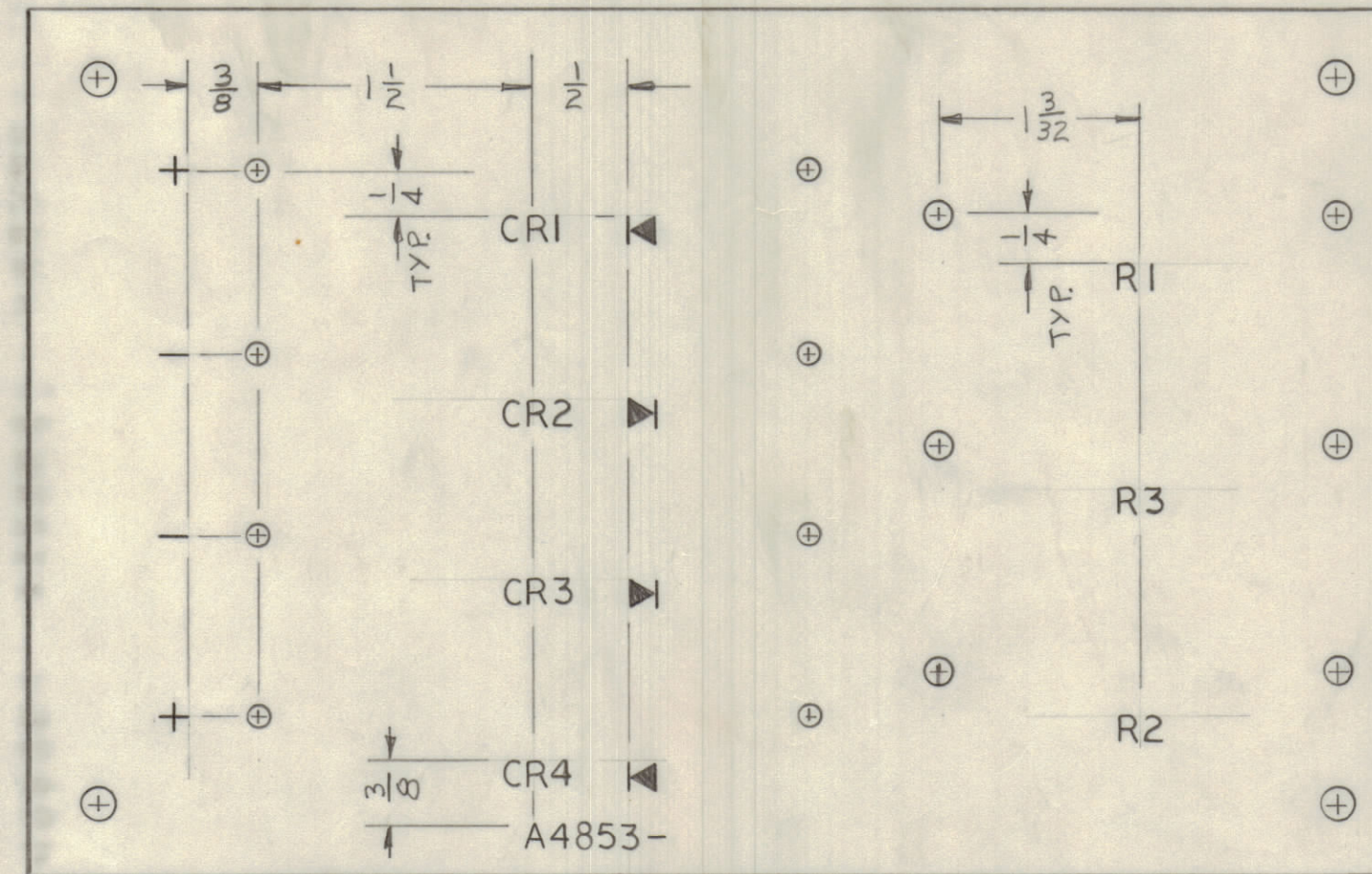


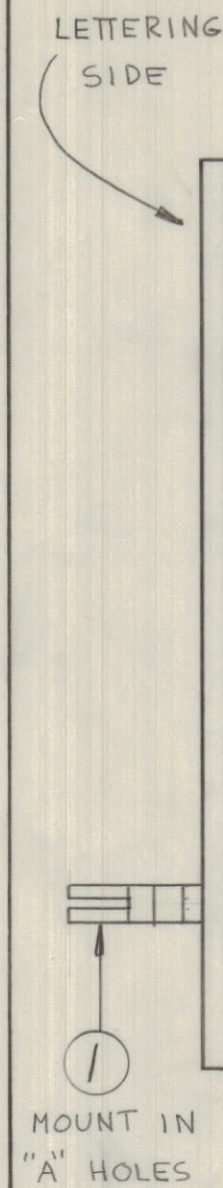
- A ~ #13 DRILL 8 REQ
- B ~ $\frac{3}{64}$ DIA. 6 REQ
- C ~ $\frac{1}{64}$ DIA. 4 REQ

MACHINING
