

EQUIP TYPE *R390A/URR* EXP. NO.

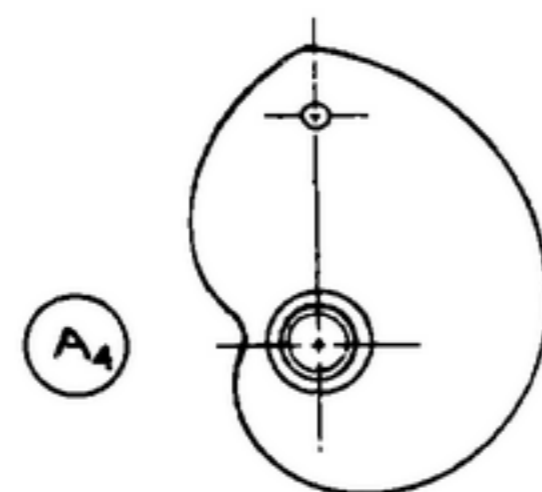
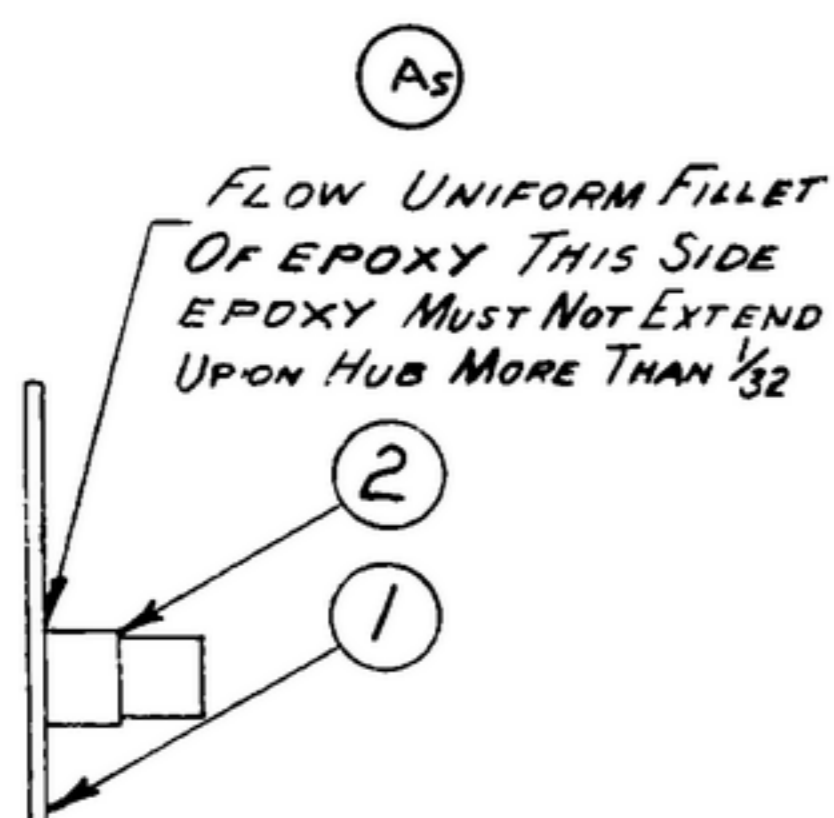
COL. 541-1101-003

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* SWE APPROVAL		REVISIONS			
SYM	PR10042-5	SYM	DESCRIPTION	DATE	APPROVAL
		A ₉	A ₁ NOTE 2 WAS SOFT SOLDER USING COMP SN 40 OR SN50 PER SPEC QQ-S-571. USE KESTER SOLDERING FLUX FORMULA 817 MFR BY KESTER SOLDER CO. CHICAGO ILL OR EQUAL A ₂ REMOVED NOTE 3 THE THROW AT THE BASE REF(0°) IS TO BE .395 ±.003 THE RISE FROM 0° TO 270° IS TO BE .0032 PER DEGREE & MUST BE ACCURATE WITHIN ±.001 THROW IS FROM CENTER OF HUB TO CENTER .250 DIA FOLLOWER CAM TO BE GROUND AFTER A ₅ 'Y A ₃ REMOVED CAM RETURN DATA A ₄ REMOVED 270°, 0° REF, & 90° A ₅ EPOXY WAS SOLDER A ₆ NOTE 3 WAS 4 A ₇ ADDED ITEM 3, 4, 5 A ₈ ITEM 1 WAS SM-B-283274 A ₉ SWE PART NOS WAS COLLINS NOS	9 OCT 59	42428-PC 59-AI-SI REV'D PME
		B ₃	B ₁ WAS IIP205114 B ₂ WAS IIP205113 B ₃ WAS IIP205112	17 MAY 60	42428-PC 59 REV'D PME
		C	(1) - ADDED NOTE # 4	22 FEB 61	42428-PC-59 REV'D PME



NOTES:

- PRESS HUB (2) IN CAM (1) SNUG AGAINST SHOULDER & BOND WITH EPOXY
- BOND WITH EPOXY CONSISTING OF EPON 828 (SHELL CHEMICAL CO. CHICAGO, ILL OR EQUAL) CURING AGENT BF3-400 (HARSHAW CHEMICAL CO. CLEVELAND, OHIO OR EQUAL) AND HEAVY GRADE TITANIUM DIOXIDE (TITANIUM PIGMENT CO, NATIONAL LEAD CO, N.Y., N.Y. OR EQUAL)
- CAMS MUST WITHSTAND 6 FT LBS TORQUE WITHOUT A EPOXY JOINT FAILURE
- REAM I.D. OF HUB TO .2492 ±.0002 DIA. AFTER ASS'Y.

* SWE PART NO.	ITEM	REQD	PART NO.	DESCRIPTION	MATL	MATL SPEC	NOTE
20P205114	5	AS REQ'D		FILLER			2
20P205113	4	AS REQ'D		ACTIVATOR			2
20P205112	3	AS REQ'D		EPOXY			2
	2	1	SM-B-283273	HUB - CAM			
	1	1	SM-D-178928	CAM			

LIST OF MATERIAL

COLLINS PART NO. 558-0496-003

DRAWN <i>ECS</i>				CHECKED <i>Rm</i>		APPROVED		COLLINS RADIO CO. CEDAR RAPIDS, IOWA <i>1421A-PH-51-93</i>		DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY	
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.				SIGNAL CORPS REVIEWED <i>PME</i> APPROVED <i>HLV</i> <i>PME</i>		CAM ASSY - <i>R.F.</i>		SCALE <i>1/1</i>		<i>SM-C-249144</i>	
APPLICATION				DATE <i>30 DEC 55</i>							