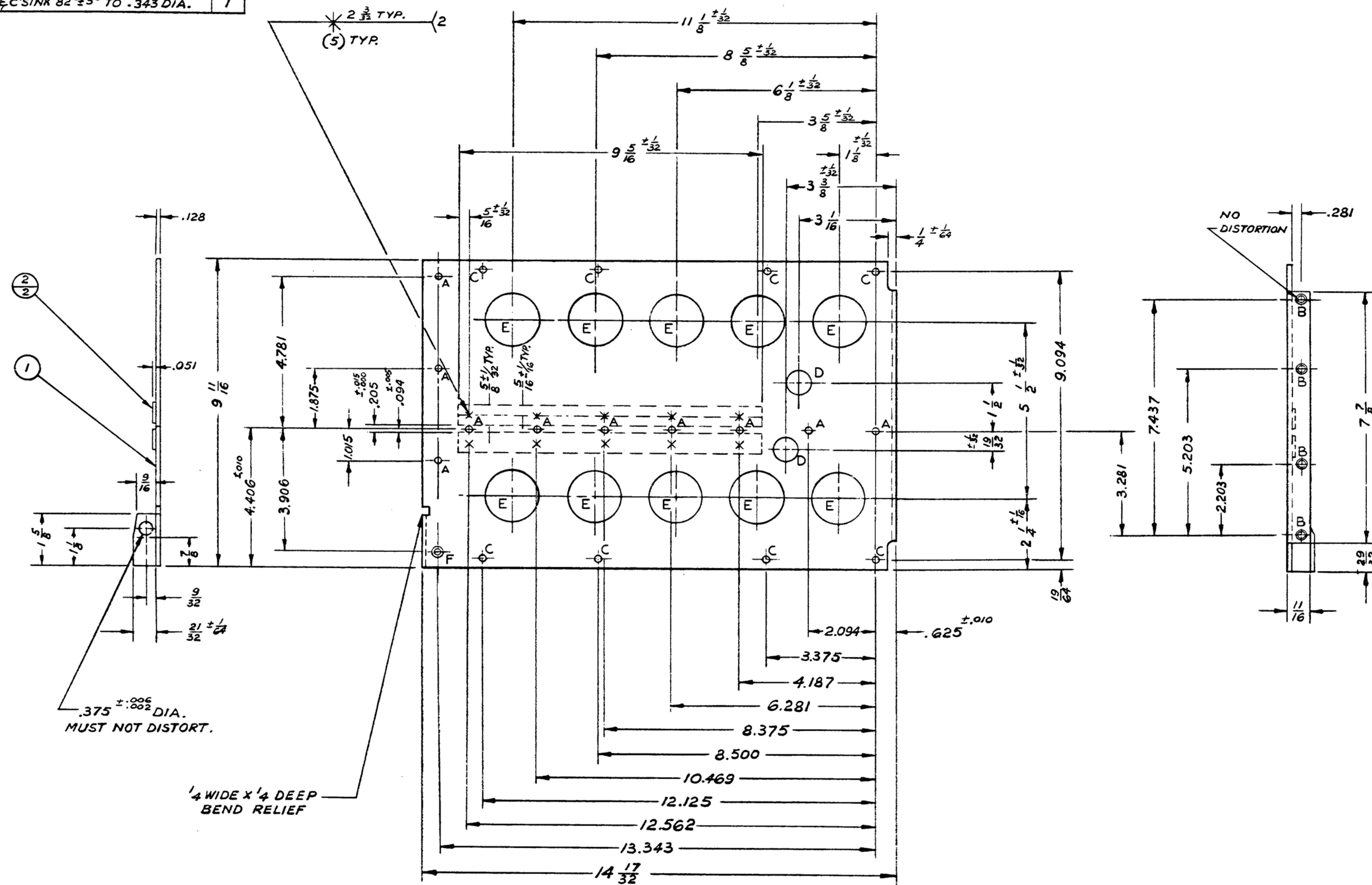


UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. DIMENSIONS ARE TO BE MAINTAINED AT ALL TIMES. DIMENSIONS ARE TO BE MAINTAINED AT ALL TIMES. DIMENSIONS ARE TO BE MAINTAINED AT ALL TIMES.

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

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL

HOLE DATA		
HOLE	SIZE	REQD
A	171 DIA.	10
B	.268 ±.002 DIA. ̸ C BORE .343 DIA X .032 DEEP	4
C	.203 ±.001 DIA.	8
D	3/4 DIA.	2
E	1 3/8 DIA.	10
F	.171 DIA. ̸ C SINK 82 ± 3° TO .343 DIA.	1



- NOTES:
- ALUMINUM ALLOY 5052 TEMPER H32, PER SPEC. QQ-A-318.
 - FINISH: E 513 PER SPEC. MIL-F-14072.
 - ALL INSIDE BEND ̸ RELIEF RADII 9/64 MAX.
 - WELDING SYMBOLS SHOWN IN ACCORDANCE WITH JAN-STD.-19, WELDING SHALL BE IN ACCORDANCE WITH SPEC. MIL-W-6858.
 - SPOTWELD LOCATION MAY VARY ± 1/8.

ITEM	REQD	PART NO.	DESCRIPTION	MATL	MATL SPEC
2	2	SM-D-343614-2	STIFFENER		
1	1	SM-D-343614-1	FRAME		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES ± 1/64 ±.005	STEWART-WARNER ELECTRONICS ORDER NO. 42428-PC-59	DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY SM-D-343614
	REVIEWED PME	
Drawn by: John Ostrowski Checked by: [Signature] Chief Drafts: [Signature] Eng. Approve: [Signature]	DATE 9 NOV. 59	SCALE 1/2
APPLICATION		