

IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

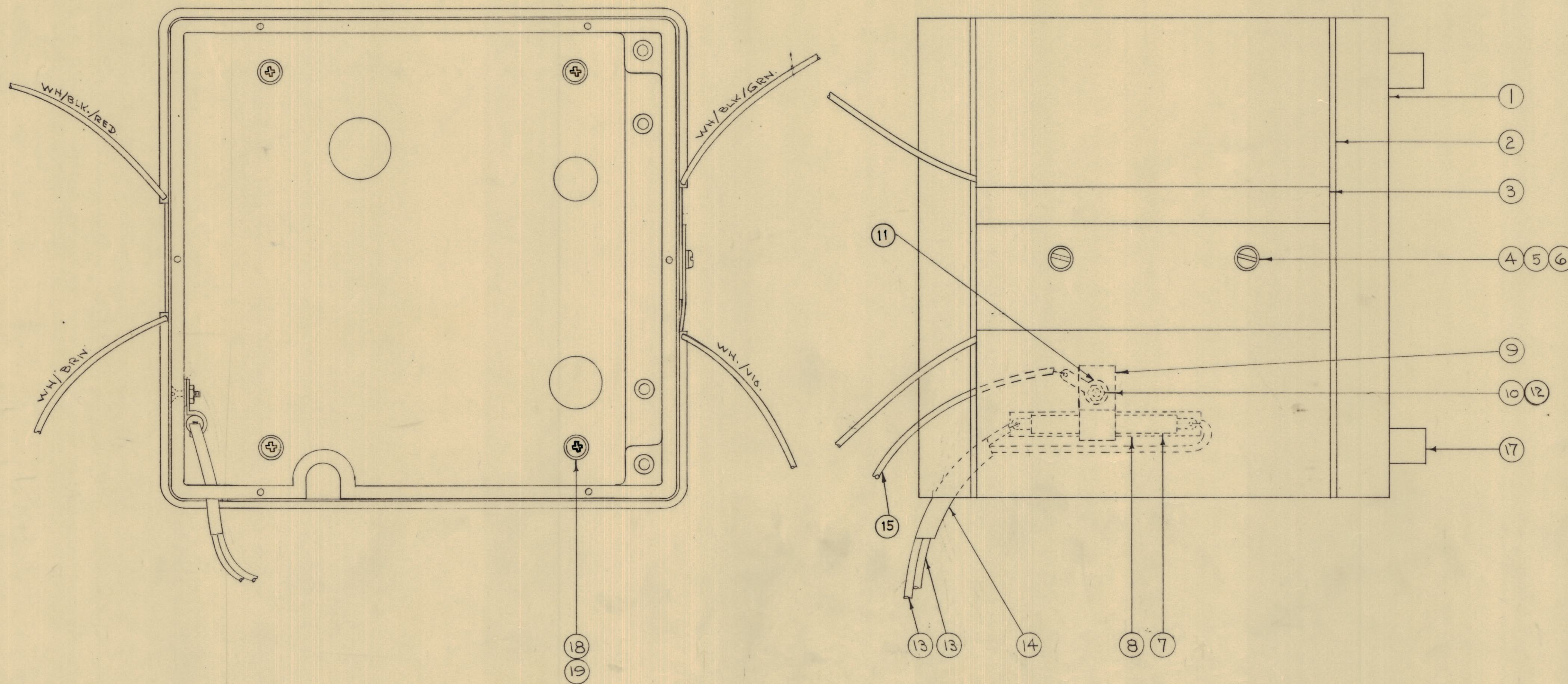
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 MAMARONECK, NEW YORK

AO-107



A	19	LWE10MRN	WASHER, LOCK	
A	18	SCBP0632BN8	SCREW, MACHINE	
A	17	PX-162	SPACER	
X	16	BS-100	SOLDER, SOFT (CONNECTIONS)	
X	15	MWC22(7)B0	CABLE, INSULATED	BLACK
X	14	PX-342-1-135	INSULATION, SLEEVING	
X	13	MWC22(7)B90	CABLE, INSULATED	WH/BLK
1	12	NTH0632BN8	NUT, HEX.	
1	11	TE-104-2	TERMINAL, LOCKING	
1	10	SCFP0632BN6	SCREW, MACHINE	
1	9	CU-104-5	CLAMP, CABLE	
X	8	PX-342-1-263	INSULATION, SLEEVING	
1	7	SS-100-3	SWITCH, SENSITIVE	S-302
2	6	LWE06MRN	WASHER, LOCK	
2	5	FW06HBN	WASHER, FLAT	
2	4	SCBP0632BN5	SCREW, MACHINE	
1	3	RR-106	OVEN HEATER	R307 R308
1	2	IM-112	FISH PAPER	
1	1	PM-309	OVEN CASTING	

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
#			
STOCK SIZE			
#			
INNER OVEN HEATER ASSY.			
#			
MATERIAL WEIGHT PER PC			
#			
TYPE & TEMPER			
#			
HEAT TREAT. SPEC.			
#			
FINISH & SPEC. NO.			

