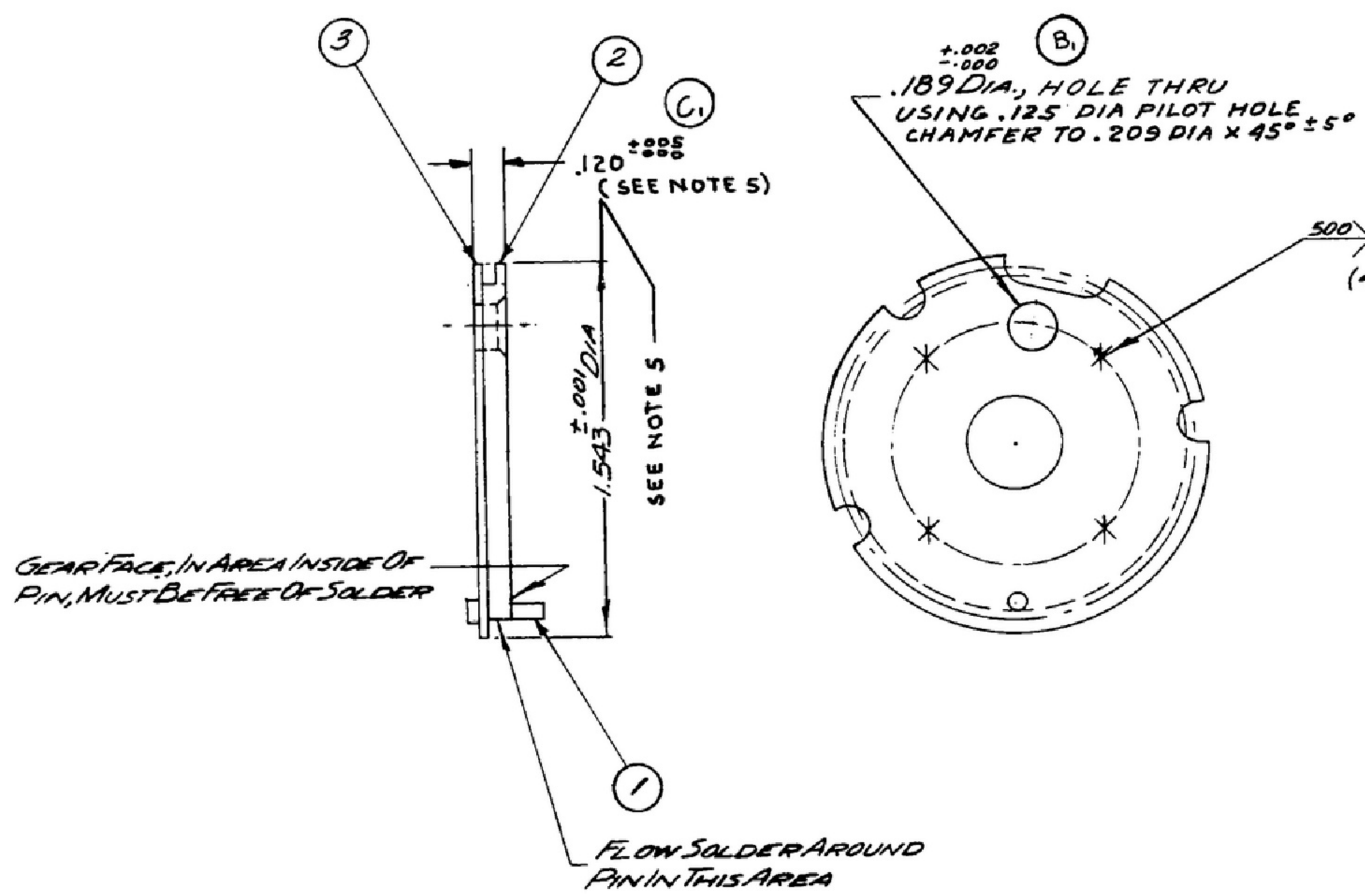


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SWE APPROVAL		REVISIONS			
SYM	PR10042-5	SYM	DESCRIPTION	DATE	APPROVAL
<del>A<sub>1</sub></del>	<del>PR10042-5</del>	A <sub>1</sub>	A <sub>1</sub> SOLDER WAS CLASS 4 OR 6 USING FLUX PER USNAVY SPEC 51 F4	9 OCT 59	42428-PC 59-A1-51 REV'D PME
<del>B<sub>1</sub></del>	<del>CA 84590</del>	B <sub>1</sub>	B <sub>1</sub> NOTATION WAS .189 ± .003 DIA USING .125 DIA PILOT HOLE	10 DEC 59	42428-PC 59 REV'D PME
<del>C<sub>1</sub></del>	<del>CA 84875</del>	C <sub>1</sub>	C <sub>1</sub> ADDED .120 ± .003 DIM C <sub>2</sub> ADDED NOTE # 8	17 OCT 60	42428-PC 59 REV'D PME



*FINISH: E 300 PER SPEC. MIL-F-14072  
\*COLLINS 580 0025 00*

- NOTES:**
1. SILVER SOLDER SHALL BE PER SPEC QQ-S-56, CLASS 4 USING FLUX PER U.S. NAVY SPEC. O-F-499
  2. WELDING SYMBOLS SHOWN IN ACCORDANCE WITH JAN-STD-19.
  3. WELDING SHALL BE IN ACCORDANCE WITH SPEC MIL-W-6858.
  4. ANY PROJECTIONS CAUSED BY SPOTWELDING MUST BE REMOVED.
  5. REWORK O.D. OF GEAR (2) & PLATE (3) TO DIMENSIONS SHOWN.
  6. ECCENTRICITY BETWEEN O.D. & BORE MUST NOT EXCEED .002 T.I.R.
  7. PRESS C'SUNK SIDE OF PLATE (3) AGAINST GEAR (2) & SHOULDER OF PIN (1) SNUG AGAINST PLATE. SILVER SOLDER PIN & SPOTWELD PLATE & GEAR AS SHOWN.
- C<sub>2</sub> B** GRIND SURFACE OF GEAR (2) AFTER SPOTWELDING AND BEFORE SILVER SOLDERING PIN (1) IF NECESSARY TO MAINTAIN DIM SHOWN

QTY	SYM	REQD	PART NO.	DESCRIPTION	MATL	MATL SPEC	NOTES
5	A <sub>2</sub>	AS REQ'D	15130296	FLUX			1
4	A <sub>2</sub>	AS REQ'D	105130020	SOLDER, SILVER			1
3	1		SM-B-248926	PLATE-LOCKING			
2	1		SM-B-248925	GEAR-INTERMITTENT			
1	1		SM-B-17826	PIN			

**LIST OF MATERIAL** *COLLINS PART NO. 580 0318 003*

<p>DRAWN <b>NUGEN</b></p> <p>CHECKED <i>[Signature]</i></p> <p>APPROVED _____</p> <p>UNLESS OTHERWISE SPECIFIED:                  DECIMAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±.009                  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.</p>	<p>COLLINS-RADIO CO. -8800-84100-100A <b>14214-PH-51-93</b></p> <p>SIGNAL CORPS</p> <p>REVIEWED <b>PME</b></p> <p>APPROVED <b>HLV</b> <b>PME</b></p> <p>DATE <b>30 DEC 55</b> SCALE <b>2/1</b></p>	<p>DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES</p> <p>FORT MONMOUTH NEW JERSEY</p> <p><b>SM-C-248969</b></p>
<p>358 0319 003 + SM-C-248970 SCDL-248775</p> <p>COLLINS NO. <b>874</b> NEXT ASSY USED ON</p> <p>APPLICATION _____</p>		