

NOTICE: THESE DIMENSIONS, SPECIFICATIONS, OR OTHER DATA ARE GIVEN FOR THE PURPOSES OF IDENTIFICATION ONLY. THE USER OF THIS DRAWING SHALL BE RESPONSIBLE FOR THE PROPER INTERPRETATION OF THE DRAWING AND FOR THE PROPER SELECTION OF MATERIALS AND METHODS OF FABRICATION. THE USER SHALL BE RESPONSIBLE FOR THE PROPER SELECTION OF MATERIALS AND METHODS OF FABRICATION. THE USER SHALL BE RESPONSIBLE FOR THE PROPER SELECTION OF MATERIALS AND METHODS OF FABRICATION.

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

REVISIONS			
BY	DESCRIPTION	DATE	APPROVAL

- NOTES:**
- ASSEMBLY SHALL BE WIRED IN ACCORDANCE WITH WIRING ASSY SM-E-249141, TO PROVIDE CIRCUIT SHOWN ON SCHEMATIC DIAGRAM SM-J-249190.
 - PART SHALL BE .062 THK. WITH FINISH M262 PER SPEC MIL-F-14072, AS SUPPLIED BY UNITED SCREW AND BOLT CORP, CHICAGO, ILL, OR EQUAL.
 - PART MAY BE SUPPLIED BY CENTRAL SCREW CO, CHICAGO, ILL, OR EQUAL.
 - PART SHALL BE LARGE, .172 I.D. X .437 O.D. X .036 THK.
 - PART SHALL BE .147 I.D. X .312 O.D. X .032 THK.
 - PART SHALL BE 3/32 THK, DOUBLE CHAMFERED.
 - PART SHALL BE .250 ^{0.005} ^{±.005} HEX. X .093 ^{±.005} THK., DOUBLE CHAMFERED.
 - PART SHALL BE 4-40NC-2A X 1/2 LONG, 6 FLUTE HD, FINISH M262, MAT'L: STEEL ALLOY. PER SPEC MIL-F-14072. MAT'L: STEEL ALLOY.
 - PART SHALL BE 4-40NC-2A X 9/16 LONG, 6 FLUTE HD, FINISH M262 PER SPEC MIL-F-14072.
 - WASHER (6) INSERTED BETWEEN JAWS OF CLAMP (8) AT APPROXIMATELY RIGHT ANGLES FROM SCREWDRIVER ACCESS HOLE.
 - ASSEMBLE CABLE ASSY (28) TO STUDS A & B OF SUPPRESSOR (37) AND/FROM FUSE AS SHOWN.
 - ADD INSULATION (29) OVER CLAMP (31).
 - LUBRICATE WITH GREASE (56) PER SPEC MIL-G-7421 BUSHING ON I.F. EXTENSION (4) ANT TRIM, BUSHING & ZERO ADJUST SHAFT & ALL CAPTIVE MTG. SCREWS.
 - ZERO ADJUSTMENT SHAFT TO BE TURNED UNTIL SNUG AGAINST CATCH & THEN RELEASED 1/4 TURN. ASSEMBLE KNOB AGAINST THE STOP IN THE EXTREME CCW POSITION.
 - ALL THROUGHSHAFT BUSHINGS SHOULD BE LEFT LOOSE FOR ASSEMBLY & TIGHTENED AFTER UNITS ARE SECURED.
 - K.C. DRIVE GEAR SHOULD BE LOOSENEED & ADJUSTED FOR MIN. DISTANCE BETWEEN DIAL LOCK & LOCKING PLATE.
 - DIAL LOCK IS LOOSENEED & ROTATED OUT OF POSITION WHEN ASSEMBLING FRONT PANEL. AFTER PANEL IS SECURED, REPOSITION DIAL LOCK AS SHOWN.
 - OSCILLATOR SHAFT (9) IS ALIGNED WITH COUPLER BY LOOSENING SCREW IN FRONT BRACKET OF OSCILLATOR AFTER UNIT IS IN POSITION.
 - MAX. TORQUE TO DRIVE K.C. KNOB AFTER ASSEMBLY IS COMPLETE IS 3 INCH LBS. MAX. TORQUE TO DRIVE M.C. KNOB OUT OF DETENT IS 12 INCH LBS. MIN. TORQUE OUT OF DETENT POSITION IS 5 INCH LBS.
 - FINISH: D213 PER SPEC MIL-F-14072. FINAL PAINT FILM NO. 1445 GREEN GLOSS ENAMEL PER SPEC T.C-595 TO MEET THE APPLICABLE REQUIREMENTS OF SPEC MIL-F-14072. PAINT ENTIRE HEAD (EXCLUDING UNDERSIDE) ^(5A) ^(5B) ~~COATINGS 595-0085-00~~
 - ASSEMBLE ALL RETAINER RINGS WITH BURR SIDE AWAY FROM BEARING SURFACE.
 - CLEAN V.F.O. SHAFT, ASSEMBLE & CEMENT INSULATOR (2) TO SHAFT OF OSC. (9) WITH BONDING AGENT (55), R313, AS SUPPLIED BY CARL H. BIGGS CO, LOS ANGELES, CALIF, OR EQUAL, & AIR DRY 24 HOURS.
 - IN ALL SALT BALLOONS TOP FIGURE IS MATERIAL LIST ITEM INDICATOR & BOTTOM FIGURE IS QUANTITY.
 - FOR LIMITING DIMENSIONS SEE SM-D-248782 (33).

