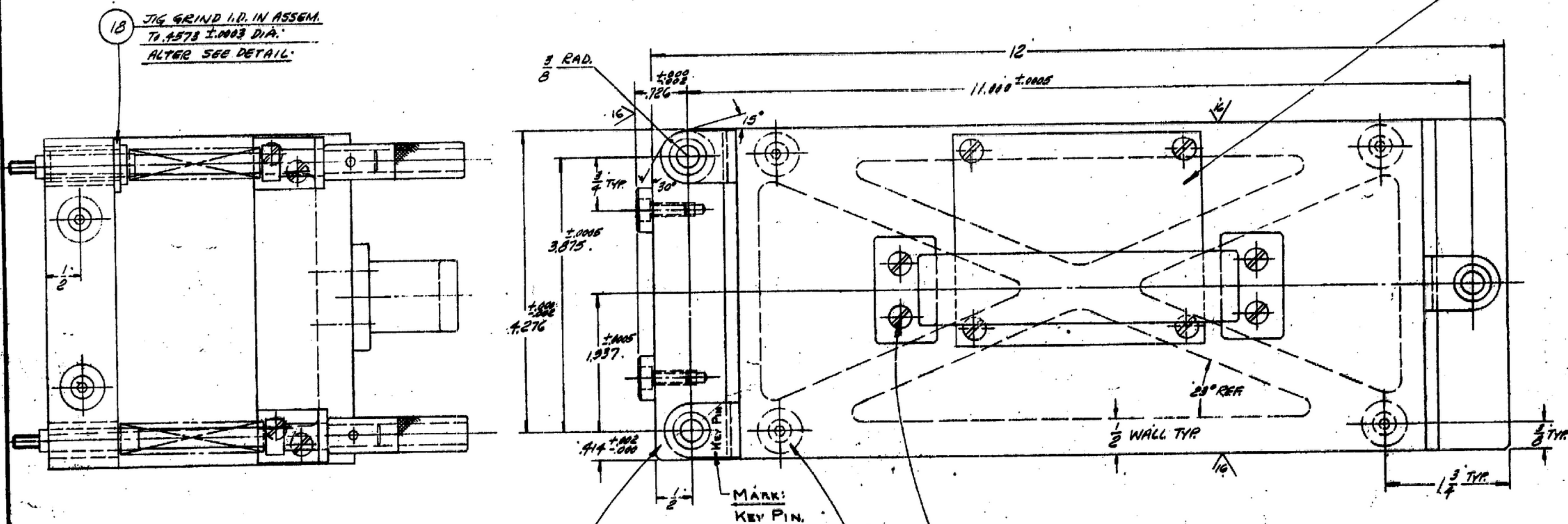


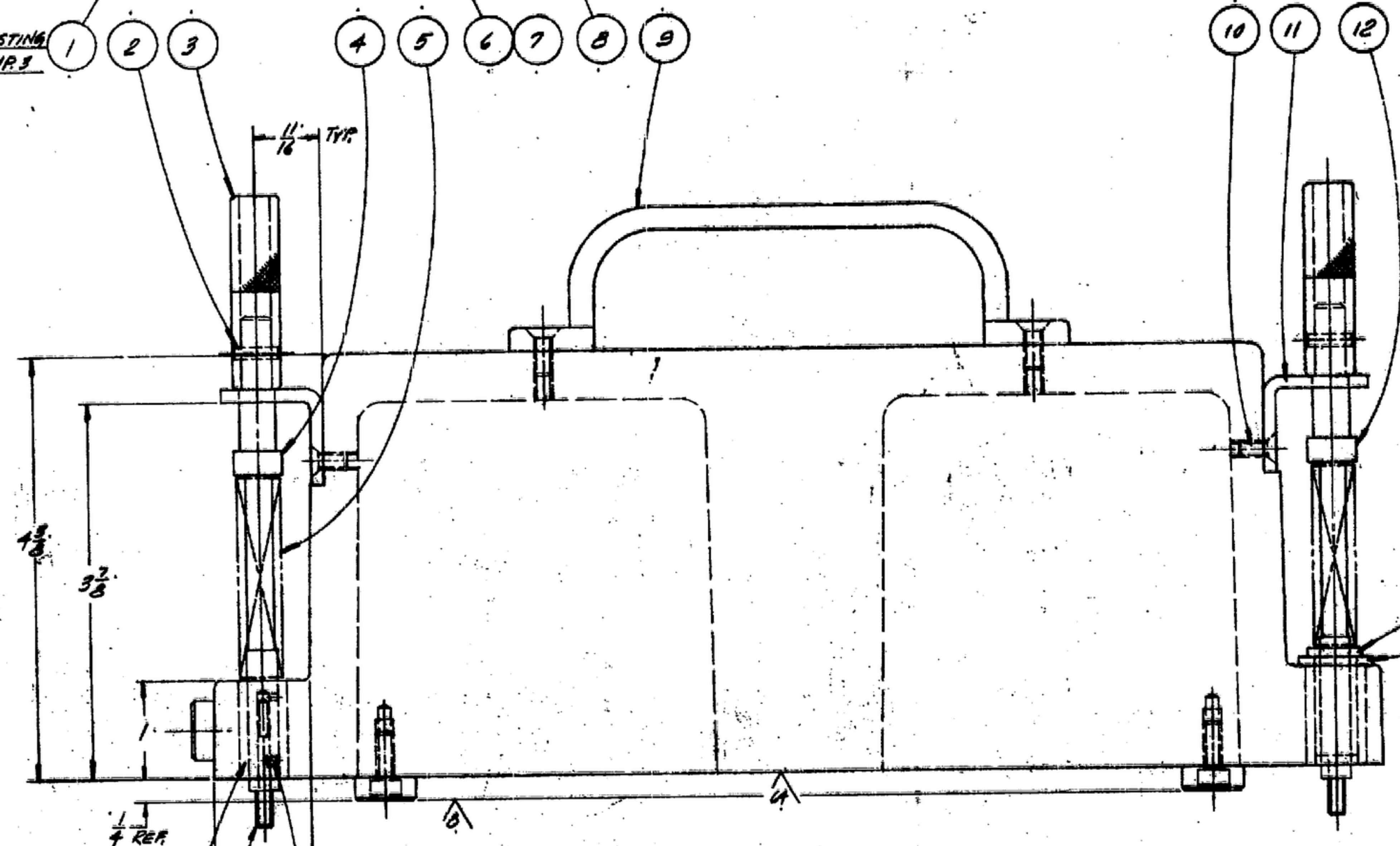
NOTE:
 *FOR INFORMATION ONLY, CONTRACTOR MAY AT HIS OPTION DEVIATE FROM THESE PROCESS DETAILS

ENGRAVE:
 R-390A/URR
 RECEIVER
 FRAME ASSY.
 CHECK LOC. OF 3 MTS HOLES
 & VOLUME FOR I.F. SUB-CHASSIS.
 SIG. C. INSP.
 57331
 (MFR'S NAME OR SYMBOL)



- NOTES:
- SUPPLIED BY SIENK TOOL CO.
 2862 E. GRAND BLVD. DETROIT 2, MICH. OR EQUAL
 - SUPPLIED BY THE STANLEY WORKS
 NEW BRITAIN, CONN. OR EQUAL
 - SUPPLIED BY ACME INDUSTRIAL CO.
 200 N. LAFLIN ST. CHICAGO 7, ILL. OR EQUAL
 - SUPPLIED BY H.E. MORSE CO.
 155 DOUGLAS AVE. HOLLAND, MICH. OR EQUAL
 - THIS GAGE WILL CHECK SM-D-57331
 - A PROTECTIVE FINISH PER SPEC. MIL-Q-10944 (ORD) SHALL BE APPLIED TO NON-FUNCTIONING, NON-GAGING & NON-LOCATING SURFACES TO PREVENT CORROSION. BLACK OR GRAY COLORS ARE PREFERRED.

ALUMINUM ALLOY SANDCASTING
 PER SPEC. QQ-A-601 COMP 3
 HEAT TREAT.



