

EQUIP. TYPE *R300ALWR* EXP. NO.

COL. 540 7929 003

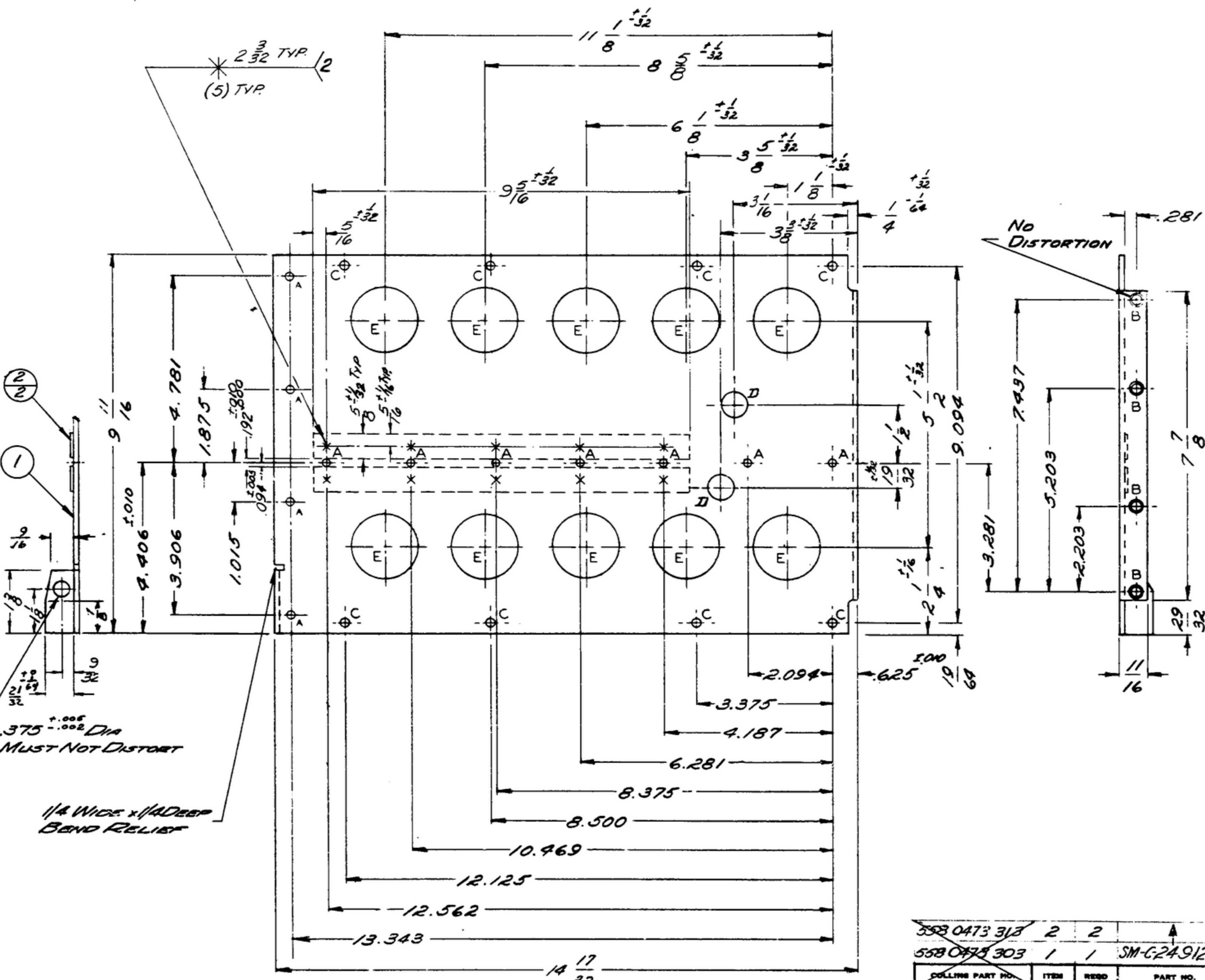
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*FOR INFORMATION ONLY. CONTRACTOR MAY AT HIS OPTION DEVIATE FROM THESE PROCESS DETAILS.

*When Part No. Appears As 558-0473 9-3 Military Source Inspection Is Required.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL



ALUMINUM ALLOY 525 TEMPER H32, PER SPEC. QQ-A-318, STIFFENER .051 THICK, FRAME: .128 THICK.
FINISH: E513 PER SPEC. MIL-F-14072.
* COLLINS 580-8036-00.

- NOTES:
1. ALL INSIDE BEND & RELIEF RADII 9/64 MAX.
 2. WELDING SYMBOLS SHOWN IN ACCORDANCE WITH JAN-STD-19, WELDING SHALL BE IN ACCORDANCE WITH SPEC MIL-W-6860.
 3. SPOTWELD LOCATION MAY VARY ±1/8.

1/8 WIDE x 1/4 DEEP BEND RELIEF

HOLE	SIZE	REQD
A	171 DIA C'BORE	11
B	268 ±.003 DIA & 343 DIA x .032 DEEP	4
C	203 ±.001 DIA	8
D	3/4 DIA	2
E	1 5/8 DIA	10

COLLINS NO.	QTY	NEXT ASSY	USED ON
558-0473-003	1	SM-C-249127	35DL-249127

DRAWN: JENNETT
CHECKED: Rlm
APPROVED: [Signature]

UNLESS OTHERWISE SPECIFIED:
DECIMAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±.005
FRACTIONAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±1/64
MACHINED ANGLES MAY VARY ±1°
BEADED 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.

COLLINS PART NO.	ITEM	REQD	PART NO.	DESCRIPTION	MATL	MATL SPEC
558-0473-313	2	2		2 STIFFENER		
558-0473-303	1	1	SM-C-249121-1	FRAME		

DEPARTMENT OF THE ARMY
SIGNAL CORPS ENGINEERING
LABORATORIES
FORT MONMOUTH NEW JERSEY
SM-C-249121

LIST OF MATERIAL - COLLINS PART NO. 558-0473-003

FRAME ASSY - LEFT SIDE

DATE 29 Dec 55 SCALE 1/2