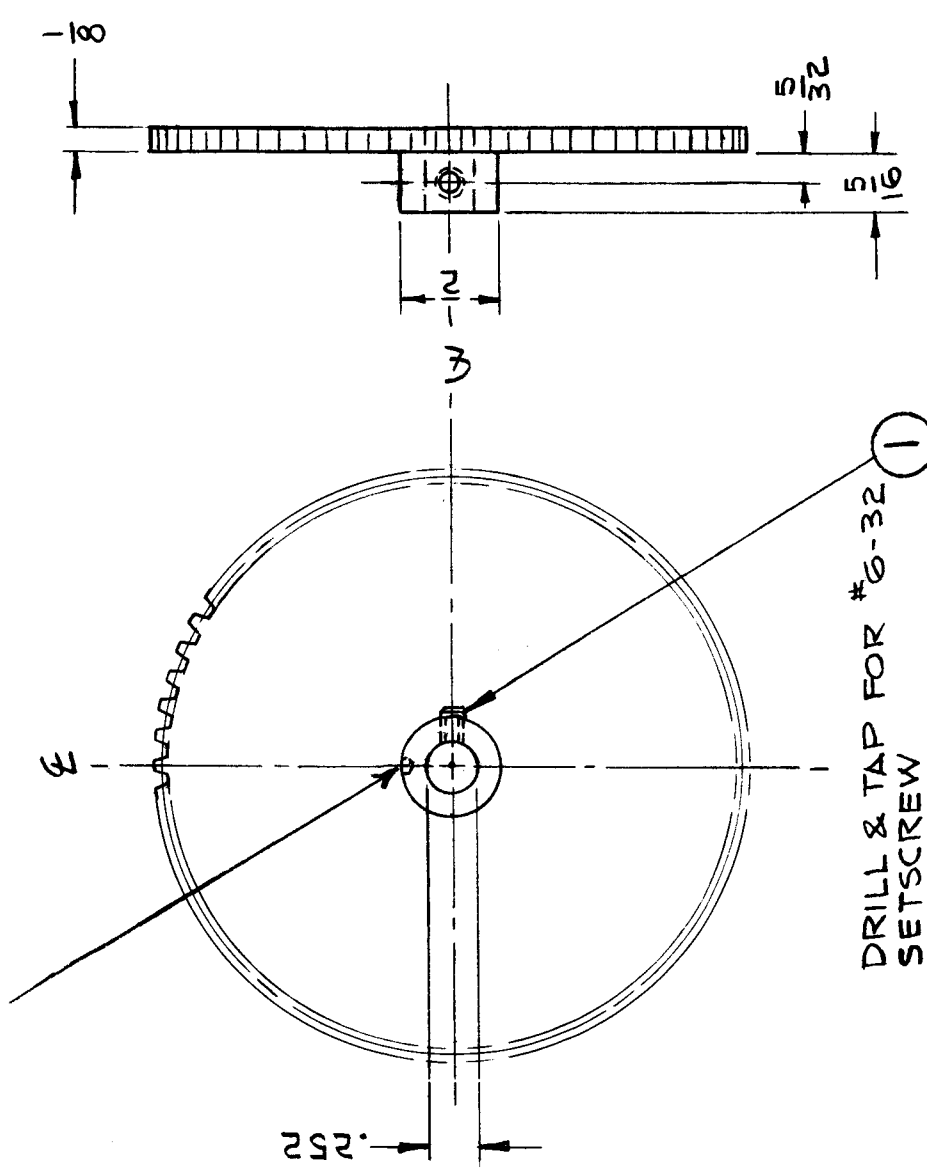




REQ. PER UNIT	1	USED ON	GR-202 B
MODEL	CHG-2A	ASSY. NO.	A3595
DATE	8-9-63		

#50 SUB-DRILL  
(PARTWAY)



PITCH DIA 3.000  
 PITCH 48  
 NO. OF TEETH 144  
 HUB DIA .500  
 HUB PROJ. .312  
 BORE .252<sup>+0.002</sup><sub>-.001</sub>  
 FACE .125  
 STYLE WEB  
 PRESSURE 14 1/2°

REQ. ITEM	1	SLHC0632553	SETSCREW	SYMBOL	
PART NO.				DESCRIPTION	KRUY
STOCK SIZE	BRASS			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MATERIAL				GEAR, IDLER	
TYPE & TEMPER	1/2 H	HEAT TREAT. SPEC.		DRAWN	JMY
FINISH & SPEC. NO.				CHECKED	JDK
DATE	12/29/65	CH. NO.	1/1	SCALE	8/27/63
DESCRIPTION	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES			FINAL APPROVAL	
TOLERANCES	FRACTIONS ± 1/64 ANGLES ± 0° 30'			GR-202 B	
DECIMALS	.X ± .05 .XX ± .01 .XXX ± .005			ELEC. DES. APP. MECH. DES. APP.	