NO.	QTY.	DESCRIPTION	MATL.	MATL. SPEC.	NOTES
18	1	1/8" DIA. X 1/2" L. BUSH TYPE 5			3
17	2	1/8" DIA. X 1/2" L. BUSH TYPE 5			3
16	1	1/8" DIA. X 1/2" L. BUSH TYPE 5			3
15	3	1/8" DIA. X 1/2" L. BUSH TYPE 5	STEEL		
14	3	1/8" DIA. X 1/2" L. BUSH TYPE 5			4
13	1	1/8" DIA. X 1/2" L. BUSH TYPE 5			3
12	2	1/8" DIA. X 1/2" L. BUSH TYPE 5			
11	3	1/8" DIA. X 1/2" L. BUSH TYPE 5	AL. ALLOY		
10	6	1/8" DIA. X 1/2" L. BUSH TYPE 5			
9	1	1/8" DIA. X 1/2" L. BUSH TYPE 5			2
8	4	1/8" DIA. X 1/2" L. BUSH TYPE 5	STEEL		
7	6	1/8" DIA. X 1/2" L. BUSH TYPE 5			1
6	6	1/8" DIA. X 1/2" L. BUSH TYPE 5			
5	3	1/8" DIA. X 1/2" L. BUSH TYPE 5	WIRE	88-N-474	
4	1	1/8" DIA. X 1/2" L. BUSH TYPE 5			
3	3	1/8" DIA. X 1/2" L. BUSH TYPE 5	STEEL		
2	3	1/8" DIA. X 1/2" L. BUSH TYPE 5			
1	1	SM-D-57331-1 SANDCASTING	AL. ALLOY		

JIG GRIND I.D. IN ASSEM.
 TO .3125 ± .005 DIA.

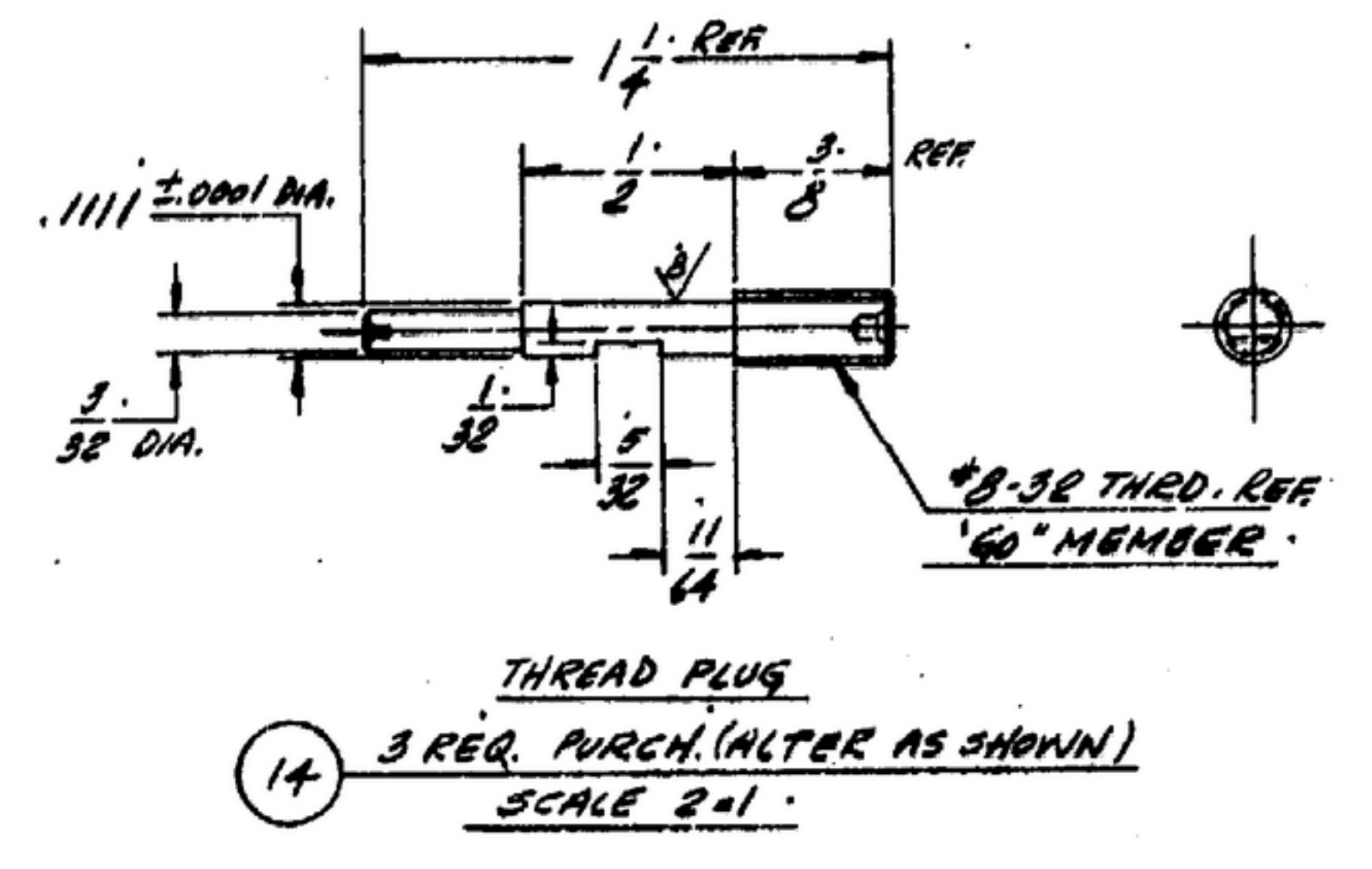
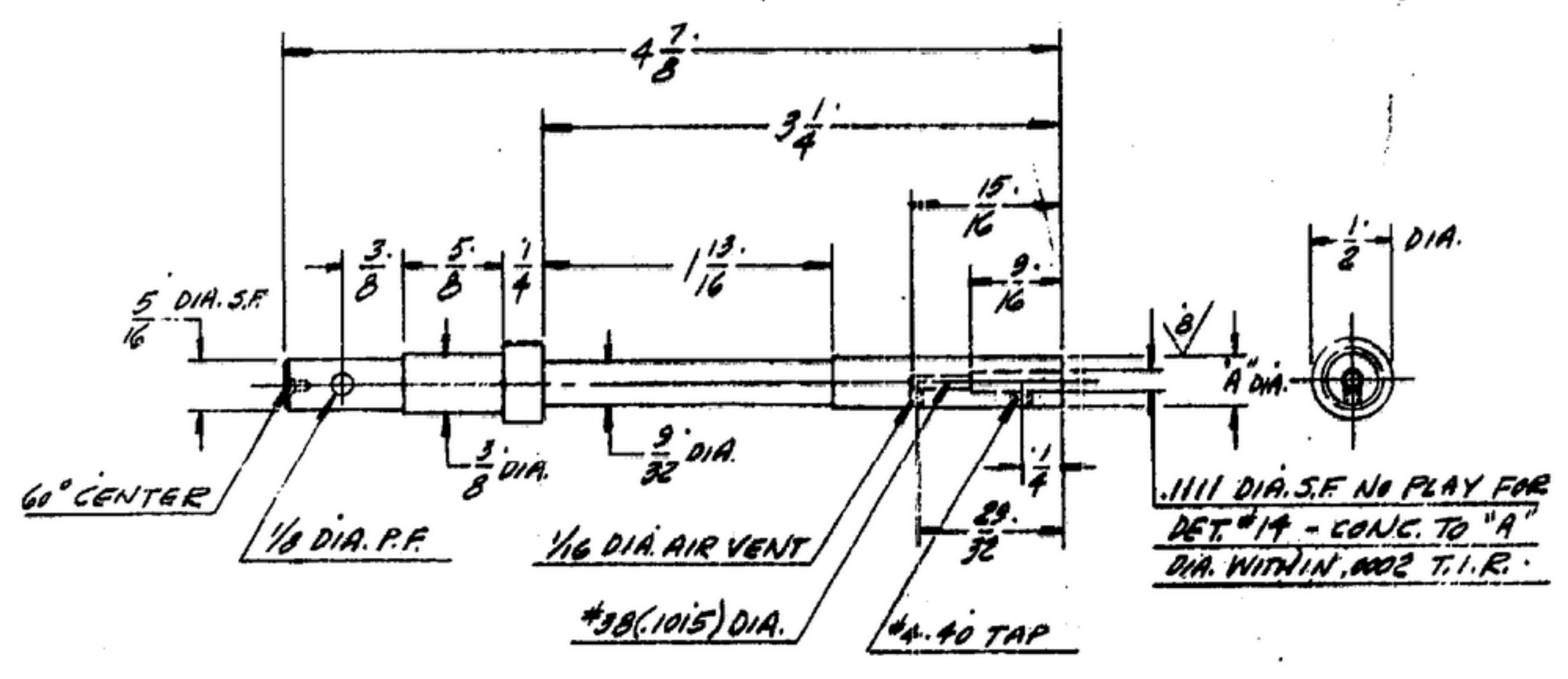
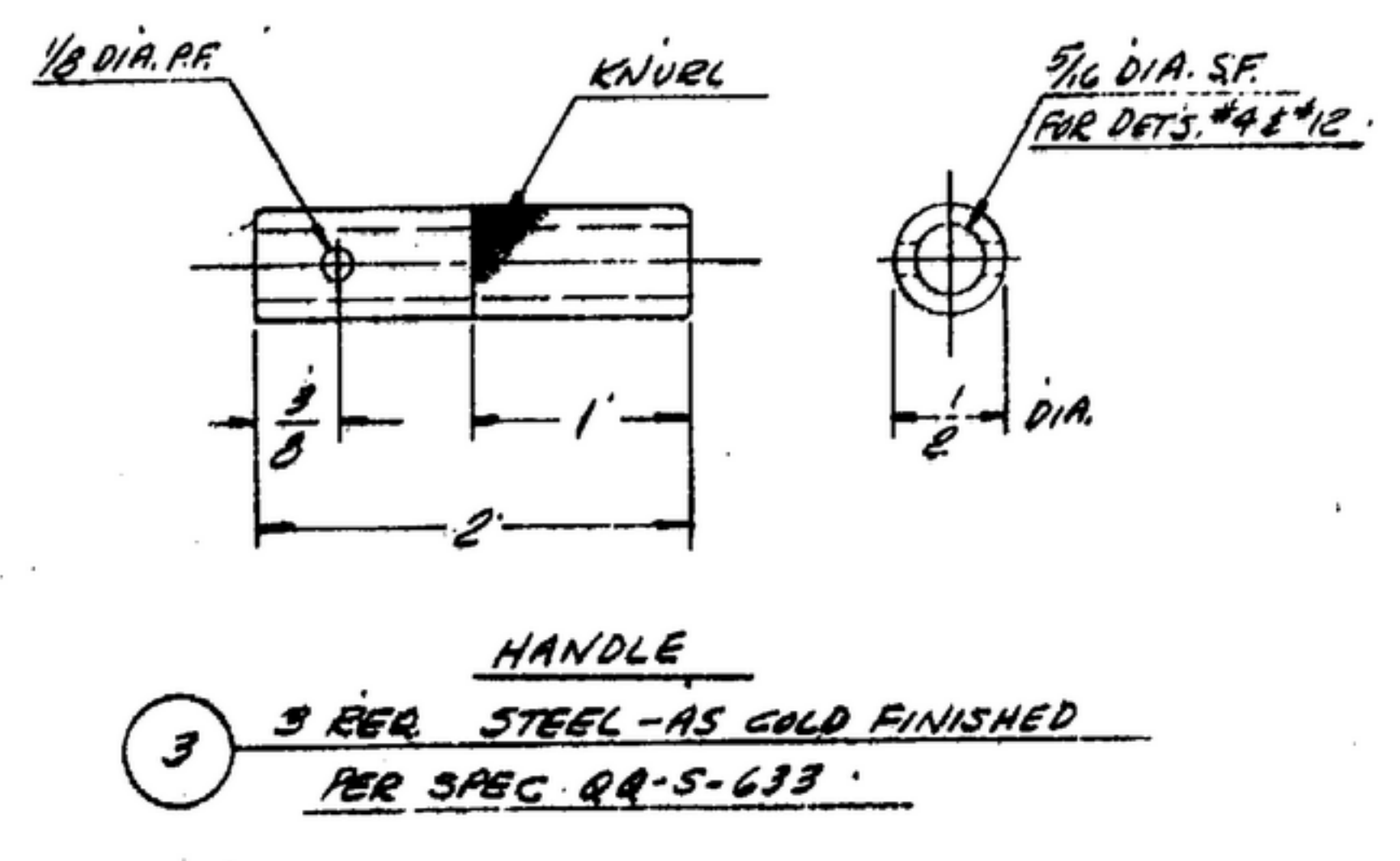
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES ± 1/32		DRAWING NO. 08719-PH-53-33 SIGNAL CORPS		VOLUME GAGE FOR MAIN FRAME, CHECK LOC. OF 3 HOLES FOR I.F. SUB-CHASSIS AND VOLUME.		DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY	
APPROVED M.H. PNE	DATE 17-10-55	SCALE FULL	WHEN REFERRING TO THIS DRAWING STATE DRAWING NO., APPLICABLE ISSUE & DATE	SM-D-57331 SHEET 1 OF 2			

NOTE: THIS DRAWING IS THE PROPERTY OF THE SIGNAL CORPS ENGINEERING LABORATORIES. IT IS TO BE USED ONLY FOR THE PURPOSES FOR WHICH IT WAS DESIGNED. IT IS TO BE KEPT IN A SAFE PLACE AND PROTECTED AGAINST LOSS, DAMAGE, OR DESTRUCTION. IT IS TO BE RETURNED TO THE SIGNAL CORPS ENGINEERING LABORATORIES WHEN NO LONGER REQUIRED.