QTY	ITEM NO.	RECD	PART NO.	DESCRIPTION	MAT'L	MAT'L SPEC	NOTES	
343	0186	00	71	12	M535216-39	SCREW		
264	4080	40	69	1	M59007812	FUSE - F0203A00A		
310	0072	00	68	18	M535338-80			
310	0282	00	67	50	M535338-79			
373	0010	00	66	5	M535336-11	WASHER		
343	0185	00	65	4			-38	
343	0170	00	64	18			-26	
343	0169	00	63	10			-25	
343	0168	00	62	12			-24	
343	0167	00	61	4			-23	
343	0166	00	60	4	M535216-22			
342	0081	00	59	8	M535200-93			
342	0063	00	58	8	M535200-26	SCREW		
			57					
005	0353	00	56		GREASE		13	
005	0308	00	55		BONDING AGENT		22	
334	0483	00	54	4	NUT-4-40NC-28 3/16 58	STEEL	2	
313	0476	00	53	4	NUT-8-32 NF-28	STEEL	347	
313	0445	00	52	7	NUT-6-32NC-28 1/4 44	CRCS	346	
310	0448	00	51	2	WASHER-FLAT, #8	CRCS	344	
310	0446	00	50	8	WASHER-FLAT, #6	CRCS	345	
324	0666	00	49	2	SCREW-SOCKET HD.	STEEL ASA B18.3	9	
324	0665	00	48	4	SM-D-249101	SCREW-SOCKET HD.	STEEL ASA B18.3	8
			47					
558	0487	004	46	1	SM-D-249135	PANEL ASSY - REAR		
558	0486	004	45	1	SM-D-249134	PANEL ASSY - FRONT		
558	0309	003	44	1	SM-C-283206	RELAY - COAXIAL		
			43					
558	0266	002	42	15	SM-B-283170	SCREW-SET		
558	0193	002	41	2	SM-B-249243	TUNING		
558	0192	002	40	2			-3	
558	0191	002	39	5			-2	
558	0190	002	38	8	SM-B-249242-1	KNOB - BAR		
558	0158	002	37	1	SM-B-249221	SUPPRESSOR-NOISE		
558	0127	002	36	2	SM-B-249205	CLAMP - CABLE		