1	VOX-1,2			7-2-62
1	PMO-1,2	285		7-2-62
1	VOX	101		7-2-62
REQ. PER UNIT	MODEL	PROJECT NO.	ABBY. NO.	DATE
USED ON				

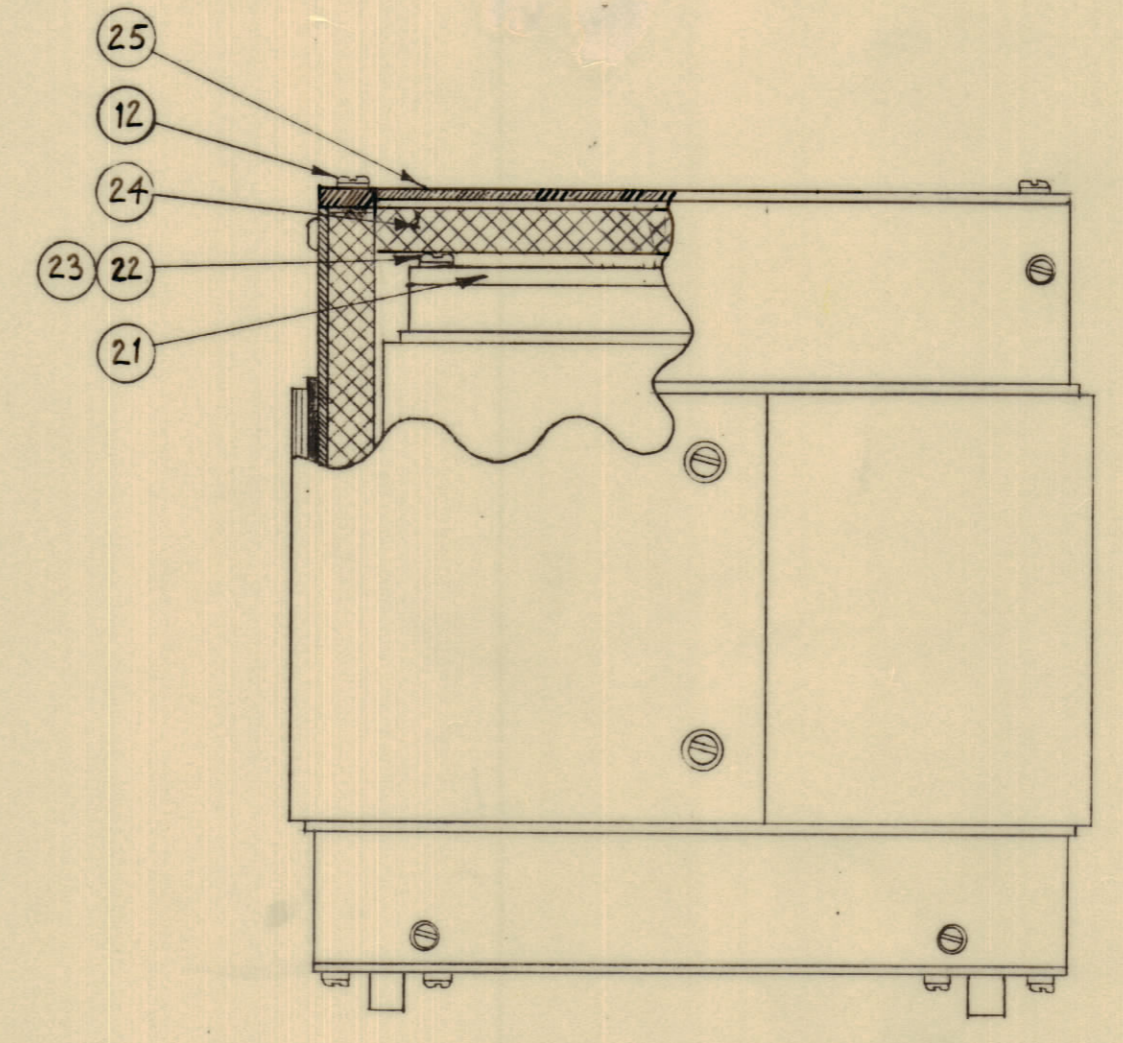