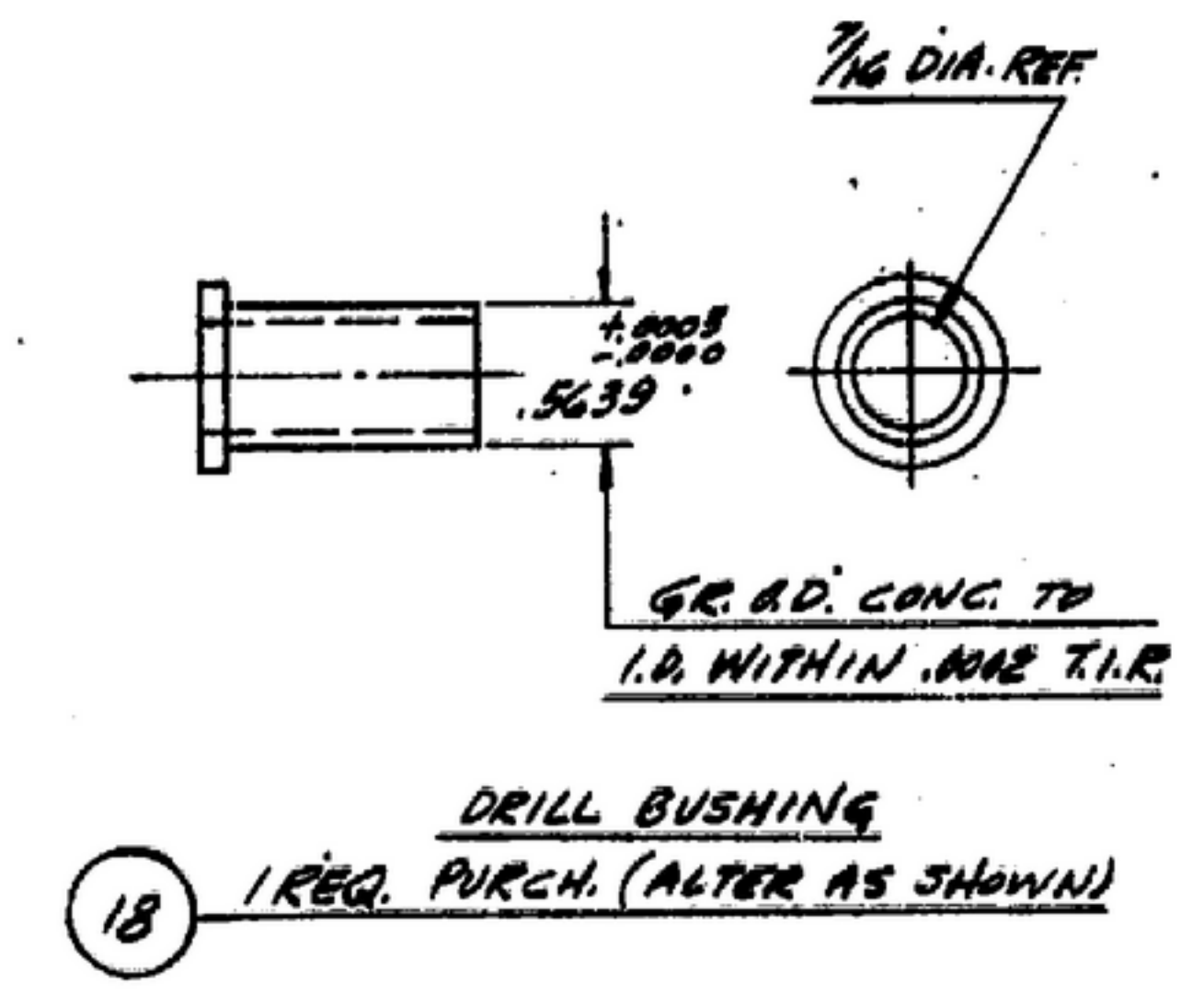
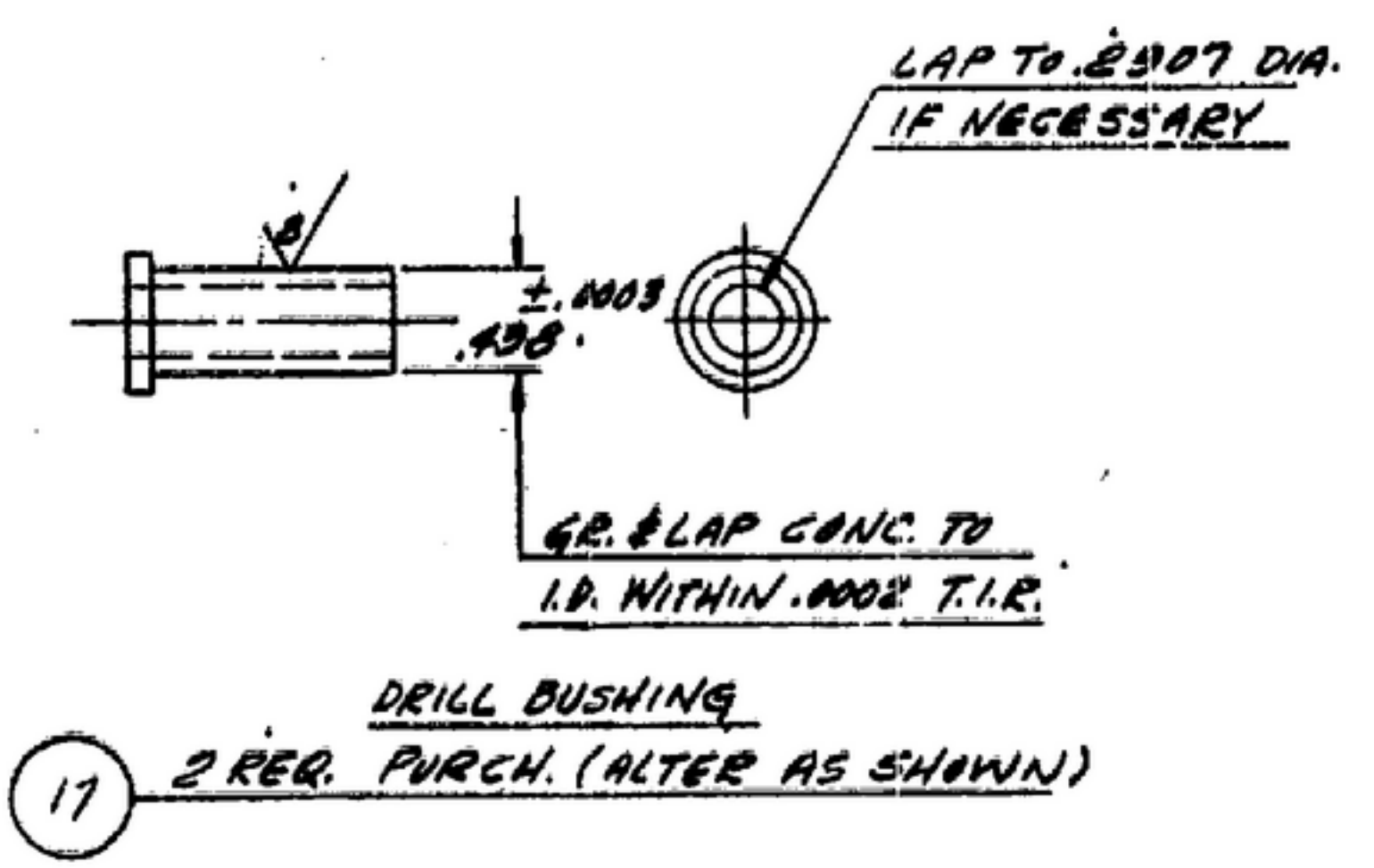
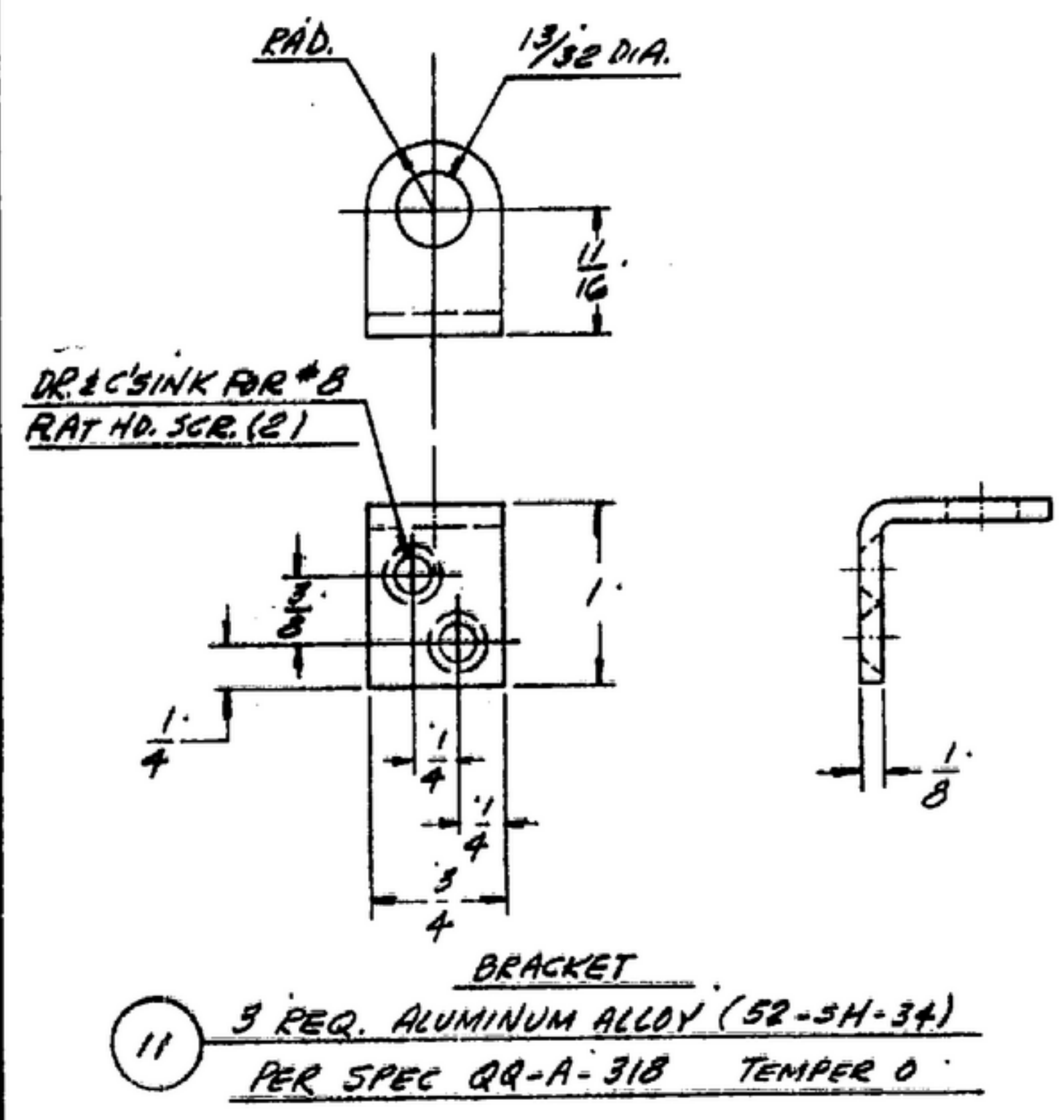
SYM	DESCRIPTION	DATE	APPROVAL
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NOTE:
* FOR INFORMATION ONLY, CONTRACTOR MAY AT HIS OPTION DEVIATE FROM THESE PROCESS DETAILS

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES...
DIMENSIONS ARE IN INCHES
FRACTIONS ON DECIMALS ANGLES
± 1/32



- PIN**
- 4 1 REQ. STEEL - FS-A2 PER SPEC QQ-S-00778
ROCK 'C' 62 MIN. "A" = .3125 DIA. S.F. IN DET #13
 - 12 2 REQ. STEEL - FS-A2 PER SPEC QQ-S-00778
ROCK 'C' 62 MIN. "A" = .2907 DIA. S.F. IN DET #17



PART NO.	DESCRIPTION	MATL.	MATL. SPEC.
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LIST OF MATERIAL

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ON DECIMALS ANGLES ± 1/32	ORDER # 13719-PH-55-93	VOLUME GAGE FOR MAIN FRAME CHECK LOG. OP 3 HOLES FOR I.F. SUB CHASSIS AND VOLUME	DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY SM-D-57331 SHEET 2 OF 2
	SIGNAL CORPS		
	REVIEWED PNF APPROVED M.H. PNF DATE 17-10-58	SCALE FULL	
NEXT ASSY USED ON APPLICATION	SC-DC-57592		