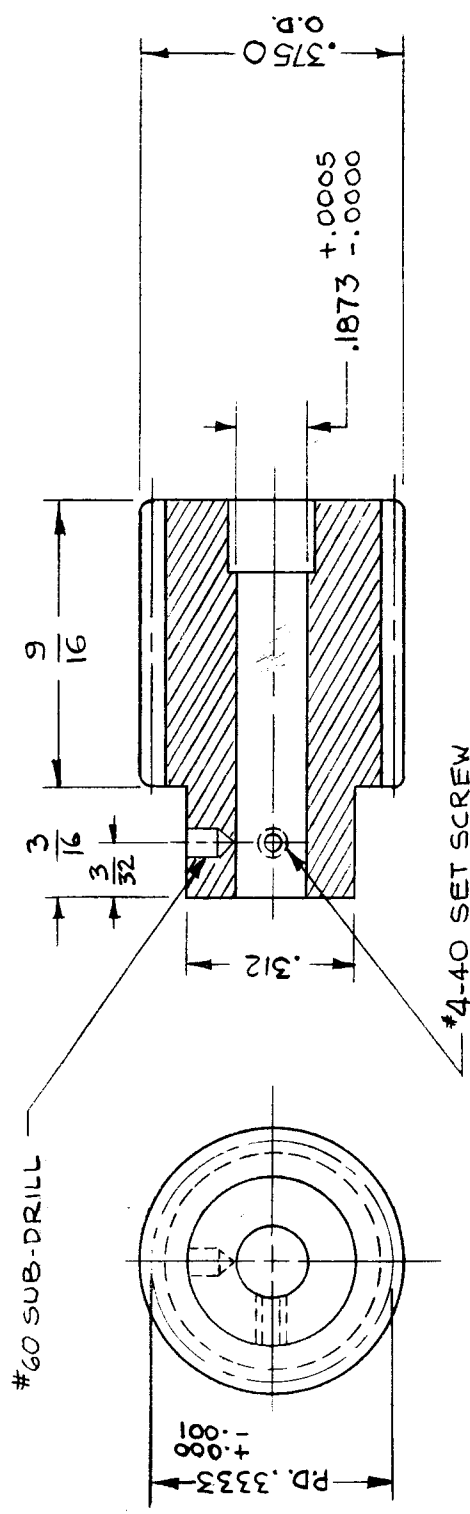






# STANDARD DRAWING

REQ. PER UNIT	1	USED ON	GR 215 $\phi$
MODEL	VLR B-1	ASSY. NO.	
DATE	7/2/64		



GEAR DATA	
PITCH	48
PITCH DIA	.3333
SINGLE TH'D - R. H.	

REQ. ITEM	PART NO.	T. KRUY	DESCRIPTION	SYMBOL
			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
			STAINLESS STEEL	
			MATERIAL	
# 303		ASB 7.2.64	WORM	
			TYPE & TEMPER	
			HEAT TREAT. SPEC	
			FINISH & SPEC. NO.	
			S104 PASSIVATE	
			SCALE	
			DATE	
			CH. NO.	
			DRAFTS	
			CHECKER	
			ENG. APP.	
			DATE	
			CH. NO.	
			DRAFTS	
			CHECKER	
			ENG. APP.	
			SCALE	
			DATE	
			CH. NO.	
			DRAFTS	
			CHECKER	
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			DRAFTS	
			CHECKER	
			ENG. APP.	
			DATE	
			CH. NO.</	

PITCH DIA ~ 3.080

PITCH ~ 17

NO. OF TEETH ~ 38 ACTIVE, 10 INACTIVE

PRESSURE ANGLE ~ 20°

THREADS RIGHT HAND

HELIX  $\frac{3}{4}$  ~ 21°, 48'