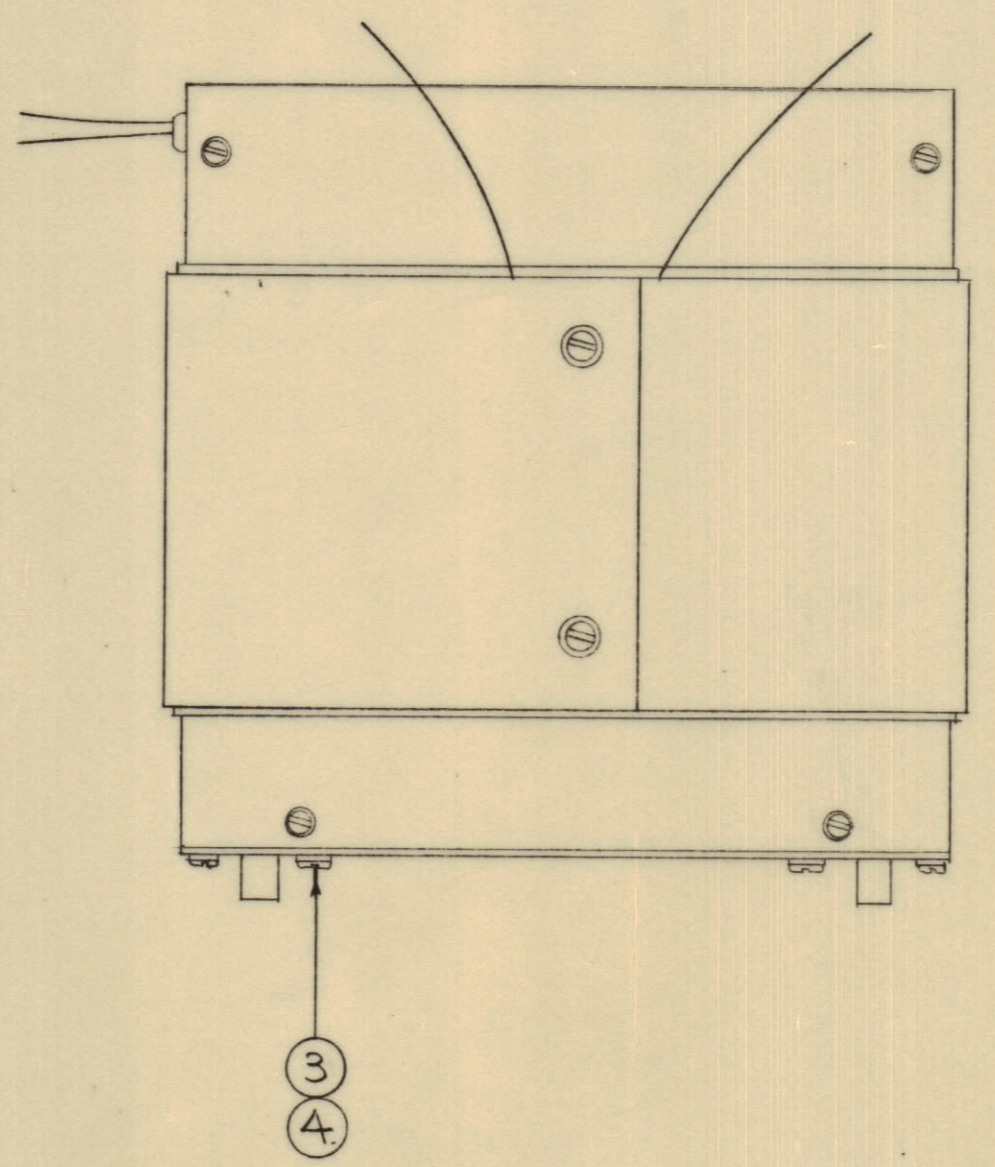
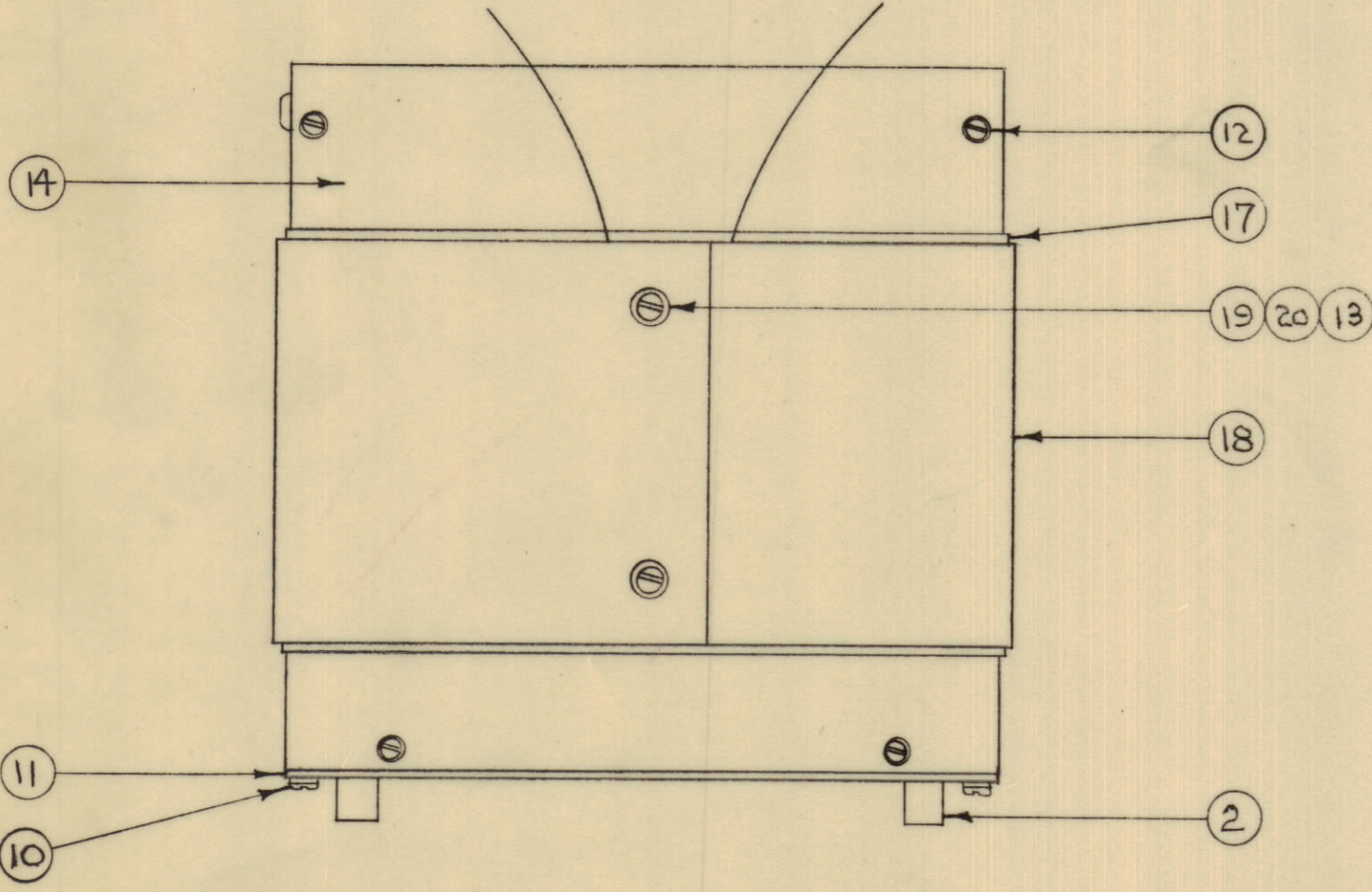
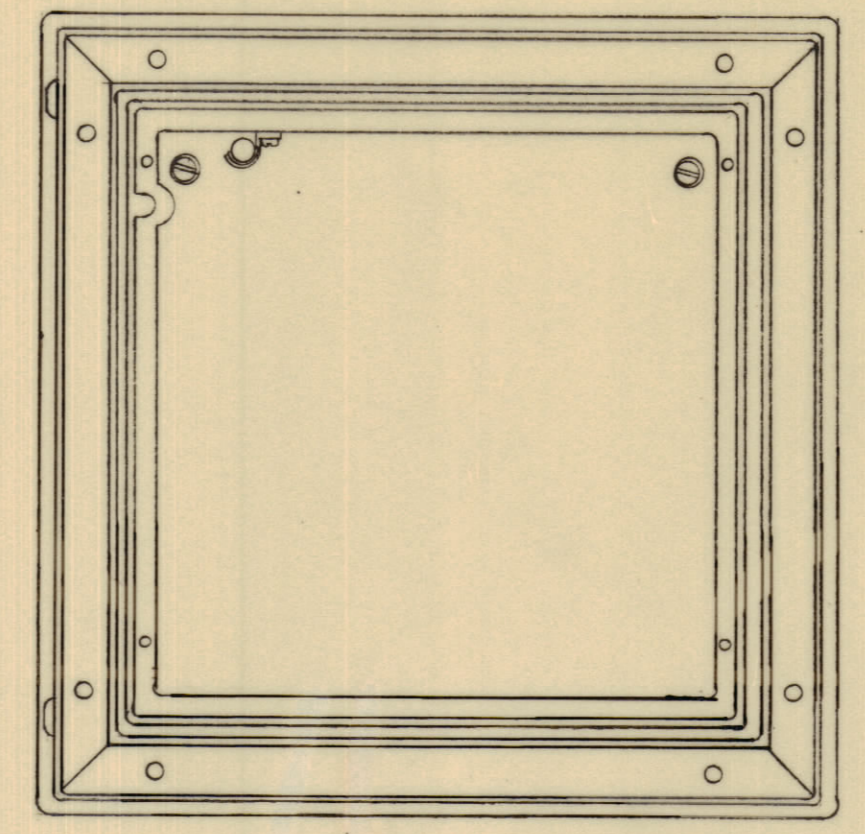
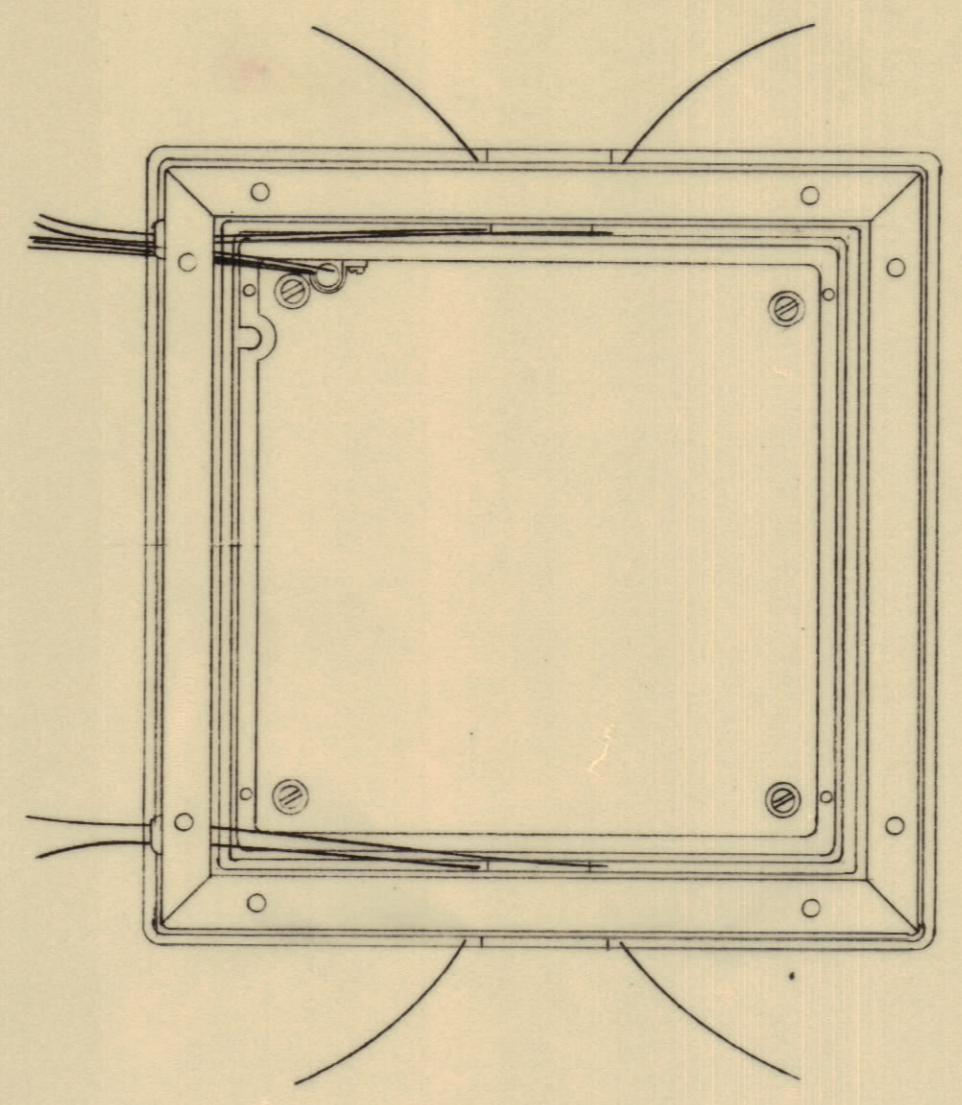
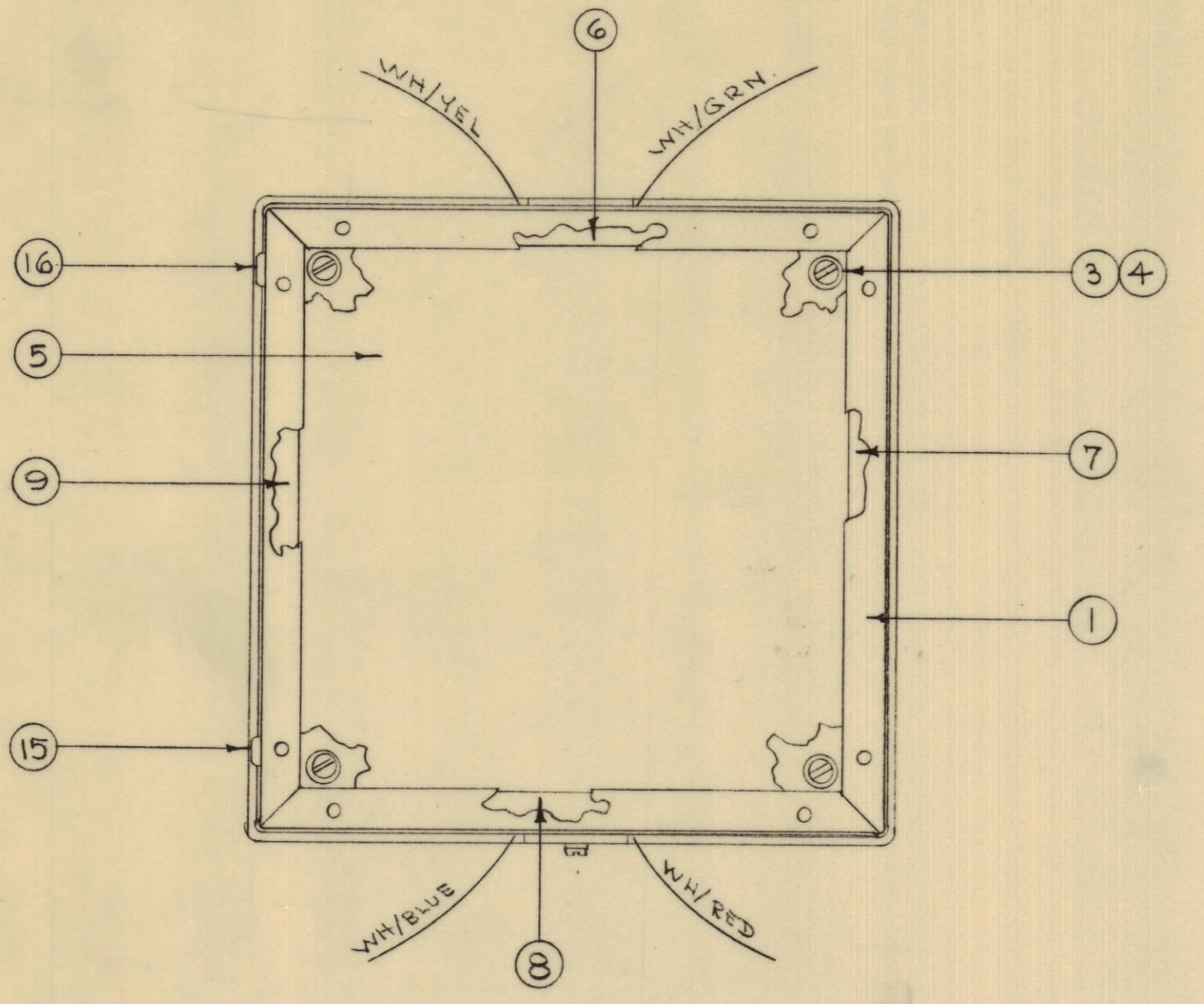
C	B/U UPDATED (3/2/63)	29.10	17811	LHD		
B	SEE SHT 2 OF 3	11/26/62	10395			
A	SEE SHEET 3 OF 3	6/25/62	9361			
ISSUE ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES						
SCALE: 1						
ALL	DEC. DIM. ±	DRILL PUNCH, COMMERCIAL STOCK				
OTHERS	FRAC. DIM. ±	SIZES AND MANUFACTURERS				
	ANGULAR DIM. ±	TOLERANCES ARE NOT INCLUDED.				