A4853-1



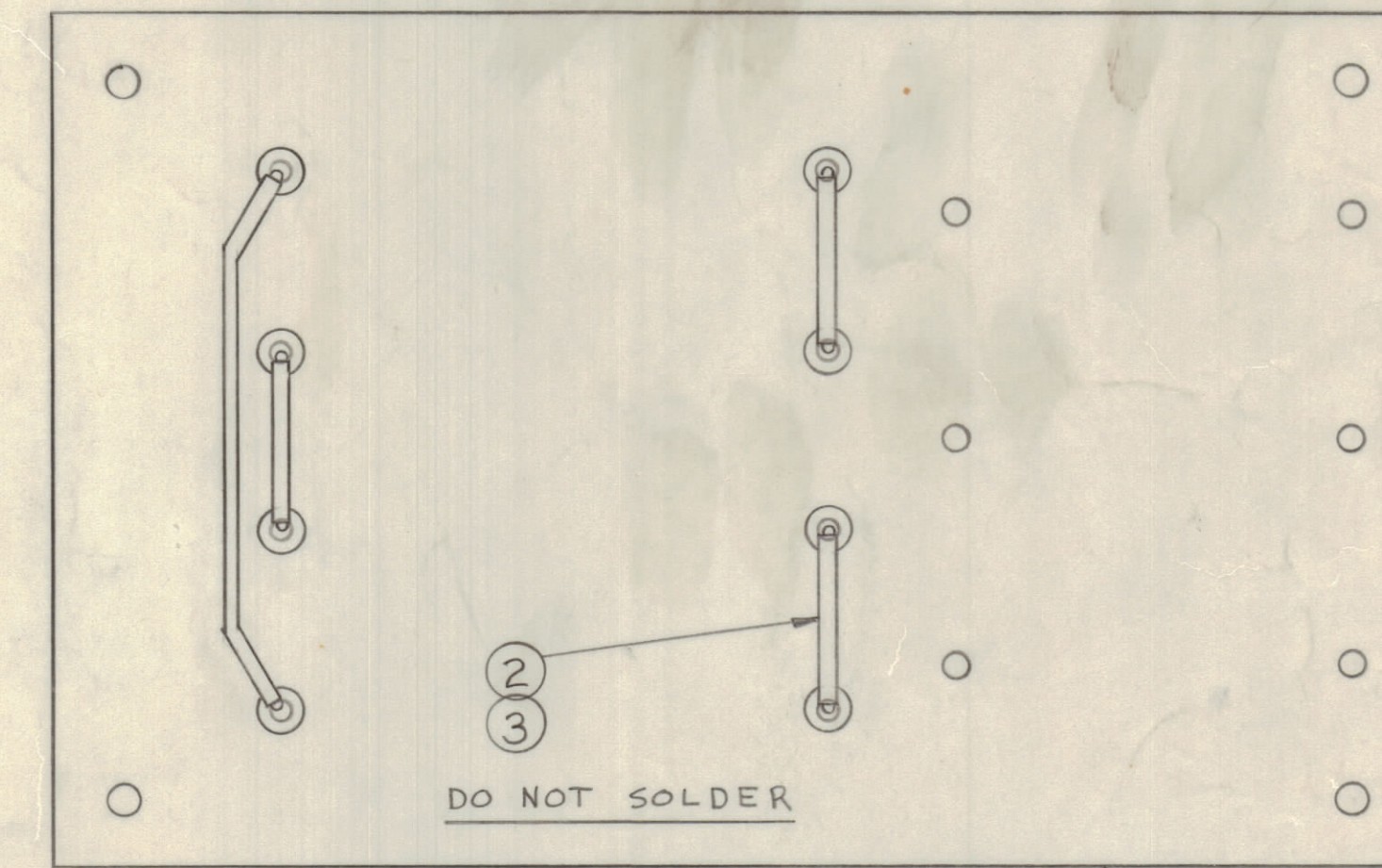
MARKING PROCESS: AS PER TMC SPECIFICATION S727
 LETTERING: 1/8 HIGH BLACK GOTHIC, LOCATED AS SHOWN
 S113 - FUNGUS PROOFING AFTER LETTERING

