

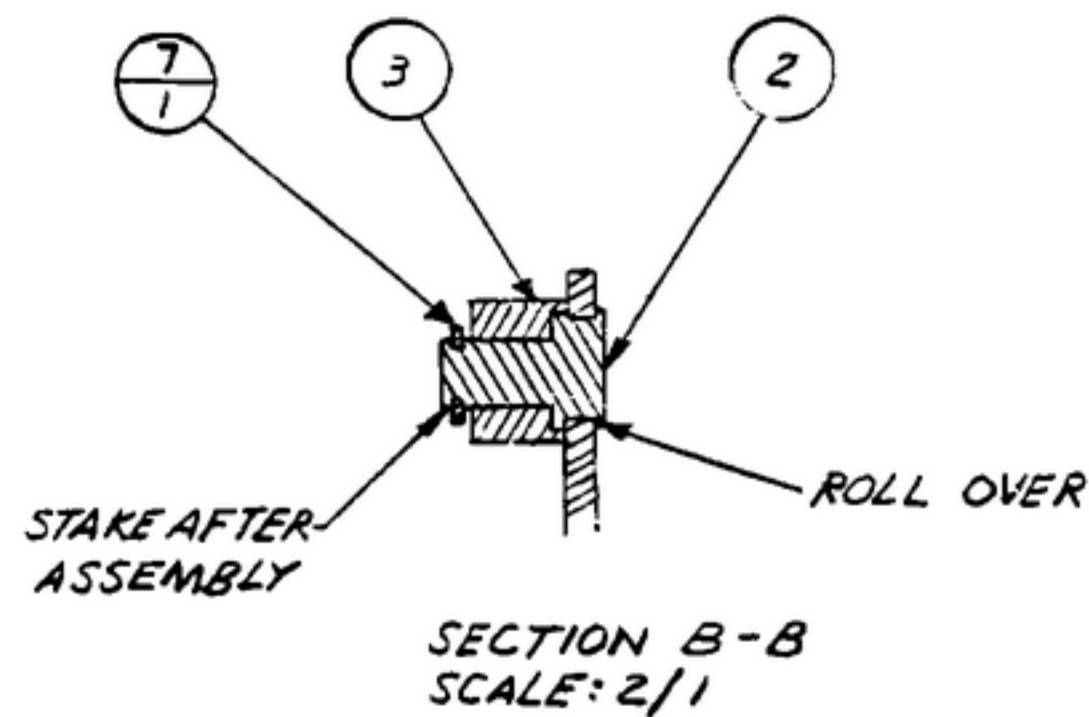
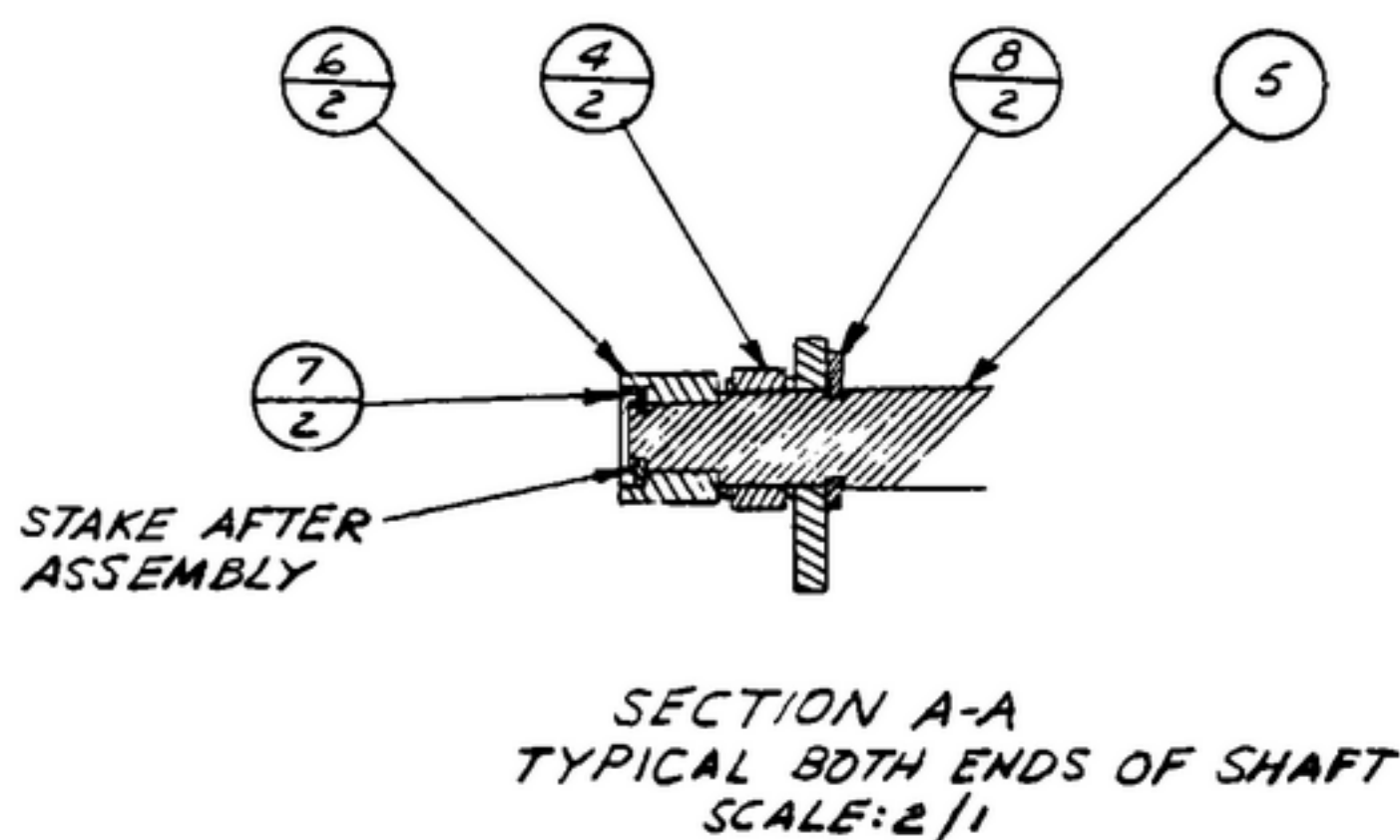
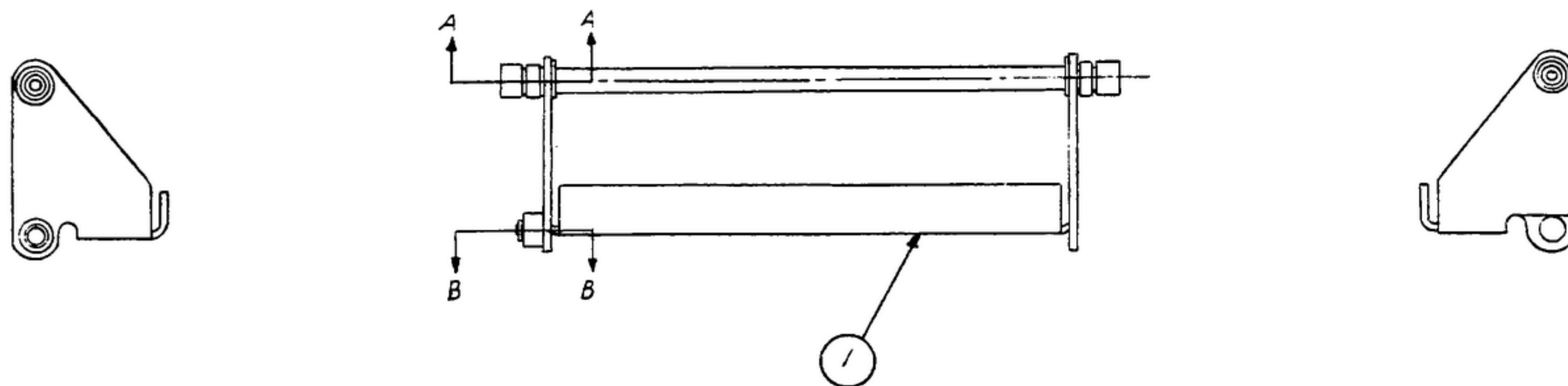
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NOTE: *FOR INFORMATION ONLY, CONTRACTOR MAY AT HIS OPTION DEVIATE FROM THESE PROCESS DETAILS

REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
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NOTES:
 1. ROLLERS MUST ROTATE FREELY AFTER STAKING.
 2. ROLLER BORE TO BE LUBRICATED WITH OIL (9) PER SPEC MIL-L-7870 BEFORE ASSY.
 3. IN ALL SPLIT BALLOONS TOP FIGURE IS MATERIAL LIST ITEM INDICATOR & BOTTOM IS QUANTITY.

ITEM	ASWE PART NO.	REQD	PART NO.	DESCRIPTION	MATL	MATL SPEC	NOTE
9	115111255-6	AS REQD		LUBRICANT			2
8		2	MS-16633-4017	RING, RETAINING			
7		3	SM-B-170822	WASHER			
6	574210	2	SM-B-178739	ROLLER			
5		1	SM-B-343611-1	SHAFT			
4		2	SM-B-343610-1	BEARING			
3		1	SM-B-343609	RETAINER			
2		1	SM-B-343608	PIN			
1		1	SM-C-249074	RACK-LOW			

LIST OF MATERIAL

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES		STEWART WARNER ELECTRONICS- ORDER NO. 42428-PC-59		RACK ASSY-I.F.		DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES	
		SIGNAL CORPS				FORT MONMOUTH NEW JERSEY	
SM-D-343629 SG-DL-248775		REVIEWED P.M.E.				SM-G-343631	
NEXT ASSY USED ON		APPROVED P.M.E.					
APPLICATION		DATE 26 OCT 59		SCALE 1/1			