

NOTE: THIS DRAWING IS A REVISION OF THE PREVIOUS EDITION AND SHOULD BE USED IN CONJUNCTION WITH THE PREVIOUS EDITION. THE REVISIONS ARE INDICATED BY THE LETTERS A THROUGH F. THE DIMENSIONS ARE GIVEN IN INCHES UNLESS OTHERWISE SPECIFIED.

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

When Part Number Applies As 558-0474-003 Material Specified In Drawing To Be Used

FORM TYPE P390A/URP EXP. 10

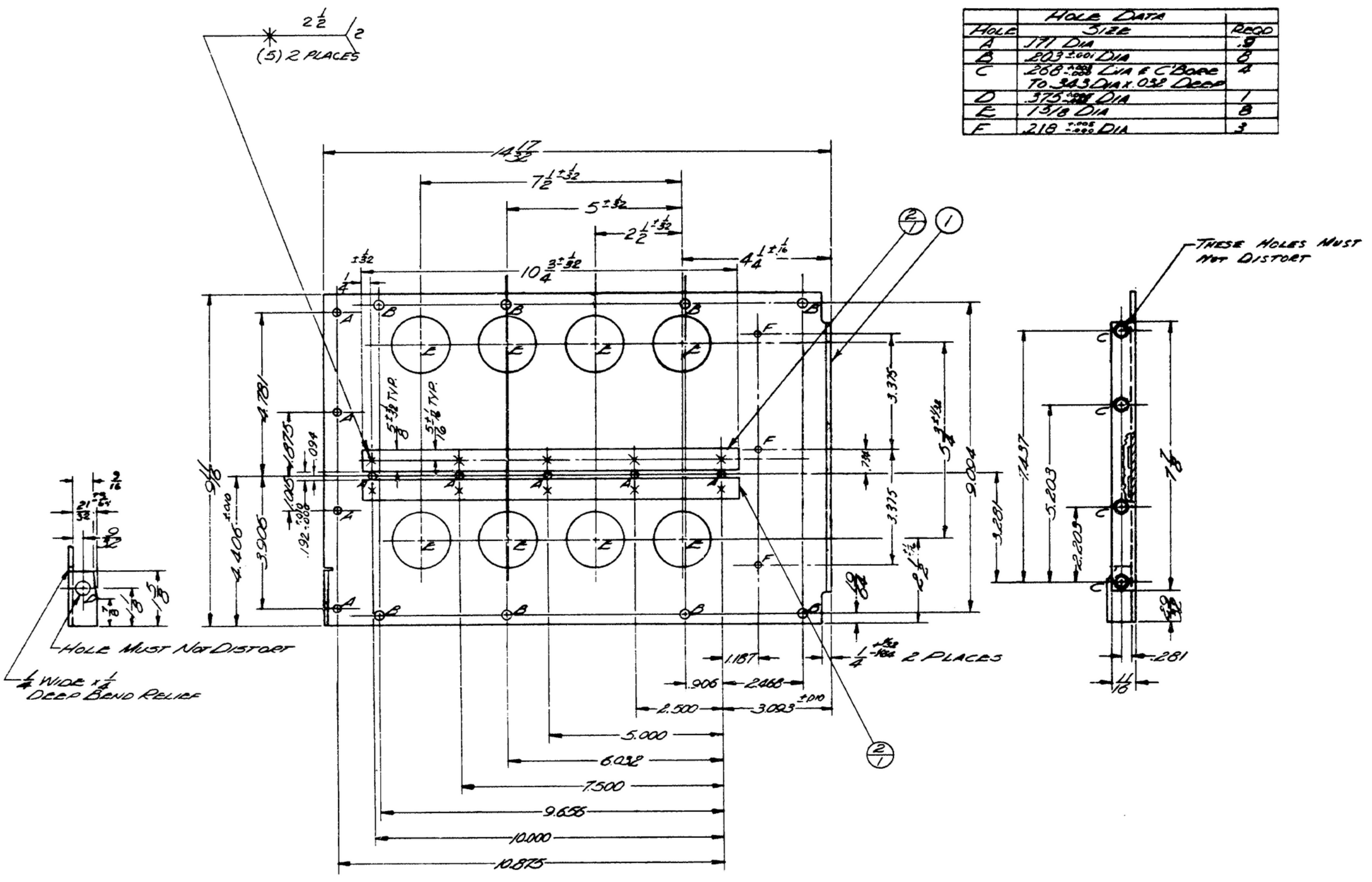
EX. 540-1230-003

REVISIONS			
BY	DESCRIPTION	DATE	APPROVAL

HOLE DATA		
HOLE	SIZE	QTY
A	1/4" DIA	8
B	3/8" DIA	8
C	208 DIA & C-BORE TO 3/4" DIA X 0.375 DEEP	8
D	3/8" DIA	1
E	1/8" DIA	8
F	218 DIA	3

MATL
 FRAME (1) ALUMINUM ALLOY 525, TEMPER H32, PER SPEC. QQ-A-318, 128 THICK
 STIFFENER (2) ALUM ALLOY 525, TEMPER H32, PER SPEC. QQ-A-318, .051 THICK
 FINISH: E513 PER SPEC. MIL-F-14072
 * GOVERNMENT SPEC. 588-0006-05

- NOTES:
1. ALL INSIDE BEND AND RELIEF RADII 9/64 MAX.
 2. WELDING SYMBOLS IN ACCORDANCE WITH JAN-STD-19 WELDING SHALL BE IN ACCORDANCE WITH SPEC MIL-W-6860.
 3. SPOTWELD LOCATIONS MAY VARY ±1/8.
 4. IN ALL SPOT WELDS TOP FIGURE IS MATERIAL LIST ITEM INDICATOR & BOTTOM FIGURE IS QUANTITY.



QTY	ITEM	REQ	PART NO.	DESCRIPTION	MATL.	MATL. SPEC.
2	2	2	2	STIFFENER		
1	1	1	1	FRAME		

DRAWN NUGEN CHECKED RAN APPROVED [Signature]	UNLESS OTHERWISE SPECIFIED: DIMENSIONS INCLUDING HOLE SIZES MAY VARY 2.00 PRACTICAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY 21/64 BORE AND ANGLE MAY VARY ±.01 BORE ANGLE MAY VARY ±.01 CONCENTRICITY BETWEEN ANY DIMENSIONS ON THE SAME CENTRAL AXIS SHALL NOT EXCEED 21/64 TOTAL INDICATOR READING ALL DIMENSIONS ARE GIVEN UNLESS OTHERWISE APPLIED FINISH AND ARE GIVEN IN INCHES	14214-PH-51-93 SIGNAL CORPS REVIEWED PHE APPROVED HLY PHE DATE: 30 DEC 55 SCALE: 1/2"	LIST OF MATERIAL FRAME ASSY - EIGHT SIDE DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH, NEW JERSEY SMD-249122
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