LETTERING
A4853-2

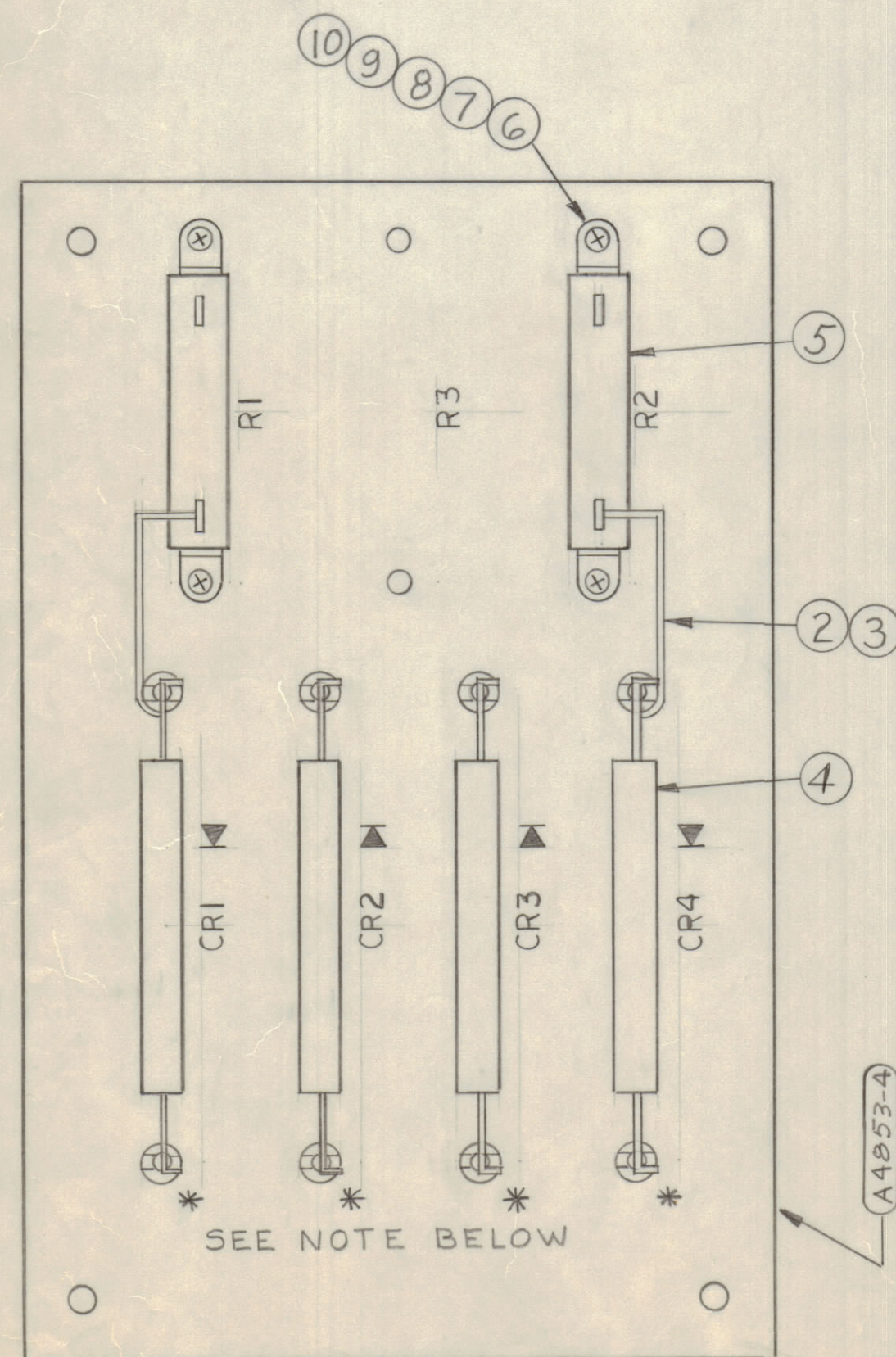


MECH.
ASY.
A4853-3

REVISIONS							
E.M.NNO	DRAFT	CHKD	ZONE	LTR	DESCRIPTION	DATE	APPROVED
					ORIGINAL RELEASE FOR PRODUCTION	10/15/70	
20179	GE			A	CHG. IT. 5 FR. RW109-7 TO RW109-4	12/28/70	P.E.A.
20227	GE			B	A HOLE CHG TO #13 DRILL WAS #32	2/11/71	P.E.A.
20503	RG			C	NOTE ADDED	1/20/72	SP
20670	GE			D	IT. 2 WAS WL100-6 IT. 3 WAS PX370-20-7	5-5-72	SP
20953	GE			E	ADDIT. 15 & CHG. IT. 6 TO IT. 15	1-30-73	SP