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STEP 1 - INNER SHELL, INSULATION AND HEATER.

STEP 2 - INNER SHELL AND OVEN.

STEP 3 - INNER SHELL, OVEN, AND COVERS.

6	26	LWE08MRN	LOCKWASHER, EXTERNAL
1	25	MS-310	FRONT COVER, INNER SHELL
1	24	IM-122	INNER INSULATOR, FRONT
6	23	LWE04MRN	LOCKWASHER, EXTERNAL
6	22	SCBP0440BN7	SCREW, MACHINE
1	21	MS-306	OVEN COVER
2	20	FW 06HBN	WASHER, FLAT
2	19	SFB0632BN6	SCREW, SELF TAP
1	18	RR-105	OVEN HEATER
1	17	IM-111	INNER SHELL FISH PAPER
1	16	EY-102-3	GROMMET, ELASTIC
1	15	EY-102-2	GROMMET, ELASTIC
1	14	MS-311	TOP COVER, INNER SHELL
2	13	LWE06MRN	WASHER, LOCK
14	12	SCBP0632BN5	SCREW, MACHINE
1	11	MS-312	REAR COVER, INNER SHELL
6	10	SCBP0832BN5	SCREW, MACHINE
1	9	IM-124	INNER INSULATOR, R. SIDE
1	8	IM-120	INNER INSULATOR, TOP
1	7	IM-123	INNER INSULATOR, L. SIDE
1	6	IM-113	INNER INSULATOR, BOTTOM
1	5	IM-121	INNER INSULATOR, REAR
8	4	LWE10MRN	WASHER, LOCK
8	3	SCBP1032BN4	SCREW, MACHINE
4	2	PX-162	SPACER, SHELL
1	1	MS-333	OVEN INNER SHELL