OD, OR LEAD ~ 3.197  $\pm 0.000$

-0.002

HOLES

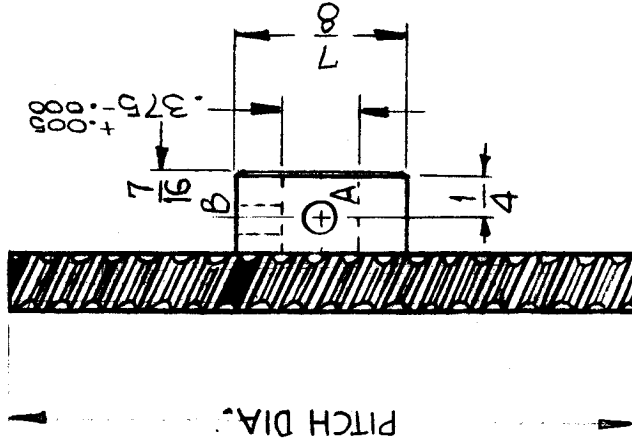
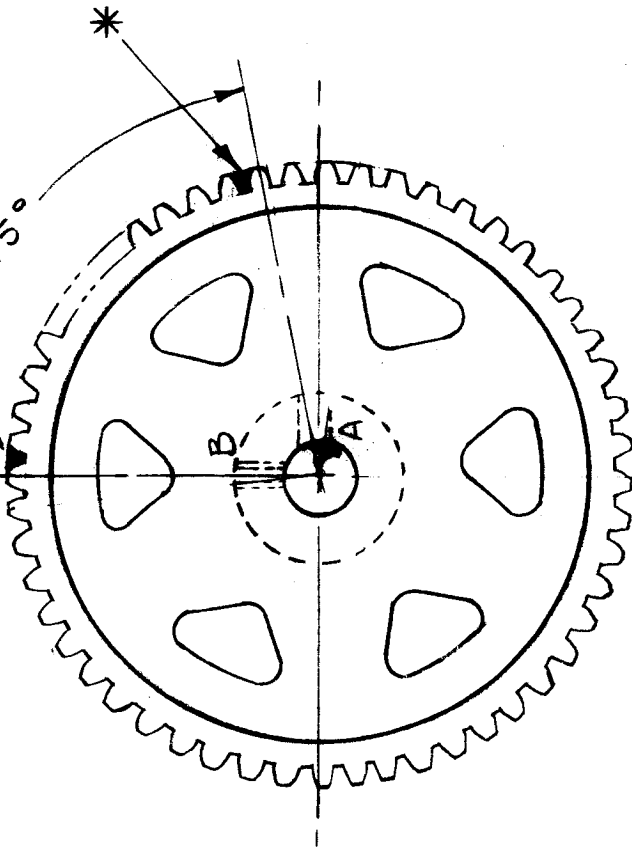
AV. 1285 Dia Hole

Bv 8-32 Tap

REQ'D

1

1



\* THESE SPACES TO BE FILLED IN WITH SILVER SOLDER BS101 OR EQUIVALENT BEFORE PLATING. (2 REQ)

MATES WITH GR143-4

ISS. PER. UNIT	1
QTY.	1
DATE	9-23-64
SYMBOL	GR216 A

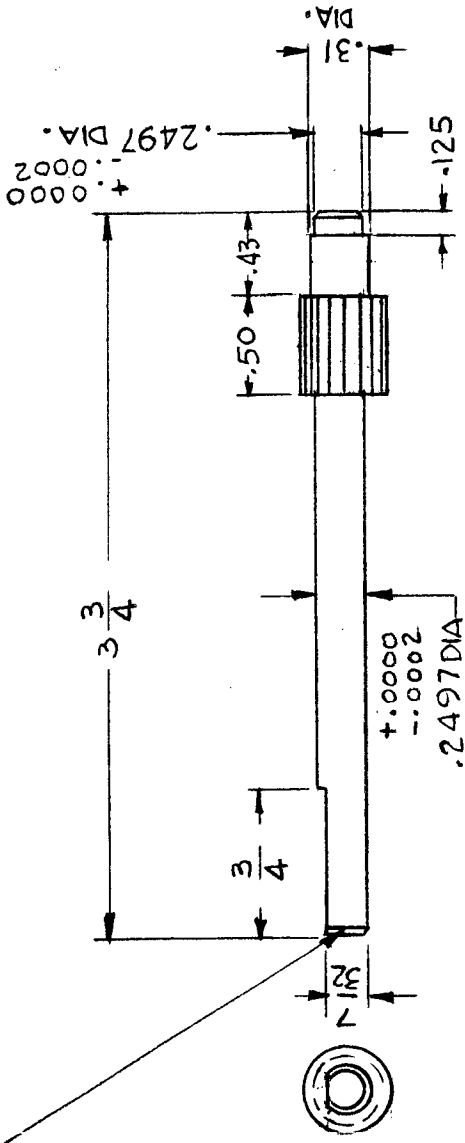
REQ. ITEM	A	1	12890	92.	11/3/64	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
ISSUE ITEM	X	1	9286	92.	9/28/64	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES		SCALE: 4- S401-15								
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES										
DEC. DIM. $\pm$										
FRAC. DIM. $\pm$										
ANGULAR DIM. $\pm$										
REQ. ITEM	4	4	4	4	4	4	4	4	4	4
TYPE & TEMPER	CHROME PLATE .0003									
HEAT TREAT. SPEC.										
MATERIAL	BRONZE									
STOCK SIZE										
PART NO.										
REQ. DESCRIPTION	BUDETTI									
DESCRIPTION	THE TECHNICAL MATERIEL CORP.									
SYMBOL	MAMARONECK, NEW YORK									
DESCRIPTION	GEAR, WORM WHEEL									
SYMBOL	GR216 A									





