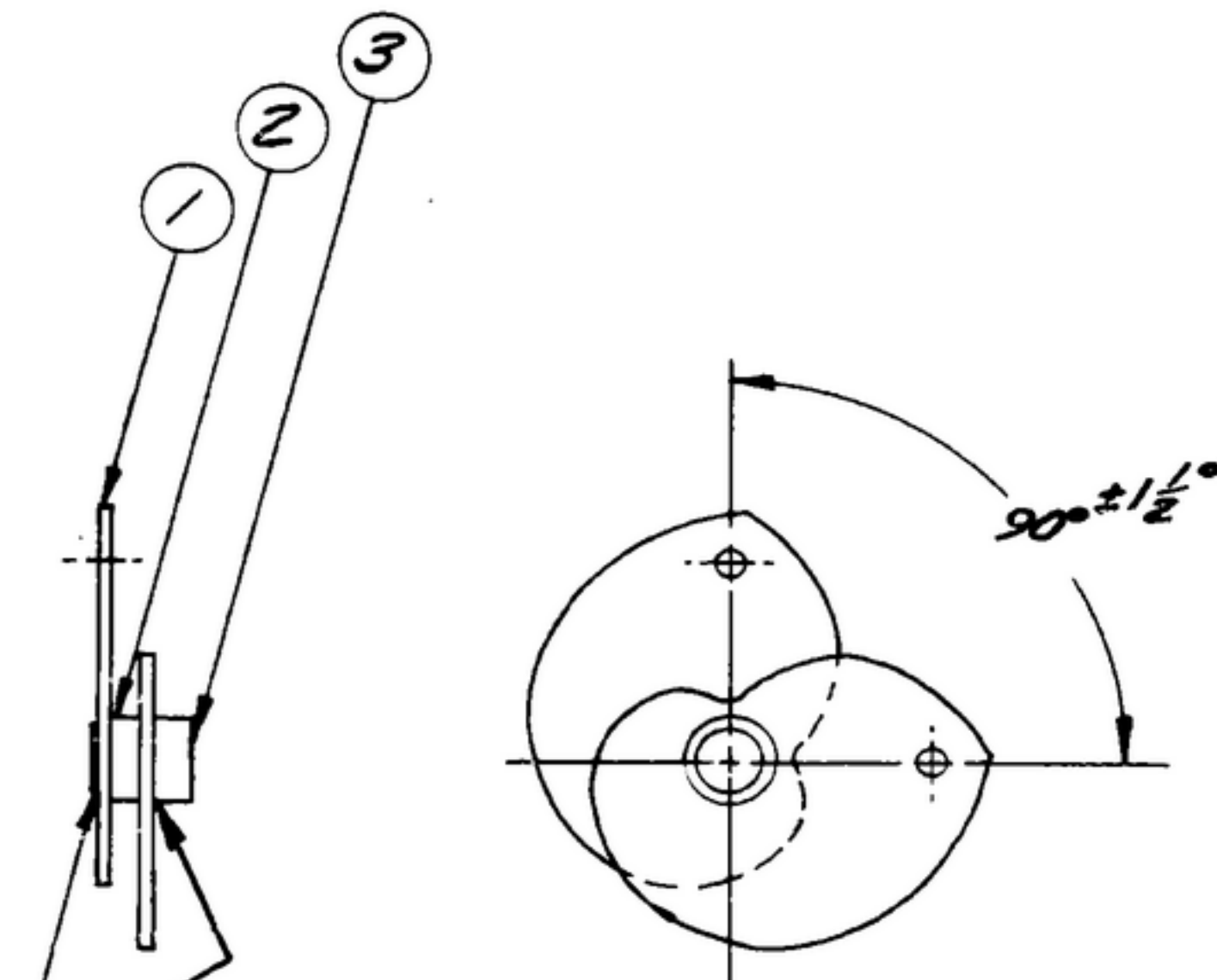


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REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A₀	A₁ IN NOTE 1 SOLDER WAS USED AS A BONDING AGENT A₂ ITEM 3 WAS SM-C-248973 A₃ NOTE 2 REFERRED TO SOLDER PER SPEC. QQ-S-571 & A COMMERCIAL FLUX A₄ WAS TORQUE WITHOUT A SOLDER JOINT FAILURE A₅ ADDED ITEMS 4, 5, & 6 A₆ ADDED IRIDITE #7 TO FINISH NOTE A₇ EPOXY WAS SOLDER A₈ DELETED CLEANING NOTE #4	9 OCT 59	4242B-PC 59-AI-51 REV'D PME
B ₃	B ₁ WAS IIP 205112 B ₂ WAS IIP 205113 B ₃ WAS IIP 205114	17 MAY 60	4242B-PC 59 REV'D PME
C ₂	C ₁ ADDED NOTE # 4 C ₂ REWORDED NOTE 1	22 FEB 61	4242B-PC 59 REV'D PME



NOTES:

- (C₂) 1. PRESS HUB (3) IN ONE OF THE CAM (1) SNUG AGAINST SHOULDERS OF HUB (3) INSERT BUSHING (2) THEN PRESS THE OTHER CAM (1) & BOND WITH EPOXY AS SHOWN
- (A₃) 2 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)
- (A₄) 3 CAM MUST WITHSTAND 6 FT LBS TORQUE WITHOUT AN EPOXY JOINT FAILURE
- (C₁) (A₈) 4 REAM I.D. OF HUB TO .2492 ± .0002 DIA AFTER ASS'Y

FINISH: CHEMICAL POLISH PER IRIDITE #7 METCOTE PROCESS BY ALLIED RESEARCH PRODUCTS INC, BALTIMORE, MD, OR EQUAL.
* COLLINS 580-0034-00

QOP	QTY	REQD	PART NO.	DESCRIPTION	MATL	MATL SPEC
20P205114	6	AS REQ'D		FILLER		
20P205113	5	AS REQ'D		ACTUATOR		2
20P205112	4	AS REQ'D		EPOXY		2
	3	/	SM-B-283271	HUB CAM		2
	2	/	SM-B-248882	BUSHING-CAM		
	1	/	SM-D-178928	CAM		

LIST OF MATERIAL *COLLINS PART NO. 580-0302-002*

DRAWN <i>LIPASCH</i>		CHECKED <i>EG</i>		APPROVED		-COLLINS RADIO CO. -SEAL RATED 1424-PH 51-93		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				<i>CAM ASSY - R.F.</i>
580-0034-002 / SM-B-248953 56-12-208715						REVIEWED <i>PME</i>				
-COLLINS NO. QTY NEXT ASSY USED ON						APPROVED <i>HLV</i> <i>PME</i>				
APPLICATION						DATE <i>3 MARCH 58</i> SCALE <i>1/1</i>		<i>SM-B-248953</i>		