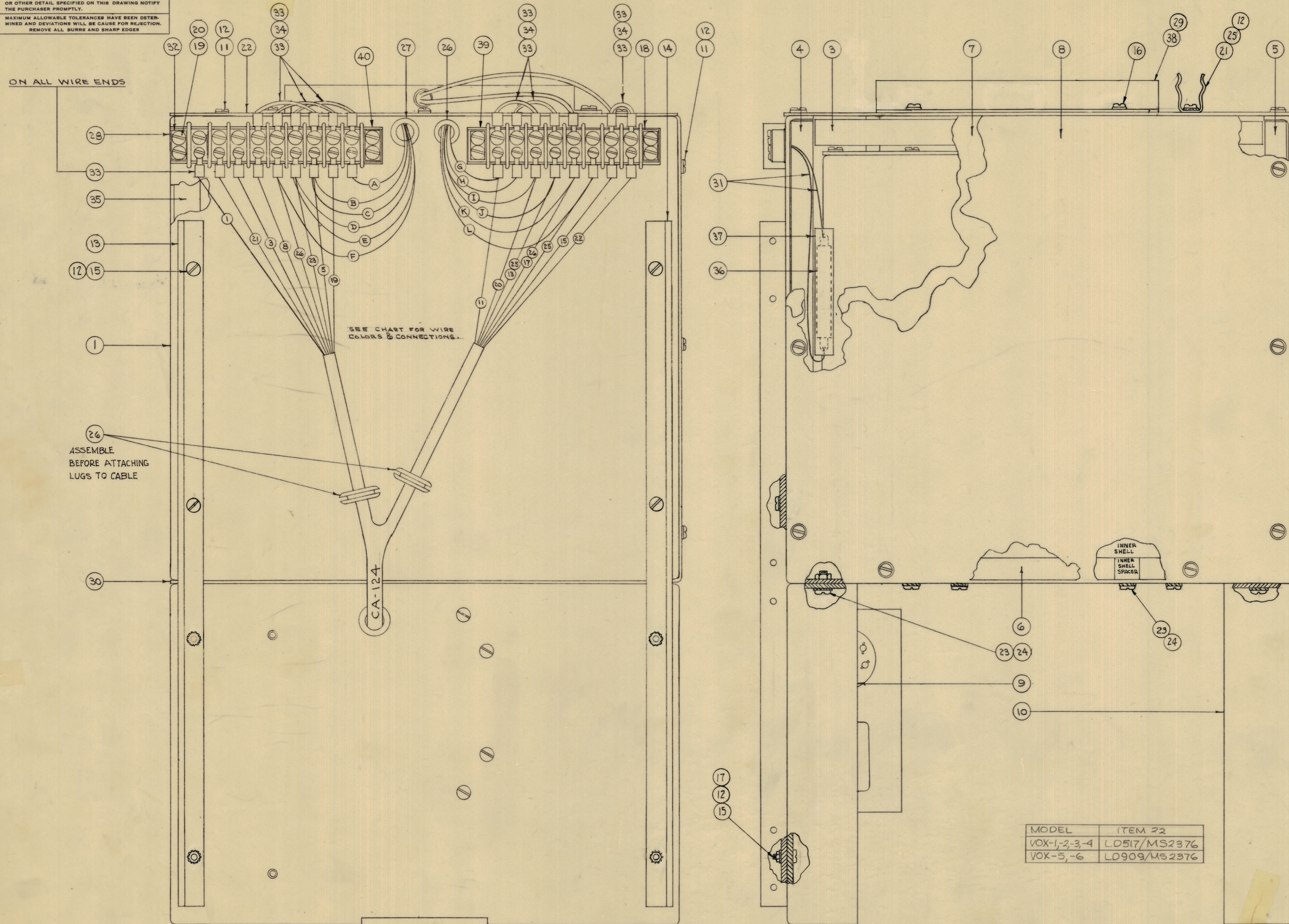
REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
INNER SHELL, OVEN AND OSCILLATOR ASSY. VOX			
MATERIAL		WEIGHT PER PC	
TYPE & TEMPER		U.A.F.	
HEAT TREAT. SPEC.		CHECKED	FINAL APPROVAL
FINISH & SPEC. NO.		SHEET 2 OF 3	

1	VOX-1,2			7-2-62
1	VOX	101		7-2-62
REQ. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE
USED ON				

IT19 WAS SFB0632BN4 SEE SH 1 & 3	4/16/62	17811	W.H.D.	
DEL. 2 CABLES ON STEP 3	8-11-63	10295		
SEE SHEET 3 OF 3	6-28-63	9361		
ISSUE	ITEM	CHANGED FROM	DATE	CN. NO. DRAFTS
TOLERANCES		SCALE:		
ALL OTHERS	DEC. DIM. ± FRAC. DIM. ± ANGULAR DIM. ±	DRILL PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.		