REQ. PER UNIT		USED ON	
1	CH GR-3	ASSY. NO. A4174	DATE 1-28-65
MODEL		GR219 A	

.01 X 45° CHAMFER  
(BOTH ENDS)



GEAR DATA	
PITCH	48
NO OF TEETH	20
PITCH DIA.	.4166
O. D.	.4583
PRESSURE ANGLE	20°

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
		PINION SHAFT	
		STAINLESS STEEL	
		MATERIAL	
		#416 HARDEN TO 28-32 ROCKWELL HARDNESS	
		TYPE & TEMPER	
		HEAT TREAT. SPEC.	
		CLEAR PASSIVATED	
		FINISH & SPEC. NO.	
		SCALE 1:1	
		DATE 4-1-65	
		CH. NO. 17983	
		DRAFTS L.R.K.	
		CHECKER HLA	
		DATE 4-1-65	
		CH. NO. G.D.L	
		DRAFTS G.D.L	
		CHECKER	
		ENG. APP.	
		DESCRIPTION	
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	
		FRACTIONS ± 1/64	
		ANGLES ± 0° 30'	
		TOLERANCES	
		DECIMALS	
		X ± .05	
		.XX ± .01	
		.XXX ± .005	
		CODE C	
		DRAWN G.D.L	
		CHECKED	
		FINAL APPROVAL	
		MECH. DES. APP. GR219 A	
		ELEC. DES. APP.	







# STANDARD DRAWING

USED ON

ASSY. NO.

DATE

GR223

Ø

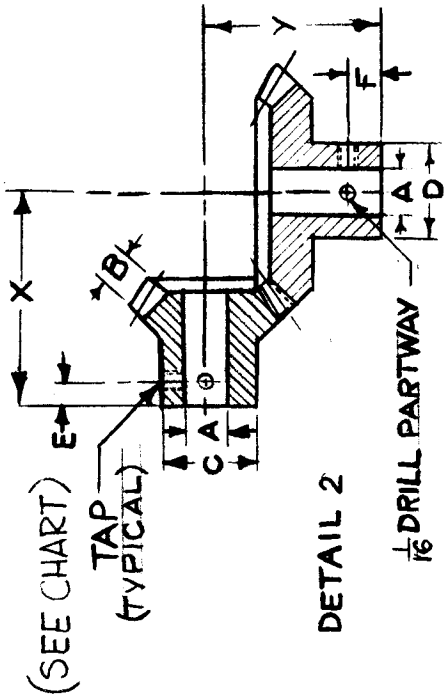
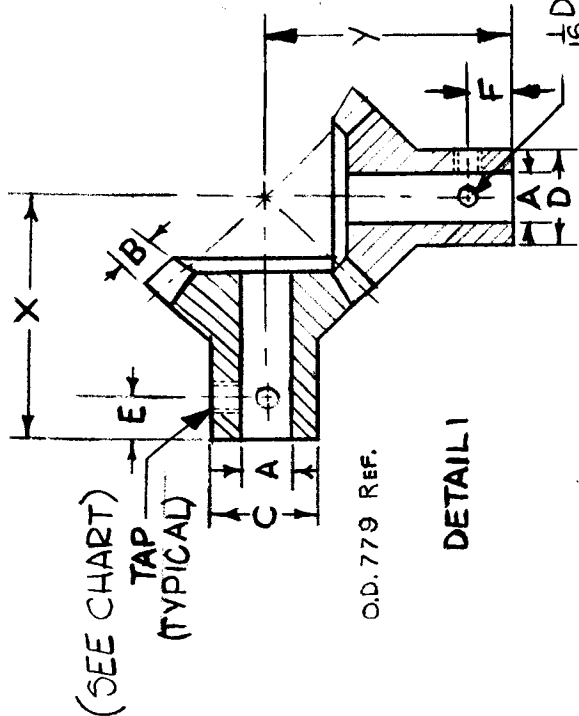
REQ. PER UNIT