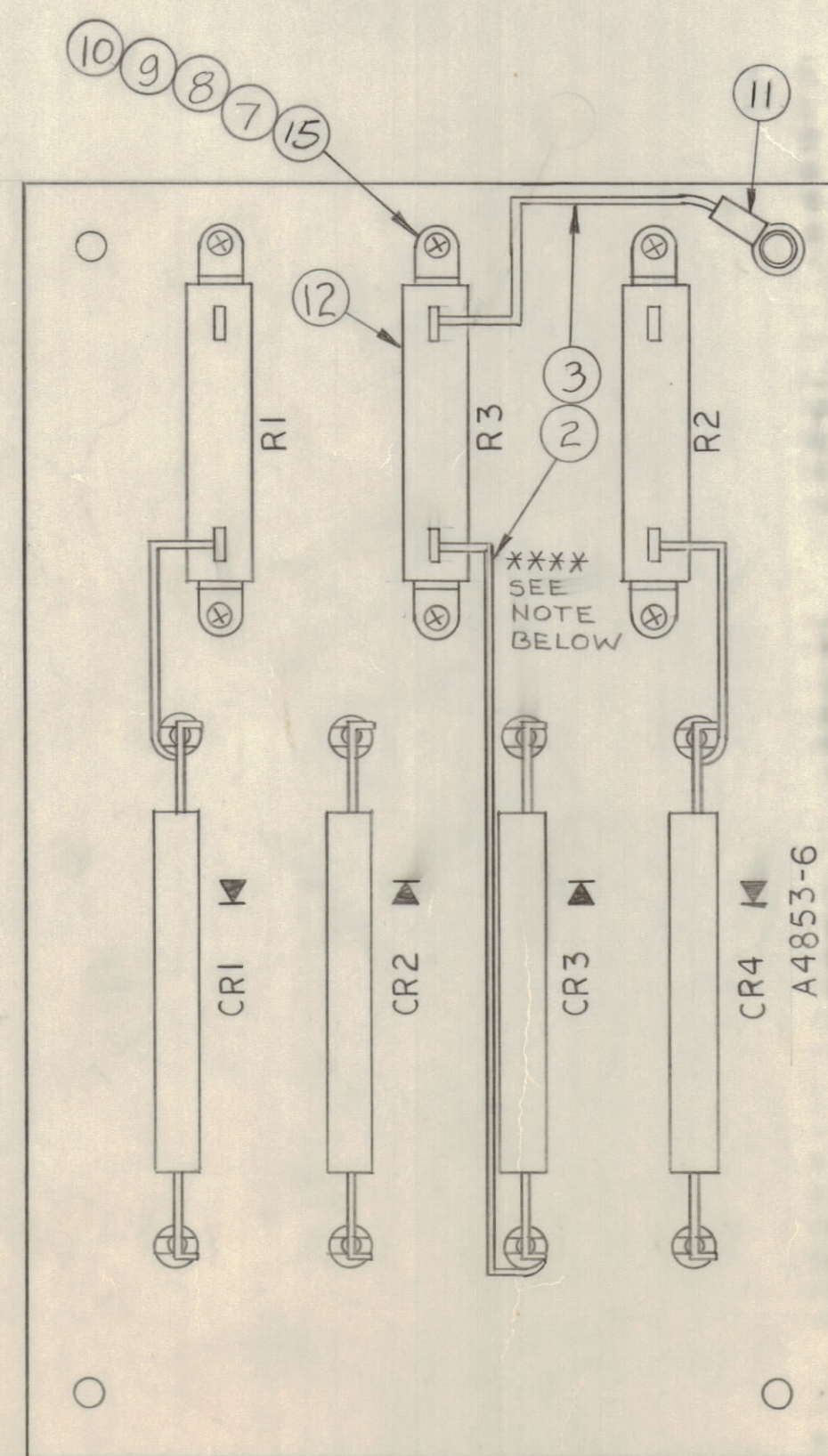


UNDERSIDE WIRING
A4853-4



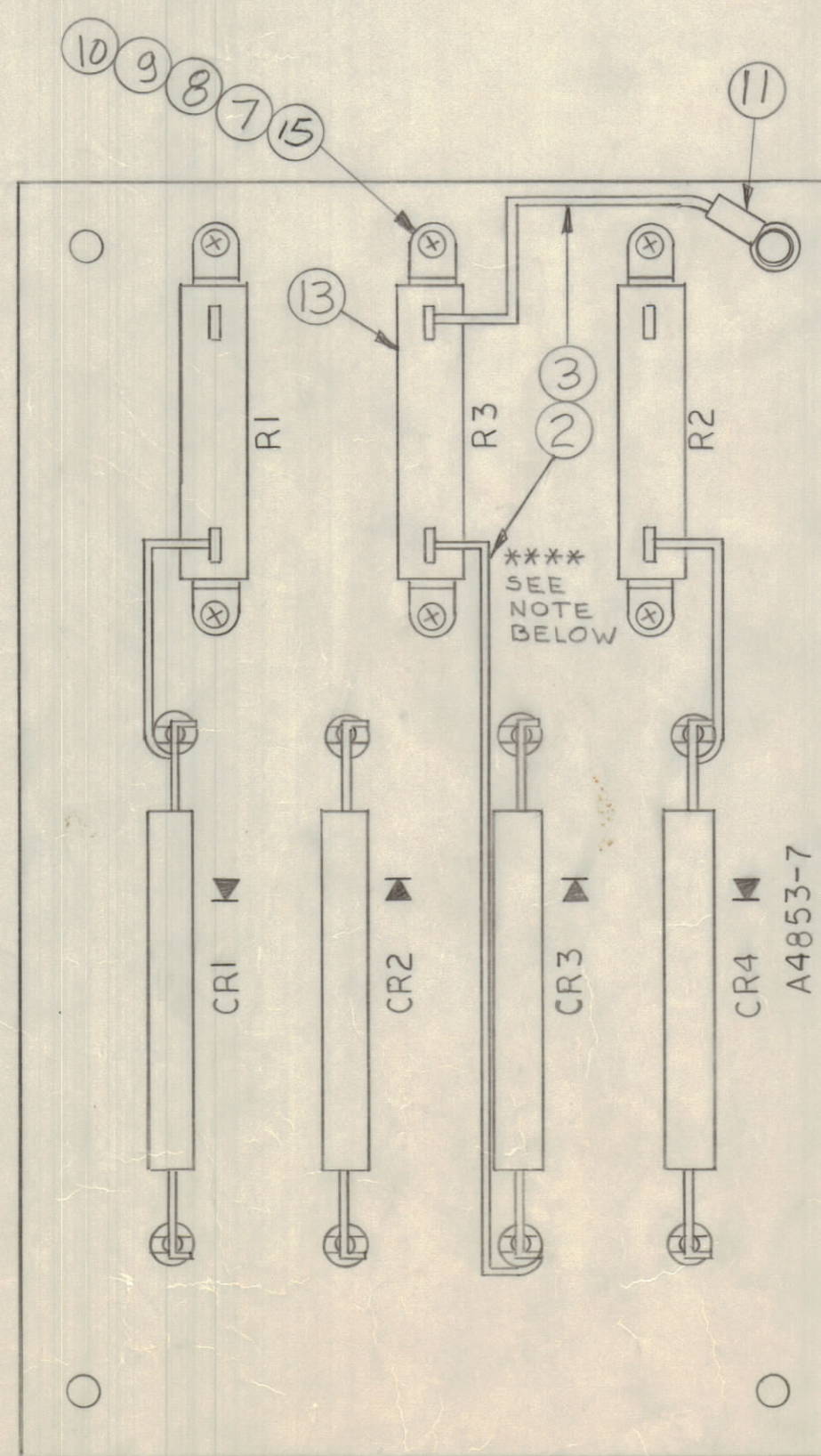
SUB-ASSEMBLY
A4853-5

SOLDER ALL CONNECTIONS
EXCEPT. *



FINAL ASSEMBLY
A4853-6

CONNECT JUMPER BETWEEN R3 & CR3
WHEN ASSEMBLY IS U/O API50.
DELETE JUMPER WHEN U/O API52.



FINAL ASSEMBLY
A4853-7

QTY / UNIT	MODEL USED ON	ASS'Y NO.
1	HFLM-1K, HFLA-1K	API50, API52
1	HFLM-1K, HFLA-1K	API50, API52

APPLICATION

CODE

NOTICE TO PERSONS RECEIVING THIS DRAWING