QTY	ITEM NO.	RECD	PART NO.	DESCRIPTION	MAT'L	MAT'L SPEC	NOTES
558	0116	002	35	1	SM-B-249204	CLAMP - CABLE	
558	0112	002	34	3	SM-B-249200	CLAMP - CABLE	
558	0507	004	33	REF	SM-D-248782	FRAME ASSY	24
558	0506	004	32	1	SM-B-249154	SPRING - GROUNDING	
558	0117	002	31	1	SM-B-249203	CLAMP - CABLE	
558	0493	005	30	1	SM-C-249141	WIRING ASSY	1
558	1325	00	29	25	SM-D-249140	INSULATION	MIL-J-5190
558	0467	002	28	1	SM-B-249115	CABLE ASSY - POWER	11
558	0485	002	27	1	SM-C-249133	PLATE ASSY - FLOOR	
558	0484	002	26	1	SM-C-249129	FRAME ASSY - LONG	
558	0480	002	25	1	SM-C-249128	FRAME ASSY - SHORT	
558	0479	002	24	1	SM-C-249121	FRAME ASSY - LEFT	
558	0478	002	23	1	SM-C-249126	FRAME ASSY - RIGHT	
343	0168	00	22	2	M535216-24	SCREW	20
343	0171	00	21	5	M535216-27	SCREW	20
558	0470	002	20	1	SM-B-249118	CABLE ASSY - I.F.	
558	0469	002	19	1	SM-B-249117	BRACKET ASSY - VFO	
			18				
558	0344	002	17	1	SM-B-249188	SHAFT ASSY	
558	0457	002	16	1	SM-B-249105	COVER	
558	0456	002	15	1	SM-C-249104	BRACKET - RELAY	
558	0453	004	14	1	SM-D-248854	FINAL ASSY - RE.	
558	0365	003	13	1	SM-C-249015	FINAL ASSY - IF	
558	0340	004	12	1	SM-D-248801	AUDIO ASSY	
558	0333	004	11	1	SM-D-248994	POWER SUPPLY ASSY	
558	0227	002	10	1	SM-B-248878	SHAFT - EXT	
558	0225	004	9	1	SM-B-248783	OSCILLATOR - 70M-12	
558	0066	002	8	2	SM-B-170763	CLAMP	
558	0065	002	7	4	SM-B-178414	CLAMP	
558	0060	002	6	2	SM-B-178433	WASHER	
558	0155	002	5	2	SM-B-178665	COUPLING ASSY	
558	0190	002	4	1	SM-B-178493	SHAFT	
558	0189	002	3	1	SM-C-178492	GUIDE	
558	0177	002	2	1	SM-B-178491	INSULATOR	
558	0276	002	1	1	SM-B-178481	SPRING	