UNIT

MODEL

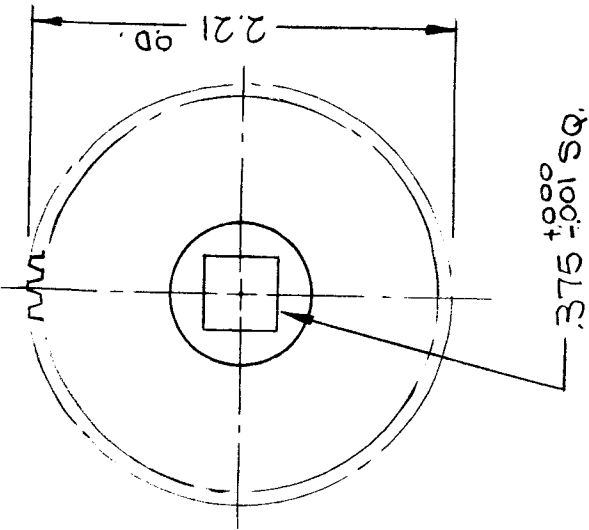
TST 10 K

TMC PART NO.	GR223-1	MFG. P/N	SBG150-36-250	A BORE	-.0002 +.0005	RATIO	1:1	TEETH	36	P.D. REF.	.750	X	.687	Y	.687	MATERIAL	STAIN. STEEL 303	PRECISION	1	TAP	4-40	B	.125	C	.500	D	.500	E	.094	F	.094	PITCH ANGLE	20°	DETAIL	I
--------------	---------	----------	---------------	--------	------------------	-------	-----	-------	----	-----------	------	---	------	---	------	----------	------------------	-----------	---	-----	------	---	------	---	------	---	------	---	------	---	------	-------------	-----	--------	---



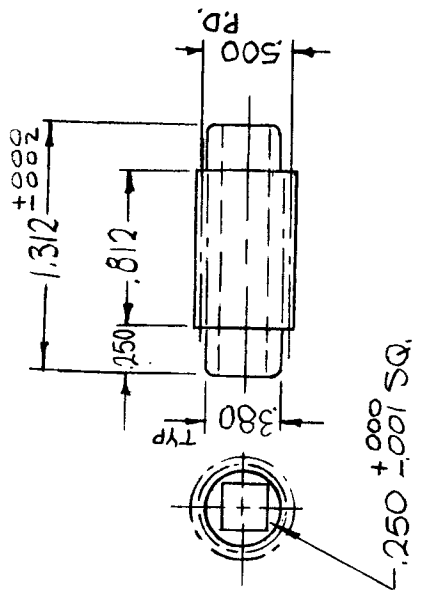
SYM	Ø	DESCRIPTION	ORIGINAL RELEASE FOR PRODUCTION	DATE	6-15-65	CH. NO.	M	DRAFTS	JC	CHECKER		ENG. APP.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES													
TOLERANCES													
FRACTIONS ± 1/64 ANGLES ± 0° 30'													
DECIMALS .X ± .05 .XX ± .01 .XXX ± .001													
CODE													
S401-346													
REQ. ITEM		PART NO.		DESCRIPTION	THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK								
				STOCK SIZE	GEAR, BEVEL, MITRE								
				MATERIAL	48 PITCH								
				TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED	FINAL APPROVAL					
				S104 - PASSIVATE			JCB	W. King	GR223				
				FINISH & SPEC. NO.	ELEC. DES. APP.	MECH. DES. APP.							

