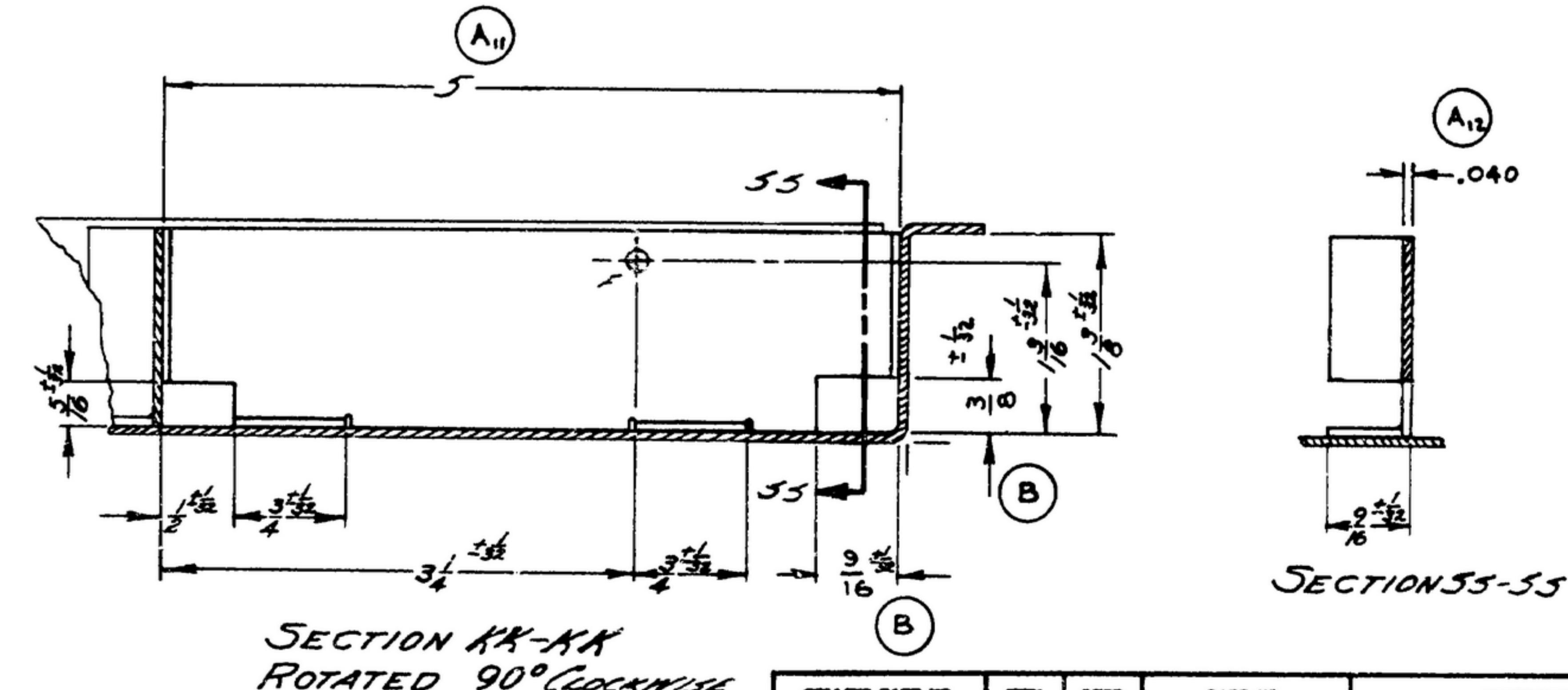
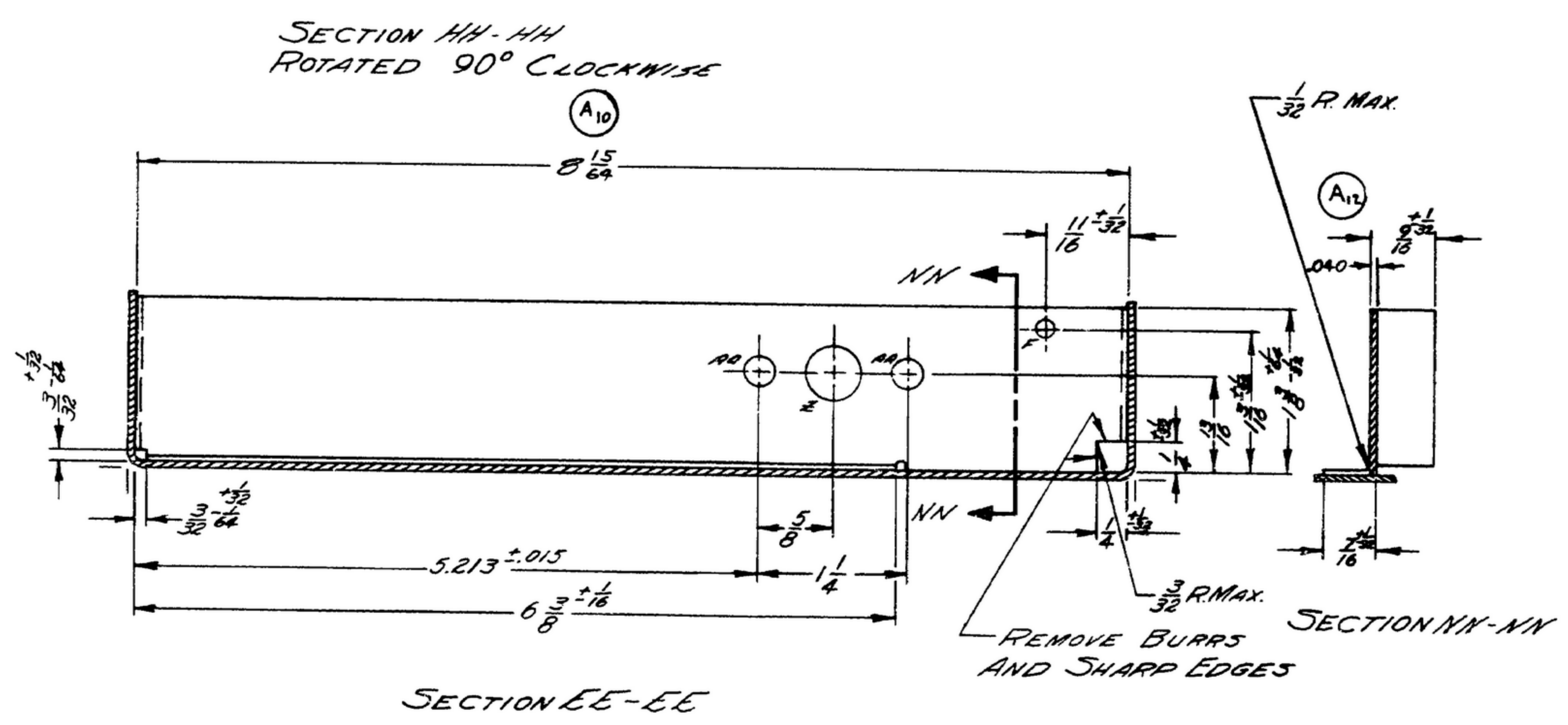
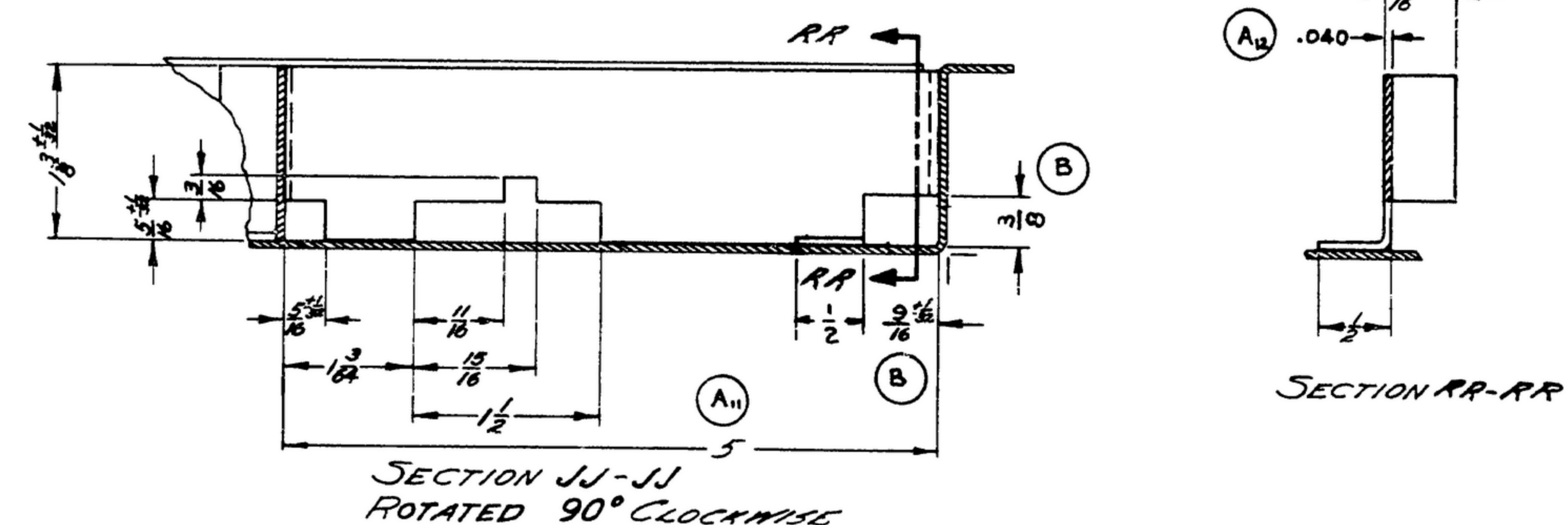
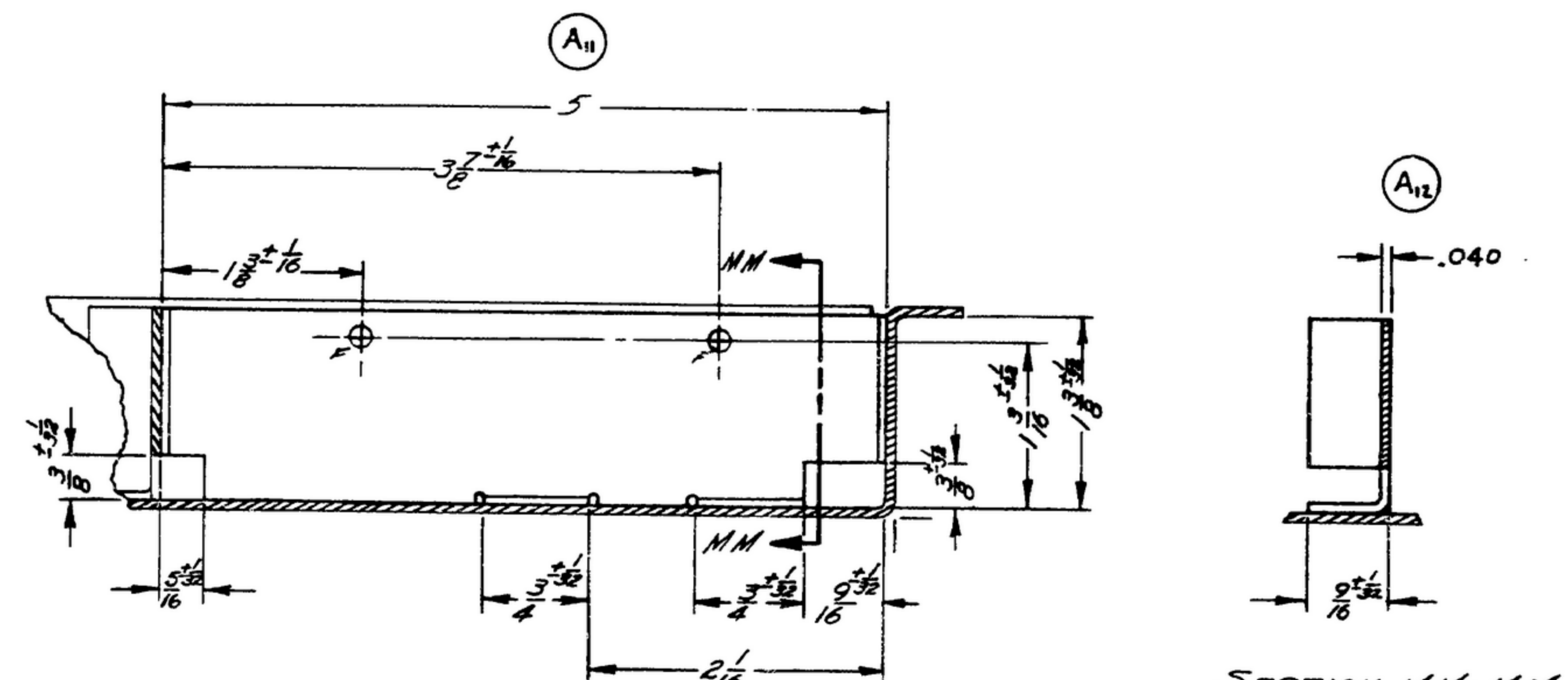
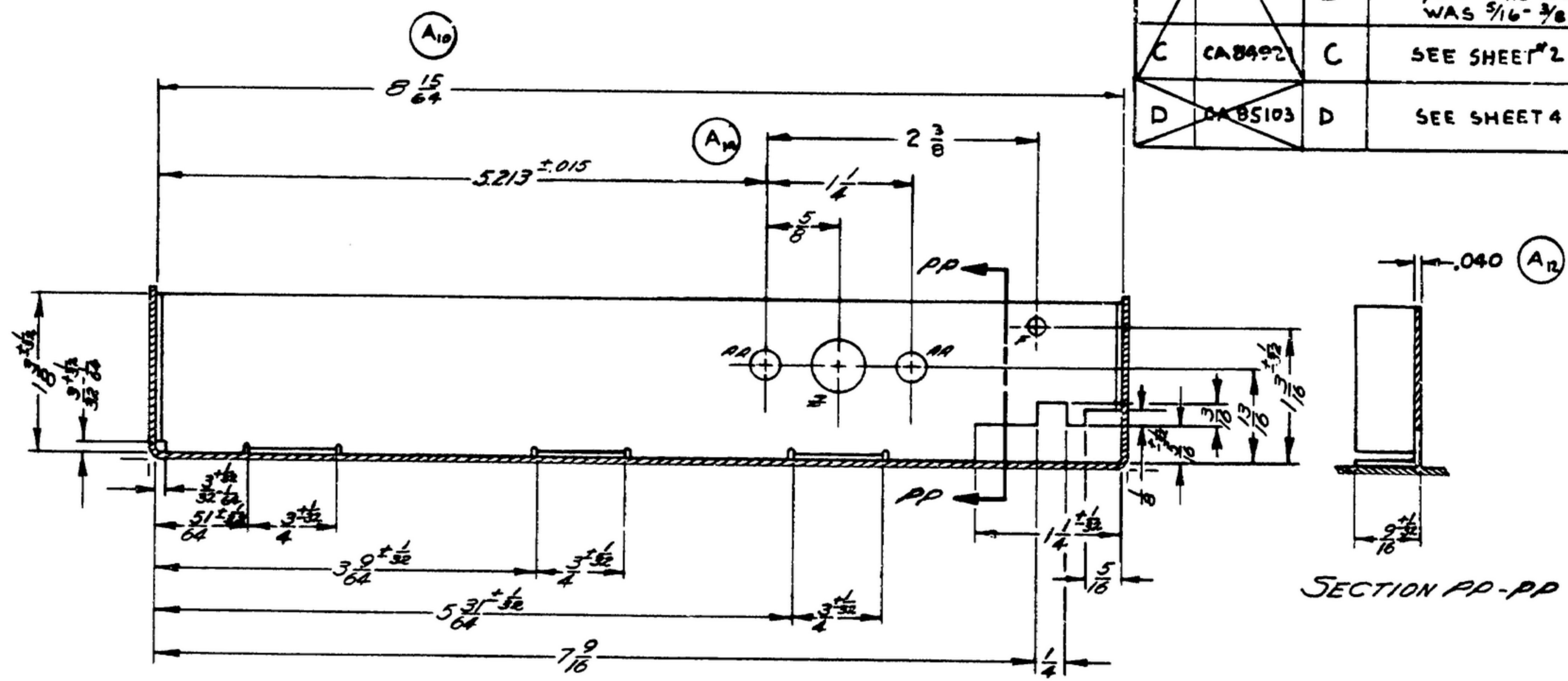
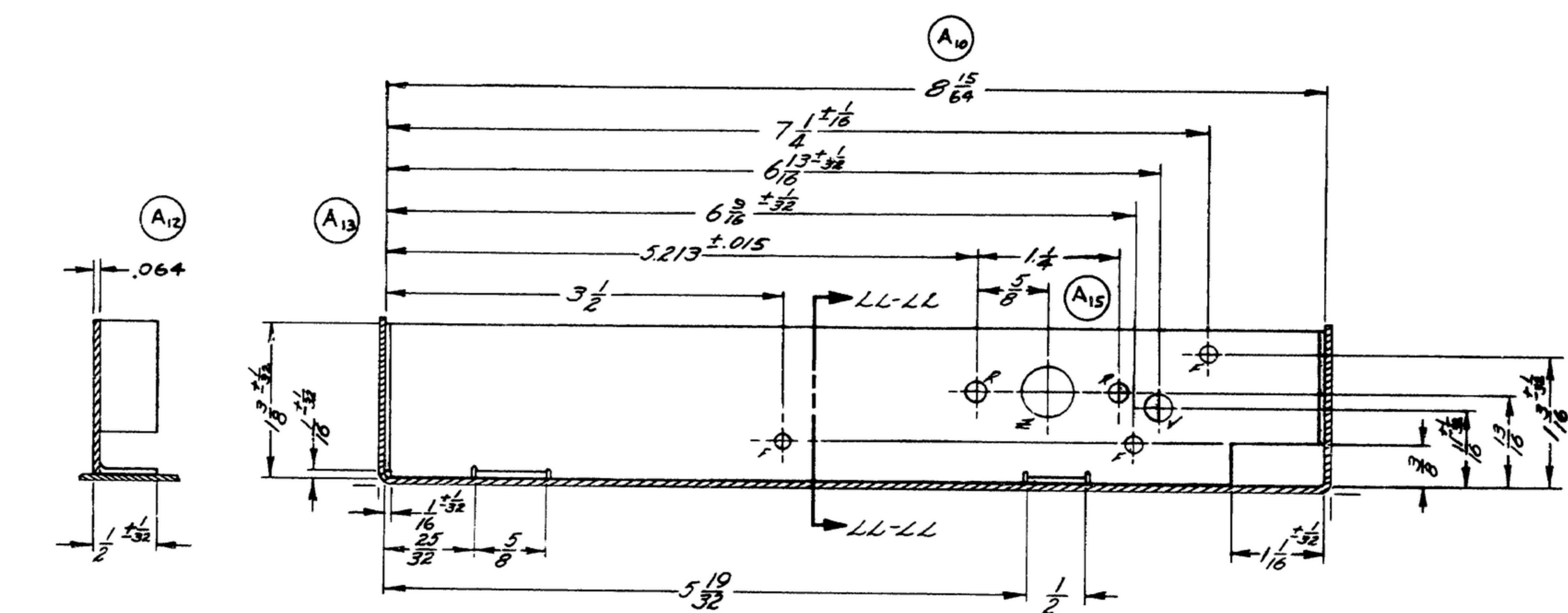
Col. 540-7910-006

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SWE APPROVAL		REVISIONS			
SYM	PRDGN	BY	DESCRIPTION	DATE	APPROVAL
		A10	A10 WAS B 3/8 A10 WAS 5/16 A12 ADDED THK DIM A13 WAS 6 5/8 & REVISED TO 6 3/8 TO ±.015 A14 REMOVED DIM 7 5/8 & REVISED TO DIM 2 3/8 A15 1 1/4 WAS 1.250	6 NOV 59	4242B-PC 59-A1-S1 REV'D PME