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UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE IN INCHES
 AND INCLUDE CHEMICALLY APPLIED
 OR PLATED FINISHES

TOLERANCES ON	FRACTIONS
DECIMALS	$\frac{1}{64}$
.X ± .05	
.XX ± .01	
.XXX ± .005	
ANGLES	$\pm 0^\circ - 30'$

MATERIAL
 $\frac{1}{8}$ " G10 GLASS EPOXY
 FINISH
 SEE A4853-2

*** QTY 1 U/O A4853-6
 ** QTY 1 U/O A4853-7

QTY. REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
	18			
	17			
	16			
2	15	CU164-2	RET. RES	
	14	BS100	SOLDER, TIN ALLOY	
**	13	RW110-7	RES, FXD, WW, 10W	R3
***	12	RW110-3	RES, FXD, WW, 10W	R3
1	11	TE156-32945	TERM LUG, INS.	
6	10	NTH0440BN6	NUT, PLN, H, H.	
6	9	LWE04MRW	WASH, LOCK, EXT	
6	8	FW04HBN	WASH, FLAT	
6	7	SCBP0440BN6	SCREW, MACH	
4	6	CU164-1	RET. RES.	
2	5	RW109-4	RES, FXD, WW, 10W	R1, 2
4	4	DD140	SCOND DEV, D10	CRI-4
	3	PX370-11-7	INS, SLVS, TEF	
	2	WL100-4	WIRE, ELEG, BUSS	
8	1	TE118-2	TERM LUG, SPLIT	

LIST OF MATERIAL

BUDE IT / THE TECHNICAL MATERIEL CORP.
 MAMARONECK, NEW YORK

ASY, BD, RECT

SIZE	CODE	IDENT NO.	DWG NO.	ISSUE
D	82679	A4853		E

SCALE SHEET OF