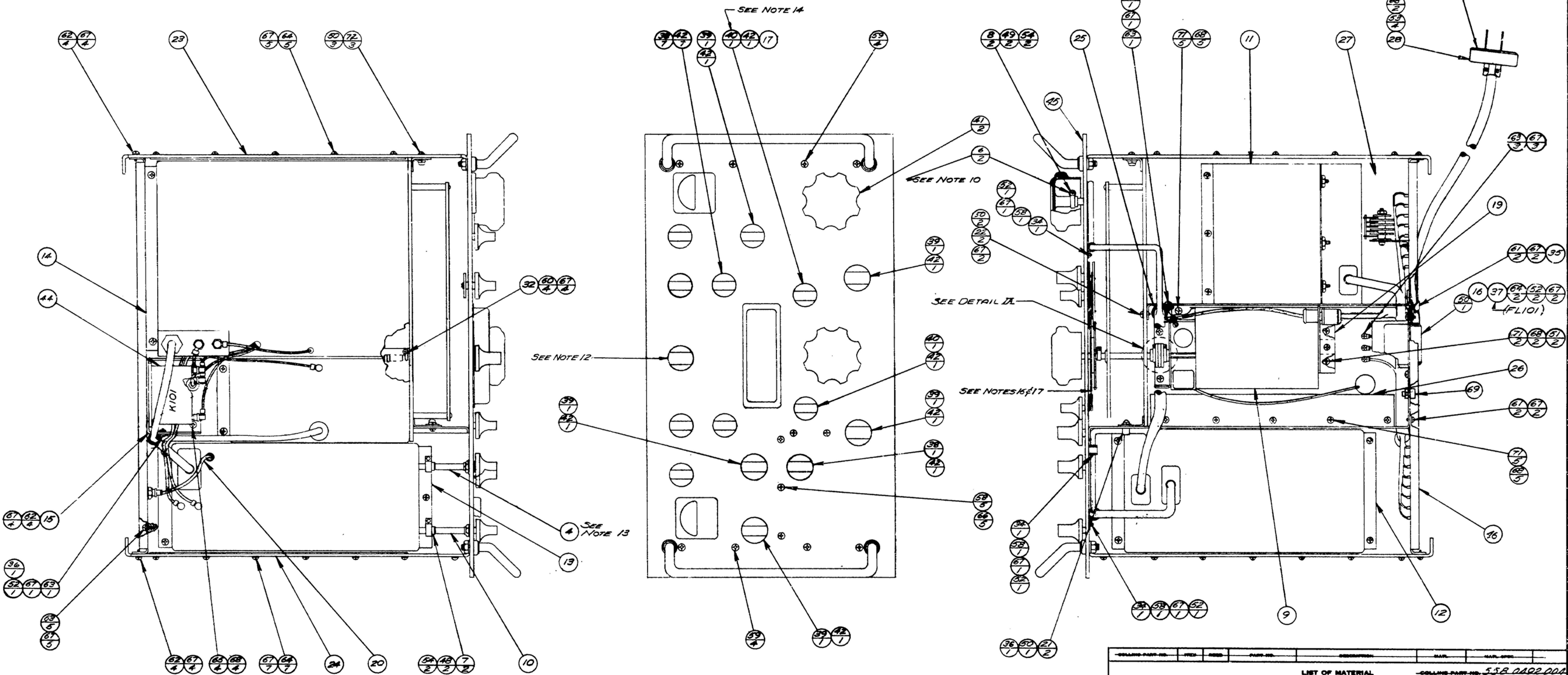
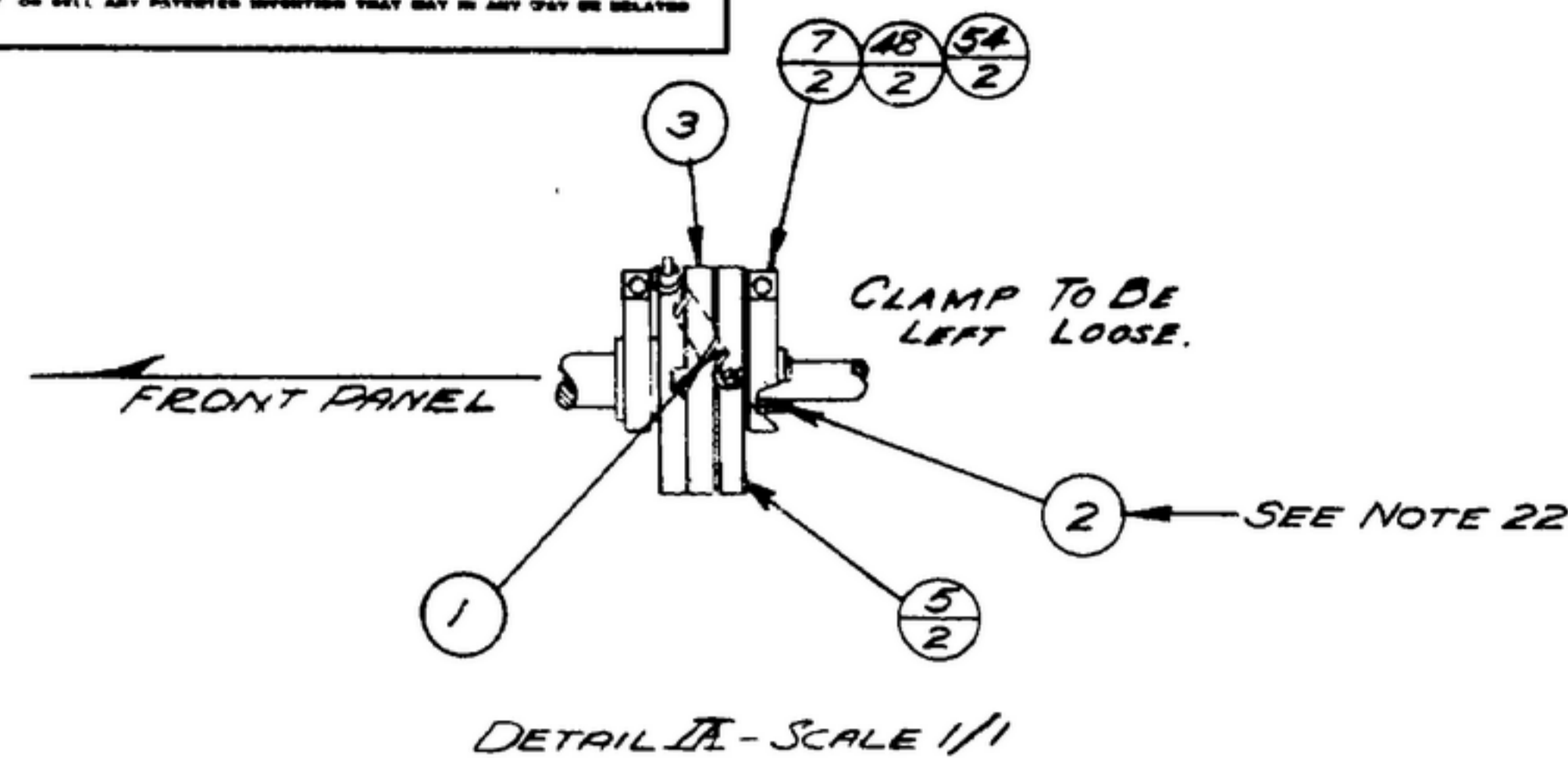
DRAWN L BRIGGS		CHECKED RG	APPROVED	DATE 30 DEC 55	SCALE 1/2
UNLESS OTHERWISE SPECIFIED: DECIMAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±.008 FRACTIONAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±1/64 BACHING UNLES MAY VARY ±.1 DRAINED ANGLES MAY VARY ±.25° BROKEN ANGLES MAY VARY ±.1° CIRCULARITY BETWEEN ANY DIAMETERS ON THE SAME CENTRELINE SHALL NOT EXCEED .010 TOTAL, INDICATOR READING. ALL DIMENSIONS ARE FINISH DIMENSIONS INCLUDING APPLIED FINISH AND ARE GIVEN IN INCHES.					
APPLICATION			RECEIVER ASSY		
DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY			SM-D-249140 SHEET 1 OF 2 SHEETS		