		B	SECTION KK-KK WAS 3/16 3/8 WAS 5/16 SECTION JJ 3/16 WAS 3/16 3/8 WAS 5/16-1/2 WAS 3/4	22 DEC 59	4242B-PC 59-A1-S1 REV'D PME
		C	SEE SHEET 2 FOR REVISIONS	24 OCT 60	4242B-PC 59-A1-S1 REV'D PME
		D	SEE SHEET 4 FOR REVISION	15 MAR 61	4242B-PC 59-A1-S1 REV'D PME



COLLINE PART NO.	QTY	UNIT	REMARKS	DATE	BY
LIST OF MATERIAL					
COLLINE PART NO. 558-0454-1000					

DRAWN RCHILL	CHECKED 	APPROVED 	COLLINS-SABO-CO. 1421A-PH-51-93 SIGNAL CORPS REVIEWED APPROVED DATE 23 JAN 58	DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY SM-D-249102 SHEET 3
UNLESS OTHERWISE SPECIFIED: DECIMAL DIMENSIONS INCLUDING HOLE DEEPS MAY VARY ±.005 FRACTIONAL DIMENSIONS INCLUDING HOLE DEEPS MAY VARY ±1/64 MACHINED ANGLES MAY VARY ±.1° BEARED ANGLES MAY VARY ±.25° BROKEN ANGLES MAY VARY ±.1° ECCENTRICITY BETWEEN HOLE 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.			CHASSIS-RF ASSY	SCALE 1/11

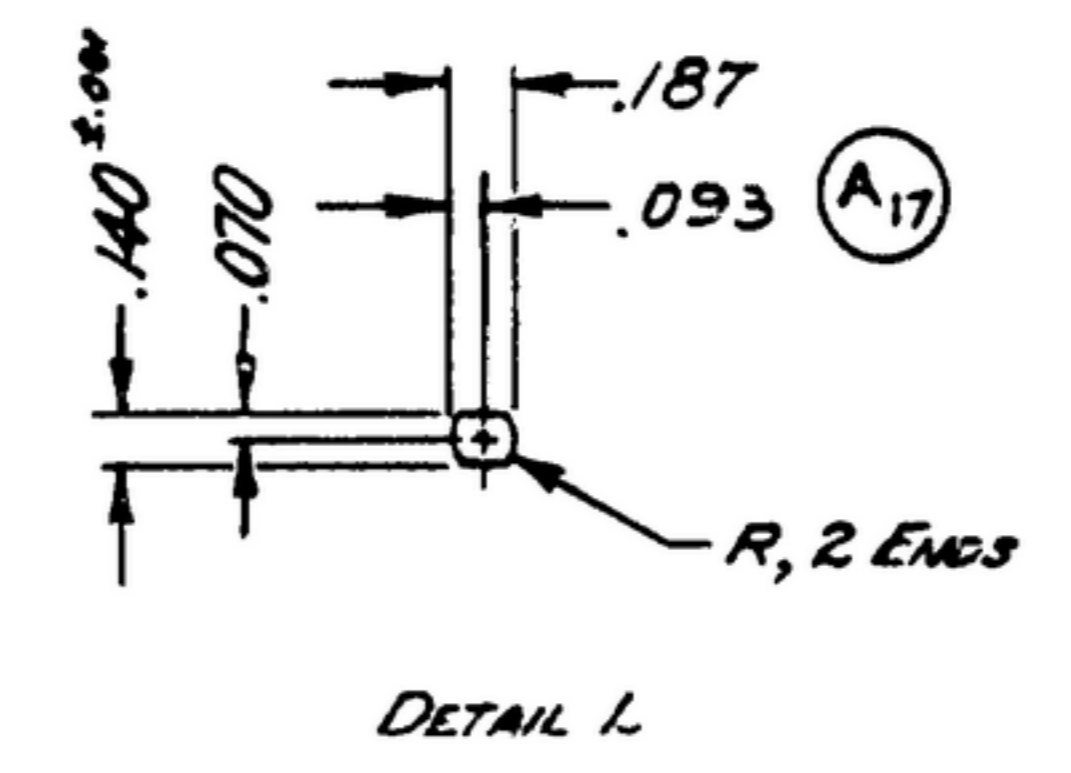
20 02

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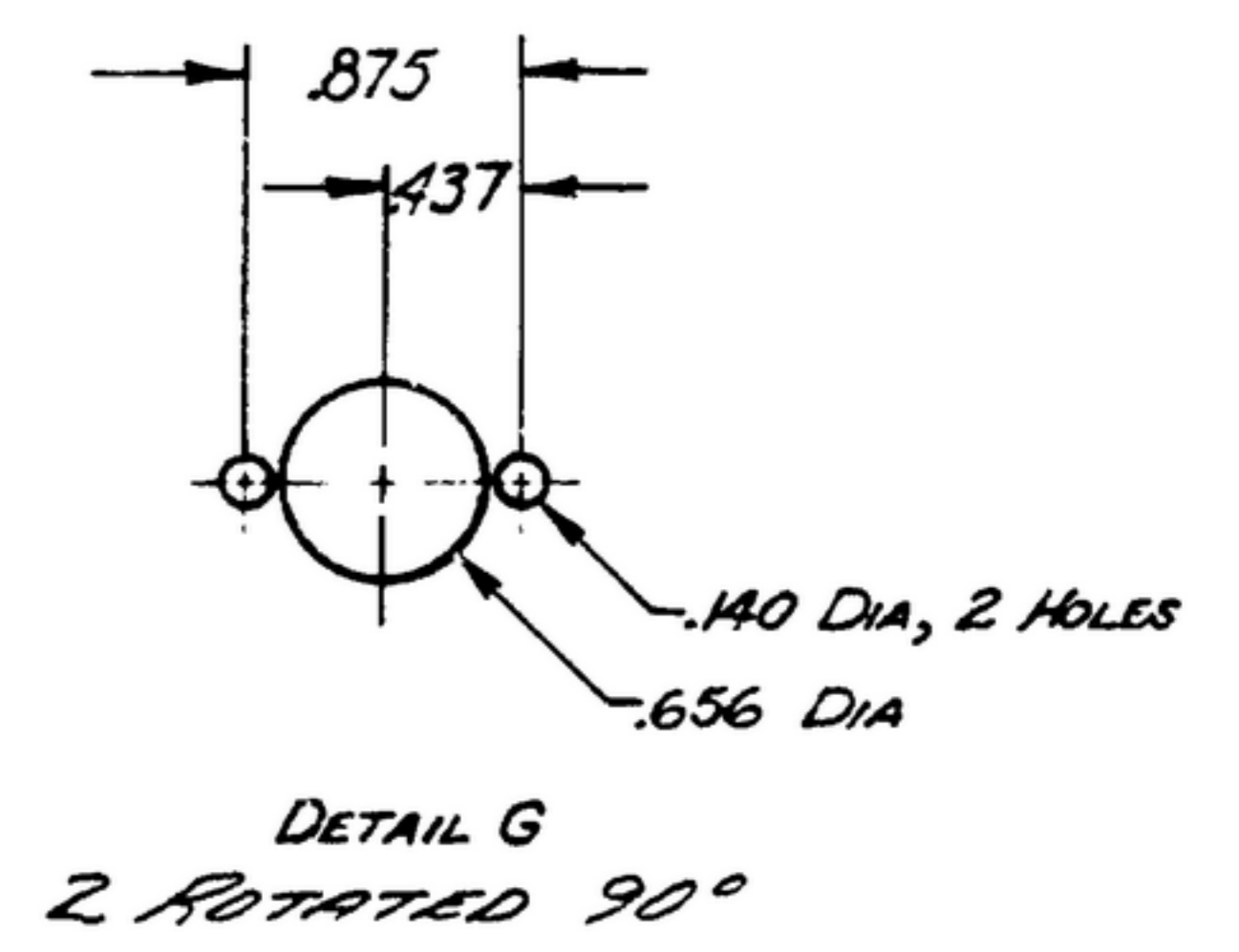
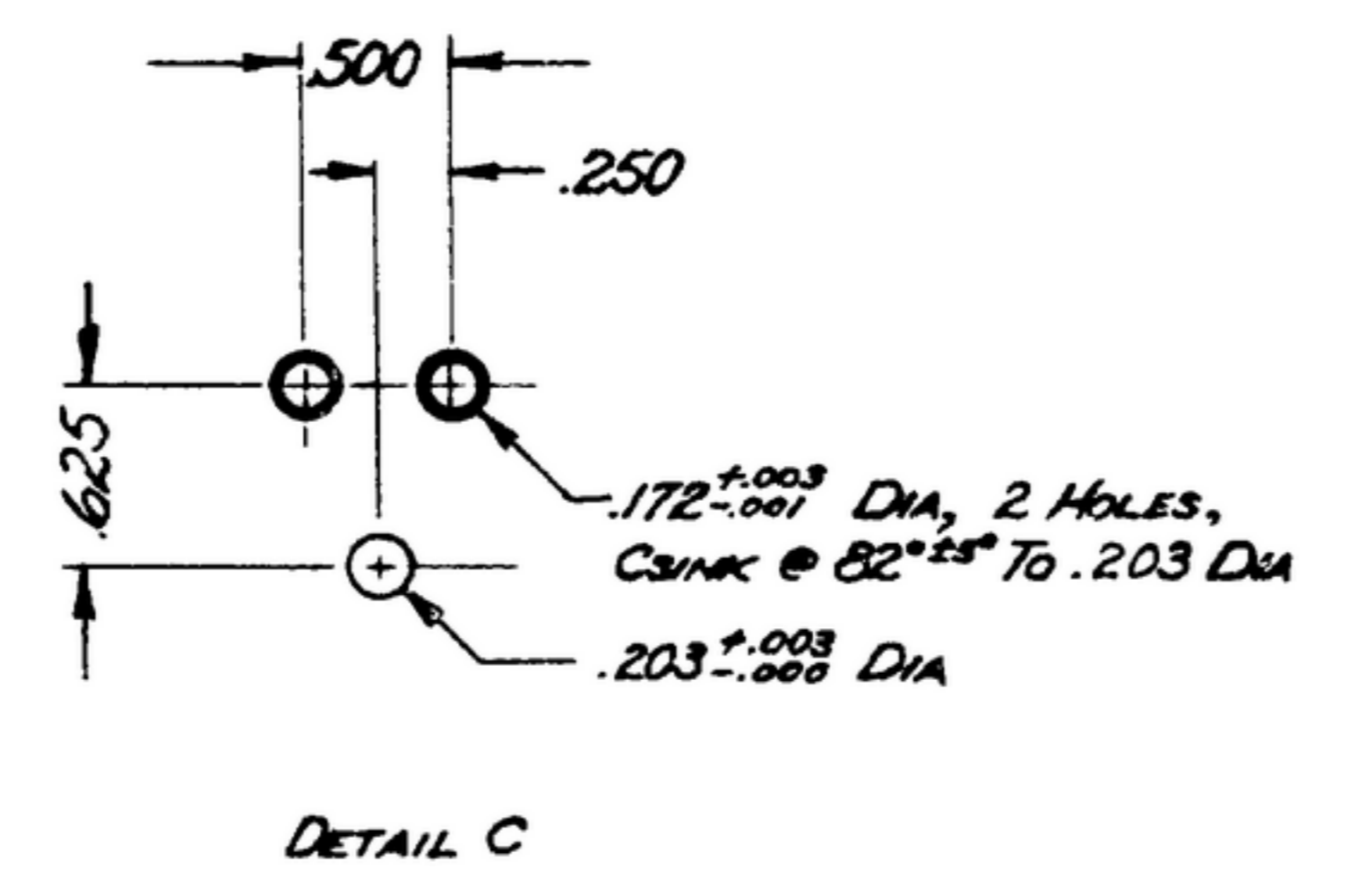
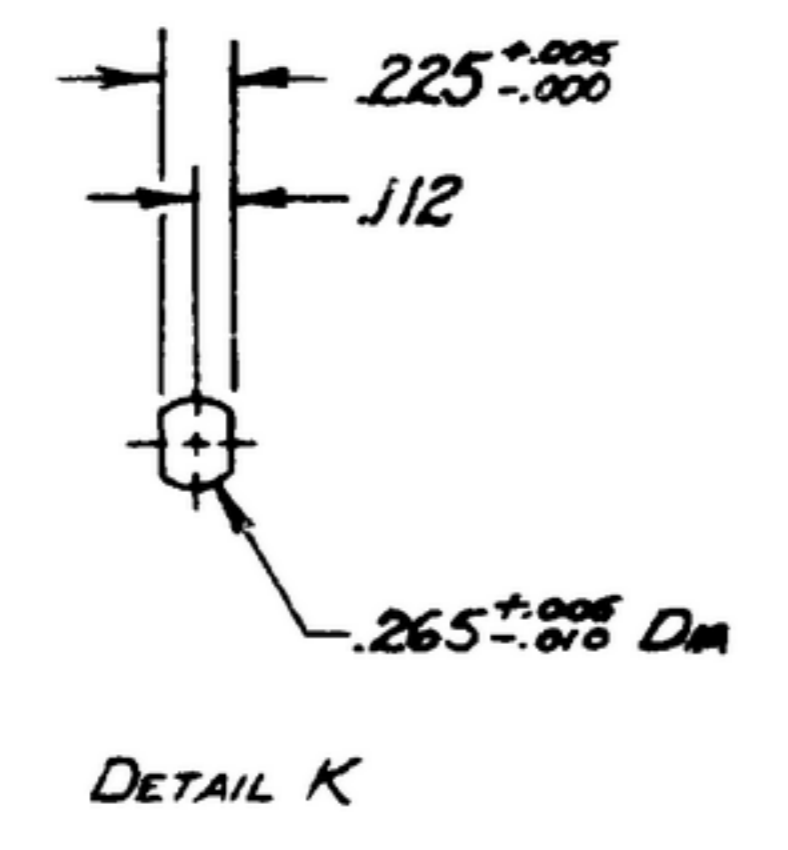
