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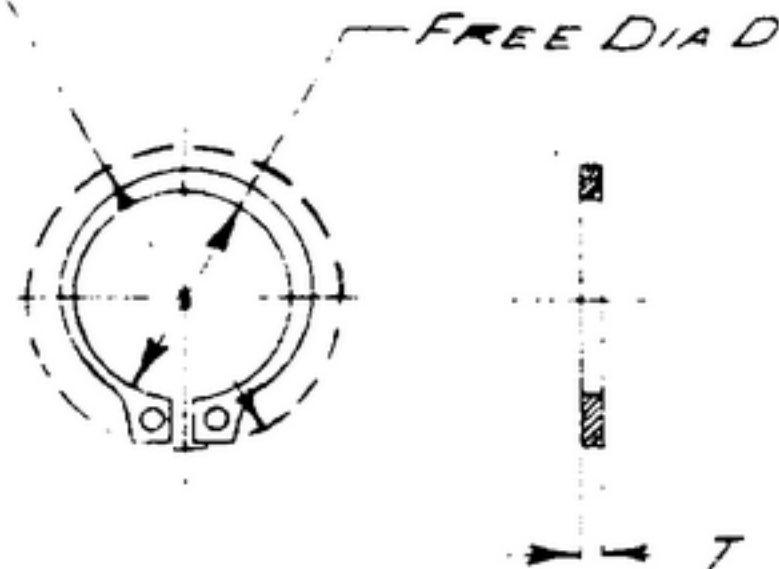
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FOR INFORMATION ONLY, CONTRACTOR MAY AT HIS OPTION DEVIATE FROM THESE PROCESS DETAILS.

~~S.W.E. APPROVAL~~
 SYM *PR10042*
 A *CA-84590*

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
<i>A1</i>	<i>A1 REVISED "C" DIM. ADDED SM-B-28317I-4</i>	<i>10 DEC 59</i>	<i>42428-PC-59</i> <i>REV'D PME</i>

C = MINIMUM CLEARANCE DIAMETER WHEN RING IS SPREAD OVER SHAFT



COLLINS No.	DASH No.	WALDES #5100-	RING DIM.		
			D	T	C
5590267002	SM-B-28317-1	25	225	0.250	.450
5590268002	-2	31	.281	0.250	.540
5590269002	-3	43	.395	0.250	.660
	-4	12	.112	.012	.222

TOLERANCES			
THICKNESS T	TOL	DIA. D	TOL
<i>.0250</i>	<i>± .0015</i>	<i>.225</i>	<i>+ .002</i> <i>- .002</i>
		<i>.281-.395</i>	<i>+ .002</i> <i>- .002</i>

NOTES:
 1. MAY BE SUPPLIED BY WALDES KOH-I-NOOR, INCORPORATED, LONG ISLAND CITY NEW YORK OR EQUAL, PROVIDING IT MEETS THE FOLLOWING REQUIREMENTS AND DIMENSIONS SHOWN.

MATERIAL: BERYLLIUM COPPER

	<i>SM-B-144666</i>
	<i>SM-D-144678</i>
	<i>SM-B-144798</i>
	<i>SM-B-144826</i>
	<i>SM-C-144864</i>
	<i>SM-L-144877</i>
	<i>SM-D-144916</i>
	<i>SM-D-144927</i>
	<i>SM-B-144989 SC-DL-144500</i>
	<i>SM-D-143843 SC-DL-143280</i>

COLLINS PART NO.	ITEM	REQD	PART NO.	DESCRIPTION	MATL	DATE SPEC
LIST OF MATERIAL						
COLLINS PART NO <i>559-0269</i> <i>0267</i> <i>0262</i>						

558 0292 002	1	SM-B-248943	
558 0396 004	1	SM-D-249007	
558 0324 004	4	SM-D-248975	
558 0316 003	1	SM-C-248967	
558 0300 003	1	SM-C-248961	
558 0309 003	1	SM-C-248960 SC-DL-248775	
COLLINS NO.	QTY	NEXT ASSY	USED ON

DRAWN *ECS* CHECKED *BL* APPROVED

UNLESS OTHERWISE SPECIFIED
 DECIMAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ± .005
 FRACTIONAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ± .004
 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 0.10 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 *HLY*
PME

DATE *18 JAN 56* SCALE _____

RING-RETAINER

DEPARTMENT OF THE ARMY
 SIGNAL CORPS ENGINEERING
 LABORATORIES

FORT MONMOUTH NEW JERSEY

SM-B-28317I