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REVISIONS			
BY	DESCRIPTION	DATE	APPROVAL



COLLINS PART NO.	QTY	REQ.	PART NO.	DESCRIPTION	MATERIAL	MAN. SPEC.
LIST OF MATERIAL						
-COLLINS PART NO. 55B 2492 005						

DRAWN R. R. E. CHECKED [Signature] APPROVED UNLESS OTHERWISE SPECIFIED: DECIMAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±.005 FRACTIONAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±1/64 MACHINED ANGLES MAY VARY ±.1° BREAKED ANGLES MAY VARY ±.25° BROKEN ANGLES MAY VARY ±.1° ECCENTRICITY BETWEEN ANY DIAMETERS ON THE SAME CENTERLINE SHALL NOT EXCEED 1/10 TOTAL INDICATOR READING. ALL DIMENSIONS ARE FINISH DIMENSIONS INCLUDING APPLIED FINISH AND ARE GIVEN IN INCHES.	COLLINS BASIS OR 14214-PH-51-93 SIGNAL CORPS REVIEWED PME APPROVED HLY PME DATE 30 DEC '55 SCALE 1/2	DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY 5M-D-249140 SHEET 2
APPLICATION 55B-2491-004-1 5M-D-249176 9C-DL249175 COLLINS NO. NEXT ARMY USED ON	RECEIVER ASSY	