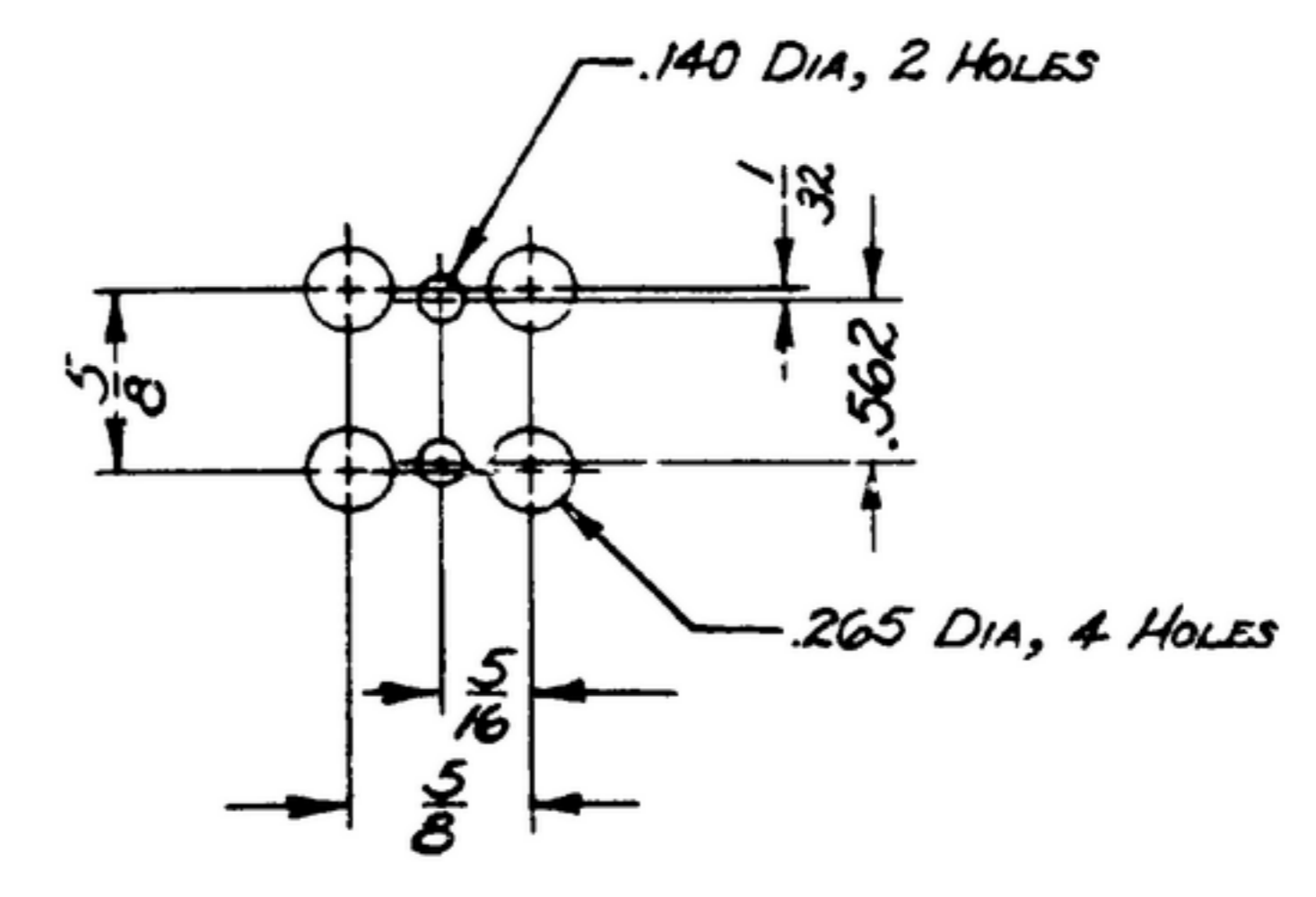
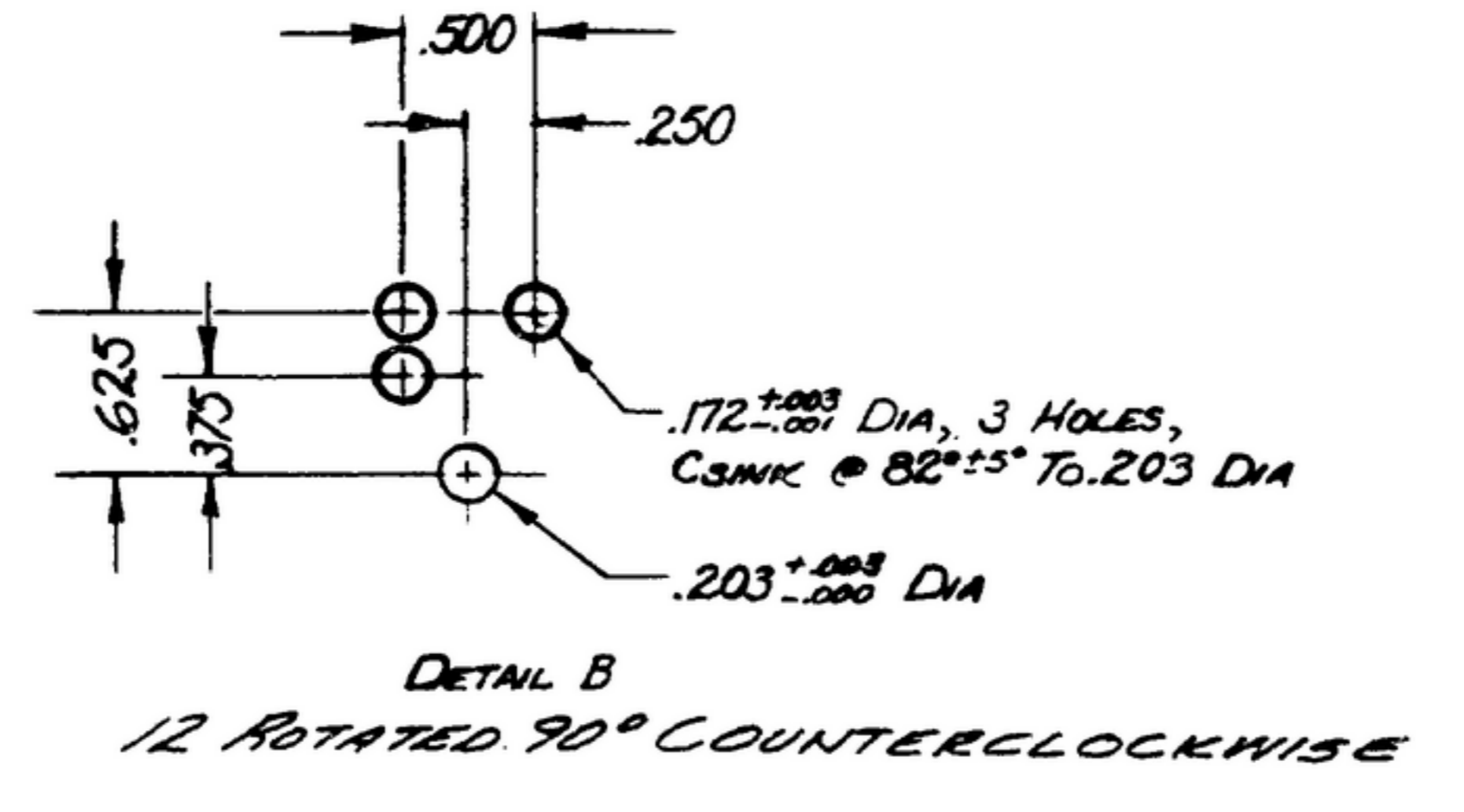
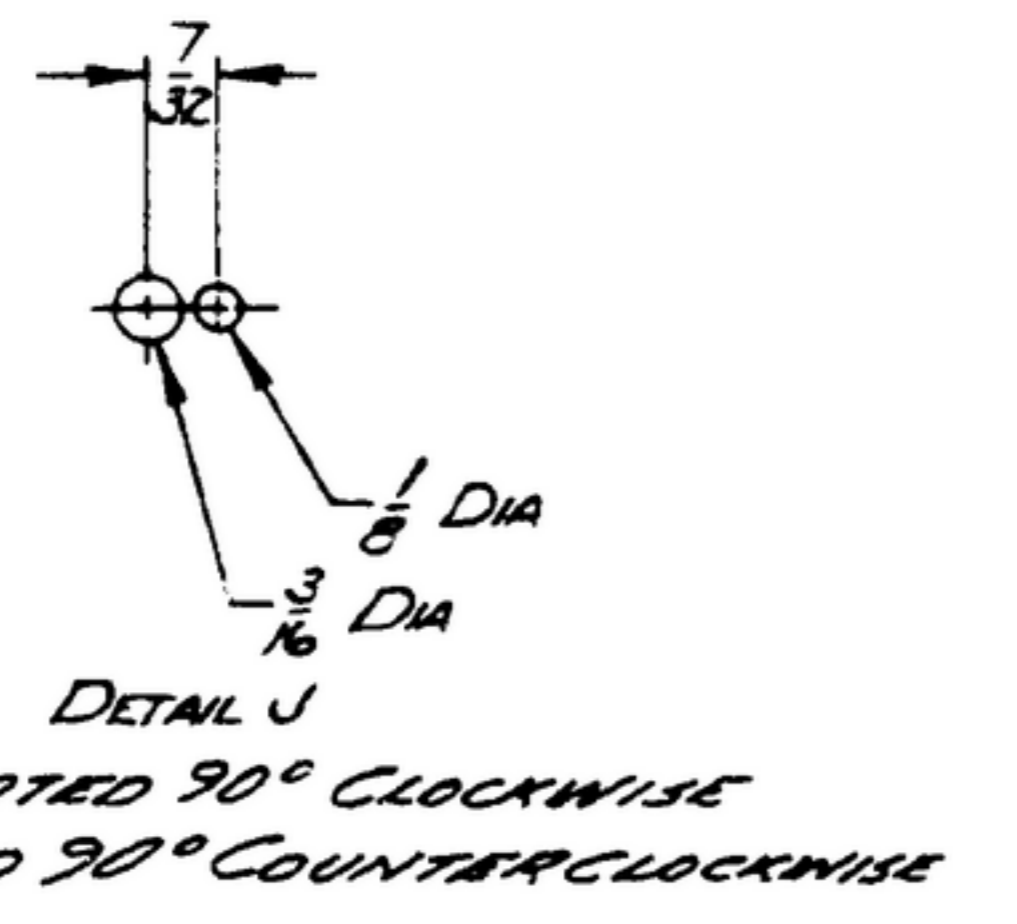
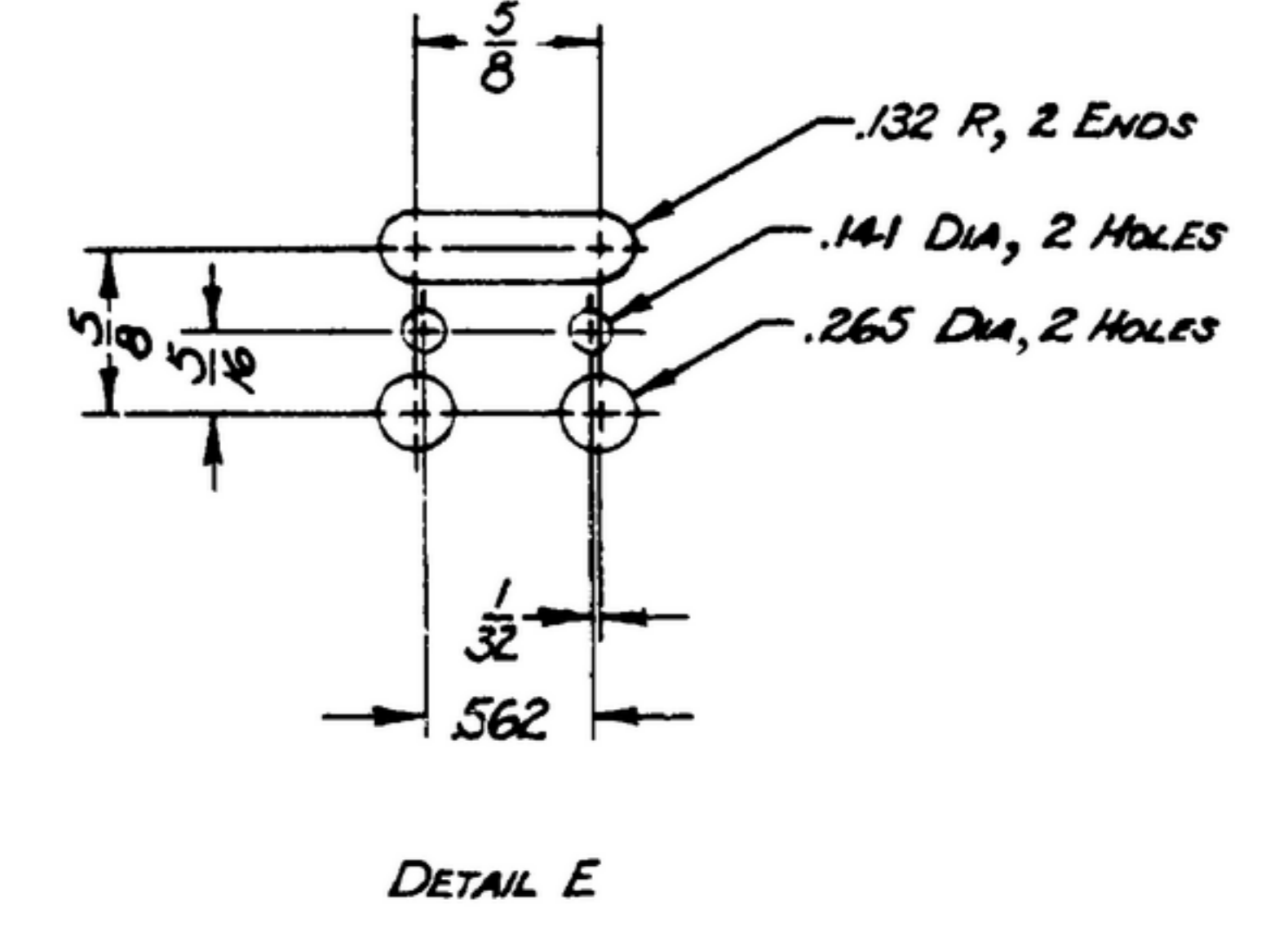
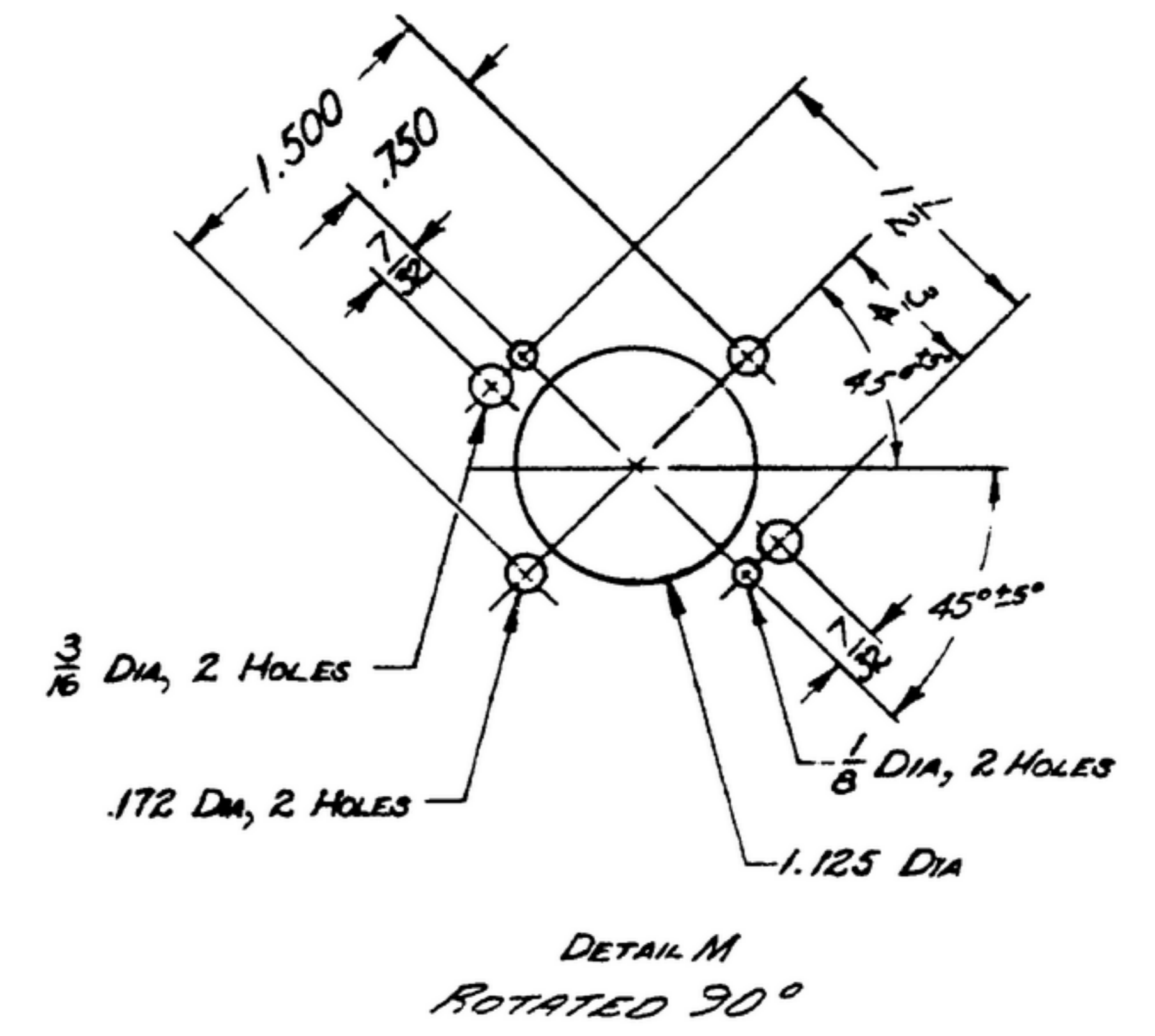
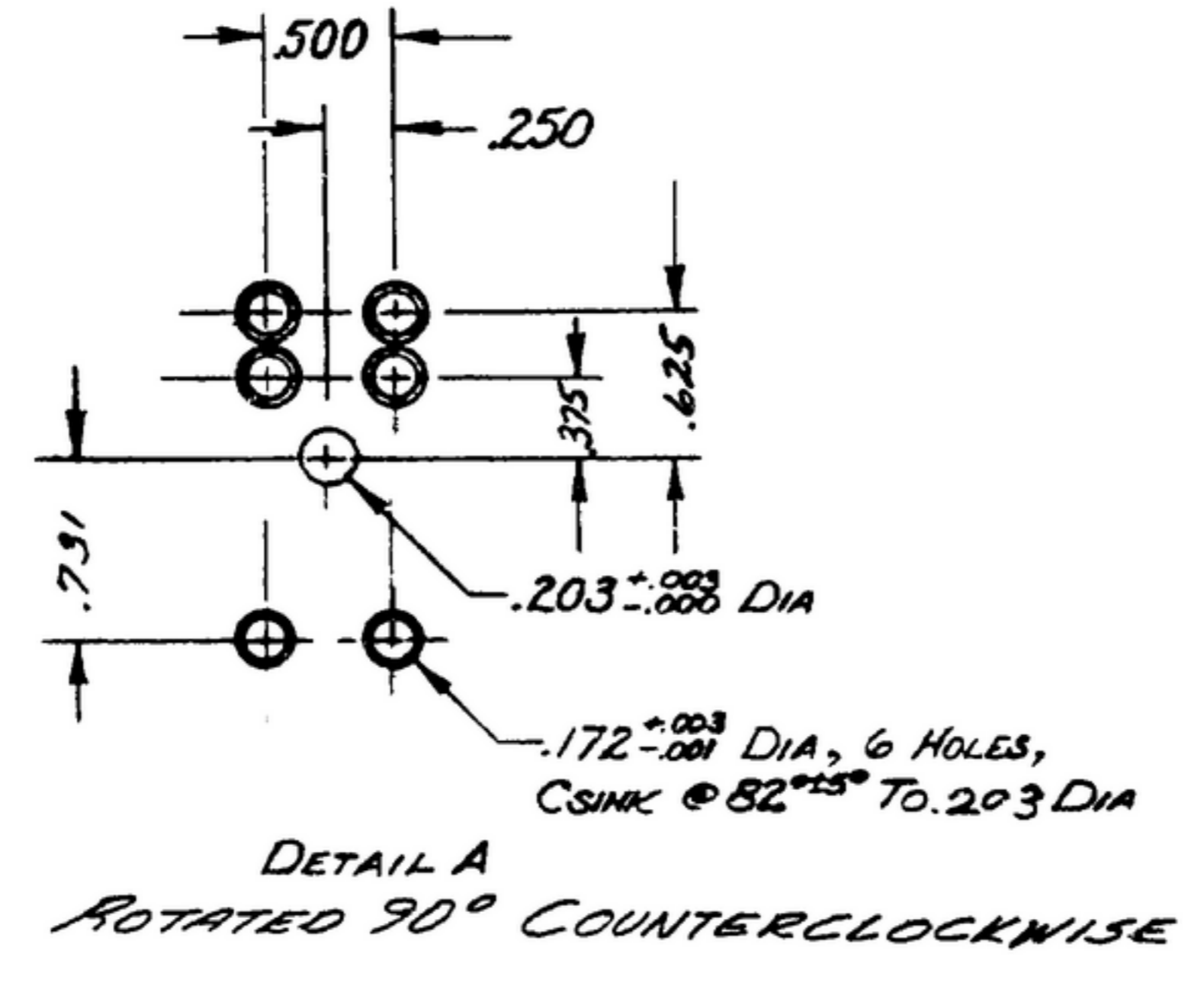
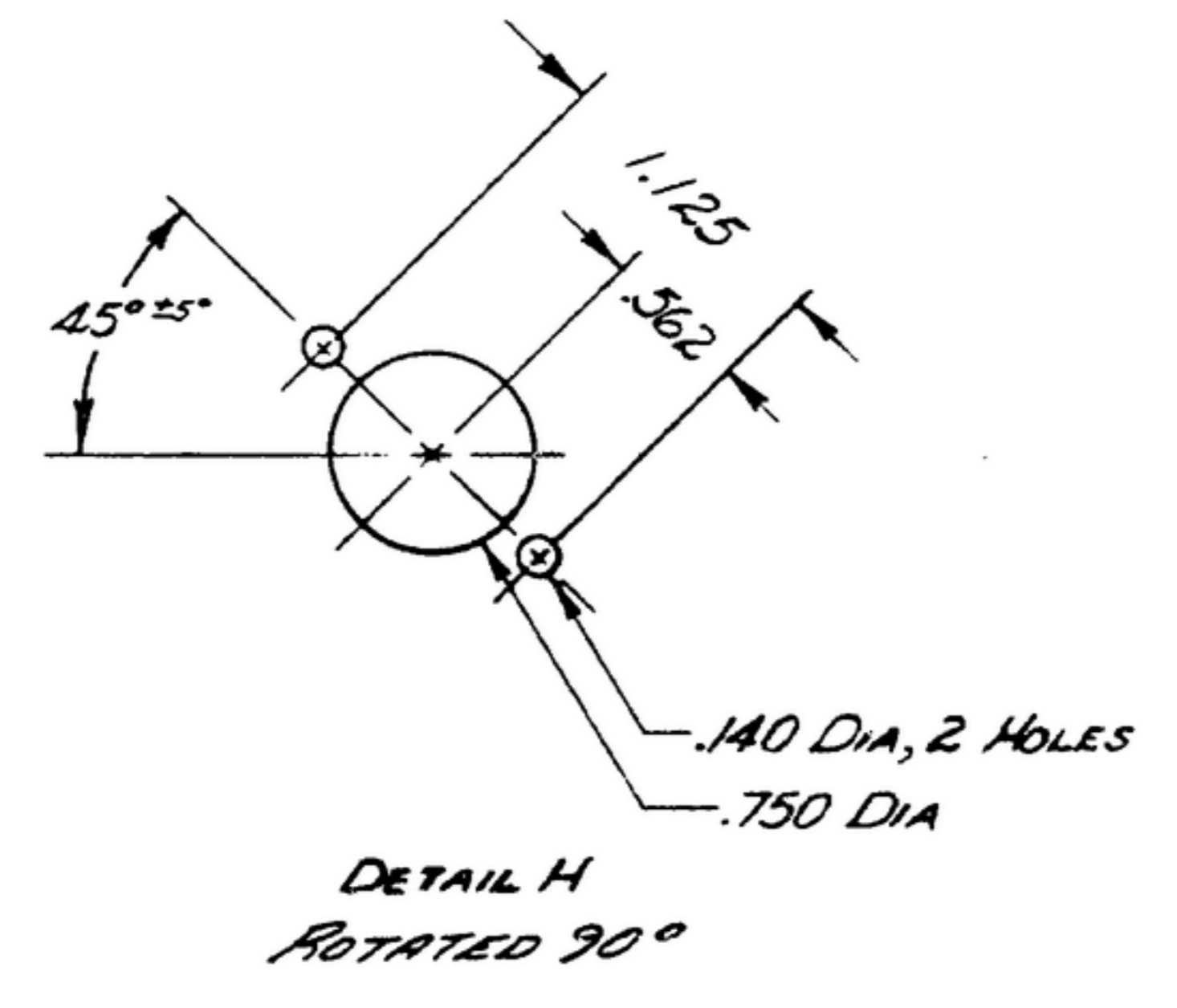
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SWE APPROVAL		REVISIONS			
SYM	PR10041-10	BYM	DESCRIPTION	DATE	APPROVAL
		A18	A16 WAS 3/16 A17 WAS .085	6 NOV 59	4142B-PC 59-A1-S1 REV'D PME
B	CA 84627	B	SEE SHEET 3 FOR REVISIONS	27 DEC 59	4142B-PC 59-REV'D PME