A0-107

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WIRE NO.	COLOR	FROM
A	WH./RED	INNER SHELL HEATER
B	WH./GREEN	" " "
C	WH./YELLOW	" " "
D	WH./BLUE	" " "
E	WH./BLK	S303 INNER SHELL SWITCH
F	WH./BLK	" " "
G	WH./BLK/GRN	OVEN HEATER
H	WH./BLK/RED	" " "
I	WH./BRN.	" " "
J	WH./VIO.	" " "
K	WH./BLK/GRN	S302 OVEN SWITCH
L	WH./BLK/GRN	" " "
M	BLACK	GND. LUG IN OVEN
21	WH./OR.	CABLE
3	BROWN	"
8	GRAY	"
26	GRAY	"
23	WH./YEL	"
5	BLUE	"
19	WHITE	"
11	GREEN	"
20	VIOLET	"
13	ORANGE	"
25	ORANGE	"
17	GRAY	"
26	GRAY	"
25	ORANGE	"
15	WH./BLUE	"
22	WH./BLK.	"
1	WH./BLUE	"

1	40	PX-336-9	INSULATION, TERMINAL STRIP, BARRIER	
1	39	PX-336-8	INSULATION, TERMINAL STRIP, BARRIER	
1	38	IM-181	INSULATOR, TUBE	
X	37	PX-100-2-375	INSULATION, SLEEVING	
1	36	SS-100-1	SWITCH, SENSITIVE S303	
1	35	IM-116	OUTER INSULATION, BTM.	
X	34	MWC 22(7)B6	CABLE, INSULATED (BLUE)	
40	33	TE-120-2	SPADE LUG	
4	32	MS-154-1	STRADDLE PLATE	
X	31	MWC 22(7)B90	CABLE, INSULATED (WH./BLK.)	
1	30	MS-883	REAR COVER, OUTER SHELL	
1	29	LD699/MS2061	COVER, INSULATOR	
1	28	TH-102-9	TERMINAL STRIP	E302
1	27	EY-102-5	GROMMET, ELASTIC	
3	26	EY-102-3	" " "	
1	25	SCBP0632BN4	MACHINE, SCREW	
15	24	LWE10MRN	WASHER, LOCK	
15	23	SCBP032BN7	SCREW, MACHINE	
1	22	SEE CHART	FR. COVER, OUTER SHELL	
1	21	FC-101	CLIP, FUSE	
8	20	LWS04MRN	WASHER, LOCK	
8	19	SCBP0440BN8	SCREW, MACHINE	
1	18	TM-102-B	TERMINAL STRIP	E301
4	17	NTH0632BN8	NUT, HEX.	
4	16	SCBP0440BN4	SCREW, MACHINE	
8	15	SCBP0632BN6	SCREW, MACHINE	
1	14	PM-203	SIDE SUPPORT ANGLE, BTM.	
1	13	PM-204	" " " , TOP	
27	12	LWEC06MRN	WASHER, LOCK	
18	11	SCBP0632BN5	SCREW, MACHINE	
1	10	A-632 VOX-6 MS-598 VOX-5	R. OVEN BRACKET ASSY.	
1	9	A-635	L. " " " "	
1	8	MS-314	TOP COVER, OUTER SHELL	
1	7	IM-115	OUTER INSULATION, TOP	
1	6	IM-113	" " " , REAR	
1	5	IM-118	" " " , LEFT	
1	4	IM-117	" " " , RIGHT	
1	3	IM-165	" " " , FRONT	
1	2	DELETED		
1	1		OVEN OUTER SHELL	

MODEL	ITEM 22
VOX-1,-2,-3,-4	LD517/MS2376
VOX-5,-6	LD909/MS2376

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VOX-142 MS-334
 VOX-345 MS-2402

ISSUE	ITEM	CHANGED FROM	DATE	GN. NO.	DRAFTS	CHECKER	ENG. APP.
C	1	CHT ADDED; B/D UPDATED	12/24/54	17811	1440		
B	1	SEE SHT 2 OF 3	11/12/53	10391			
A	1	ITEMS (33) & (40) ADDED DRAWING UPDATED & STANDARDIZED	6/26/53	9361			

ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED ARE IN INCHES.
 DEC. DIM. ±
 FRAC. DIM. ±
 ANGULAR DIM. ±

REG. PER UNIT	MODEL	PROJECT NO.	ASSY. NO.	DATE
	(SEE CHART)			

REG. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		OUTER SHELL, BRACKET ASSY.	VOX
		CHECKED	FINAL APPROVAL
		SHEET 3 OF 3	AO-107