C	CA 84921	C	SEE SHEET 2 FOR REVISIONS	24 OCT 59	4142B-PC 59-REV'D PME
D	CA 85103	D	D, ITEM 5 WAS .172 <sup>+0.003</sup> DIA C'SINK @ 82 <sup>+25</sup> TO .203	15 MAR 59	4142B-PC 59-REV'D PME



HOLE GROUP	DESCRIPTION	REQ'D
A	SEE DETAIL A	6
B	B	13
C	C	5
D	.250 DIA	2
E	SEE DETAIL E	1
F	.140 DIA	8
G	SEE DETAIL G	5
H	H	2
J	J	12
K	K	1
L	L	1
M	M	1
N	N	1
P	.140 DIA	1
R	.171 DIA	7
S	.172 <sup>+0.003</sup> DIA C'SINK @ 82 <sup>+25</sup> TO .218 <sup>+0.003</sup> DIA	32
T	3/16 DIA	6
U	.203 <sup>+0.001</sup> DIA	2
V	.218 <sup>+0.003</sup> DIA	2
W	.312 <sup>+0.003</sup> DIA	2
X	.328 DIA	1
Y	.250 <sup>+0.005</sup> DIA	3
Z	7/16 DIA	3
AA	.234 DIA	4
BB	3/8 DIA	1
CC	3/8 DIA	4
DD	.359 DIA	1



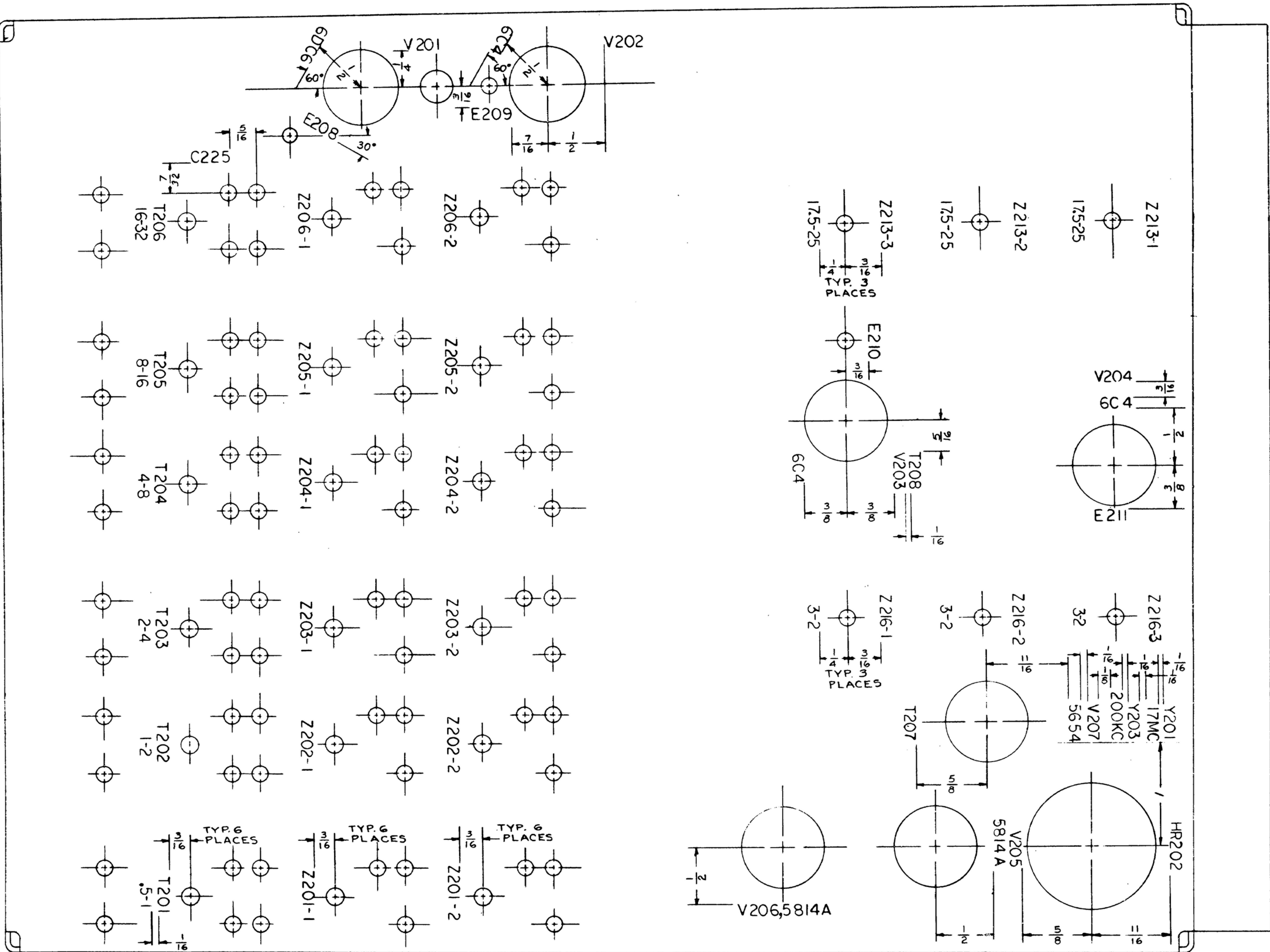
COLLINS PART NO.	QTY	REQ'D	PAGE NO.	DESCRIPTION	UNIT	MAT. SPEC.
LIST OF MATERIAL						
COLLINS PART NO. 558-0434-004						

DRAWN NUGEN	CHECKED PME	APPROVED	COLLINS RADIO CO. 14214-DH-51-93	SIGNAL CORPS	DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES
UNLESS OTHERWISE SPECIFIED: DECIMAL DIMENSIONS INCLUDING HOLE SIZE MAY VARY ±.008 FRACTIONAL DIMENSIONS INCLUDING HOLE SIZE MAY VARY ±1/64 MACHINED ANGLES MAY VARY ±1° SHEARED ANGLES MAY VARY ±.01" 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.			REVIEWED DME	APPROVED H.L.Y PME	FORT MONMOUTH NEW JERSEY
558-0436-004	SM-D-249105	SEAL-248775	DATE 20 JAN 56	SCALE 1/1	SM-D-249102 SHEET 4

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SWE APPROVAL		REVISIONS			
SYMBOL	DATE	DESCRIPTION	DATE	APPROVAL	
B	CAB4627	A18 REDRAWN & REVISED	6 NOV 59	42488-PC-59 -A1-51	
		B SEE SHEET 3 FOR REVISIONS	12/2/59	42488-PC-59 -A1-51	
C	C.A.#84921	C SEE SHEET 2 FOR REVISIONS	24 OCT 60	42488-PC-59 -A1-51	
D	C.A. 85103	D SEE SHEET 4 FOR REVISION	15 MAR 61	42488-PC-59 -A1-51	



REQD	PART NO.	DESCRIPTION	QTY	MATL. SPEC.	NOTES
LIST OF MATERIAL					
COLL. RAMP					
14214-PM-51-93					
SIGNAL CORPS					
REVIEWED PME					
APPROVED HLY PME					
DATE 28 DEC. 55 SCALE 2/1					

UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
FRACTIONS	DECIMALS ANGLES
± 1/64	± .005 ± 1°
DRAWN BY E.C.S	CHECKED BY Rca
SM-D-249085 SC-DL-348775	USED ON
NEXT ASSY	ENG APPROVAL

CHASSIS - R.F. ASSY.

DEPARTMENT OF THE ARMY  
SIGNAL CORPS ENGINEERING  
LABORATORIES  
PORT MONMOUTH NEW JERSEY  
SM-D-249102  
SHEET 5