REQ. PER UNIT 1EA	MODEL TST-10K	USED ON ABBY. NO.	DATE 6-14-65
GR224		Ø	



MAT'L ~ BRONZE  
 PITCH ~ 24  
 THD'S ~ 4  
 TEETH ~ 50

WORM, WHEEL, GR 224-1



MAT'L ~ HARDENED TOOL STEEL POLISHED  
 PITCH ~ 24  
 THD'S ~ 4  
 LEAD ~ .5236"  
 LEAD  $\angle$  18° 26'

GEAR, WORM, GR224-2

REQ. ITEM	PART NO.	F. BUDETTI	DESCRIPTION	SYMBOL
			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
			GEAR WORM, & WORM WHEEL (RIGHT HAND)	
			MATERIAL	
			STOCK SIZE	
			TYPE & TEMPER	
			HEAT TREAT. SPEC.	
			CHECKED	
			DRAWN	
			FINAL APPROVAL	
			ELEC. DES. APP. MECH. DES. APP.	
			FINISH & SPEC. NO.	
			GR224	Ø

DATE: 3/15/66  
 SCALE: 1:1  
 CHECKER: [Signature]  
 ENG. APP. [Signature]  
 CODE: A  
 TOLERANCES: DECIMALS  
 .X ± .05  
 .XX ± .01  
 .XXX ± .001  
 FRACTIONS: ± 1/64  
 ANGLES: ± 0° 30'

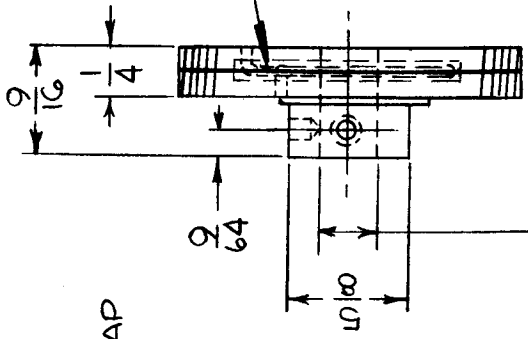




REQ. PER UNIT	USED ON	GR226 Ø
MODEL	ABBY. NO.	DATE
GPT-10KLF	A4095	11-16-65

# 50 SUB-DRILL

6-32 TAP



.065 DIA. SPRING WIRE (REF.)

GEAR DATA	
PITCH	24
NO. OF TEETH	40
PITCH DIAMETER	1.667
PRESSURE ANGLE	25°
FOUR TH'D - RIGHT HAND	

NOTE - TO MESH WITH GR227.

REQ. ITEM	PART NO.	BUDETTI	DESCRIPTION	SYMBOL
			THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
			WHEEL, WORM ANTI-BACKLASH	
			BRONZE	
			MATERIAL	
			TYPE & TEMPER	
			HEAT TREAT. SPEC.	
			DRAWN	
			CHECKED	
			FINAL APPROVAL	
			FINISH & SPEC. NO.	
			ELEC. DES. APP.	
			MECH. DES. APP.	
			GR226 Ø	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES AND INCLUDE  
CHEMICALLY APPLIED OR PLATED FINISHES

SCALE  
NOT TO SCALE

DATE  
2-2-66

CH. NO.  
Ø

DRAFTS  
M

CHECKER

ENG. APP.

CODE  
C

S401-15

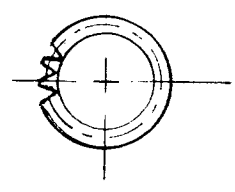
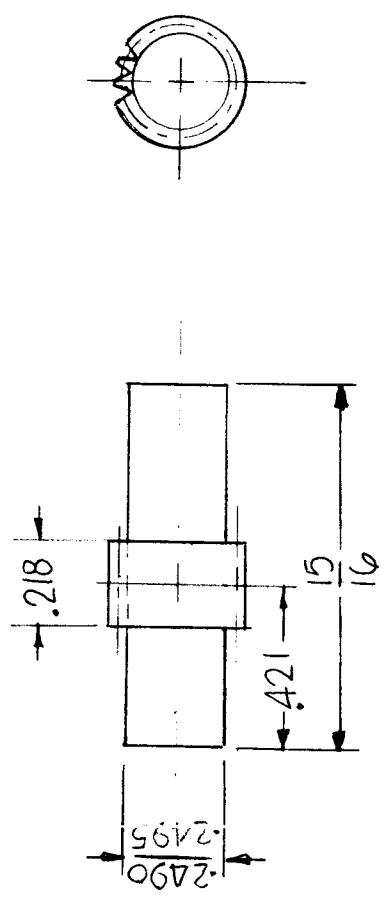
FRACTIONS  
± 1/64  
ANGLES  
± 0° 30'

DECIMALS  
.X ± .05  
.XX ± .01  
.XXX ± .005



REQ. PER UNIT	1	MODEL	TLAA-2.5K	USED ON	GR228
ASSY. NO.		DATE	6-10-66		

~ SPECIFICATIONS ~  
 PITCH DIA. .3125  
 O. D. .343  
 NO. TEETH 20  
 FACE .218  
 PRESSURE ANGLE 20°  
 PITCH 64



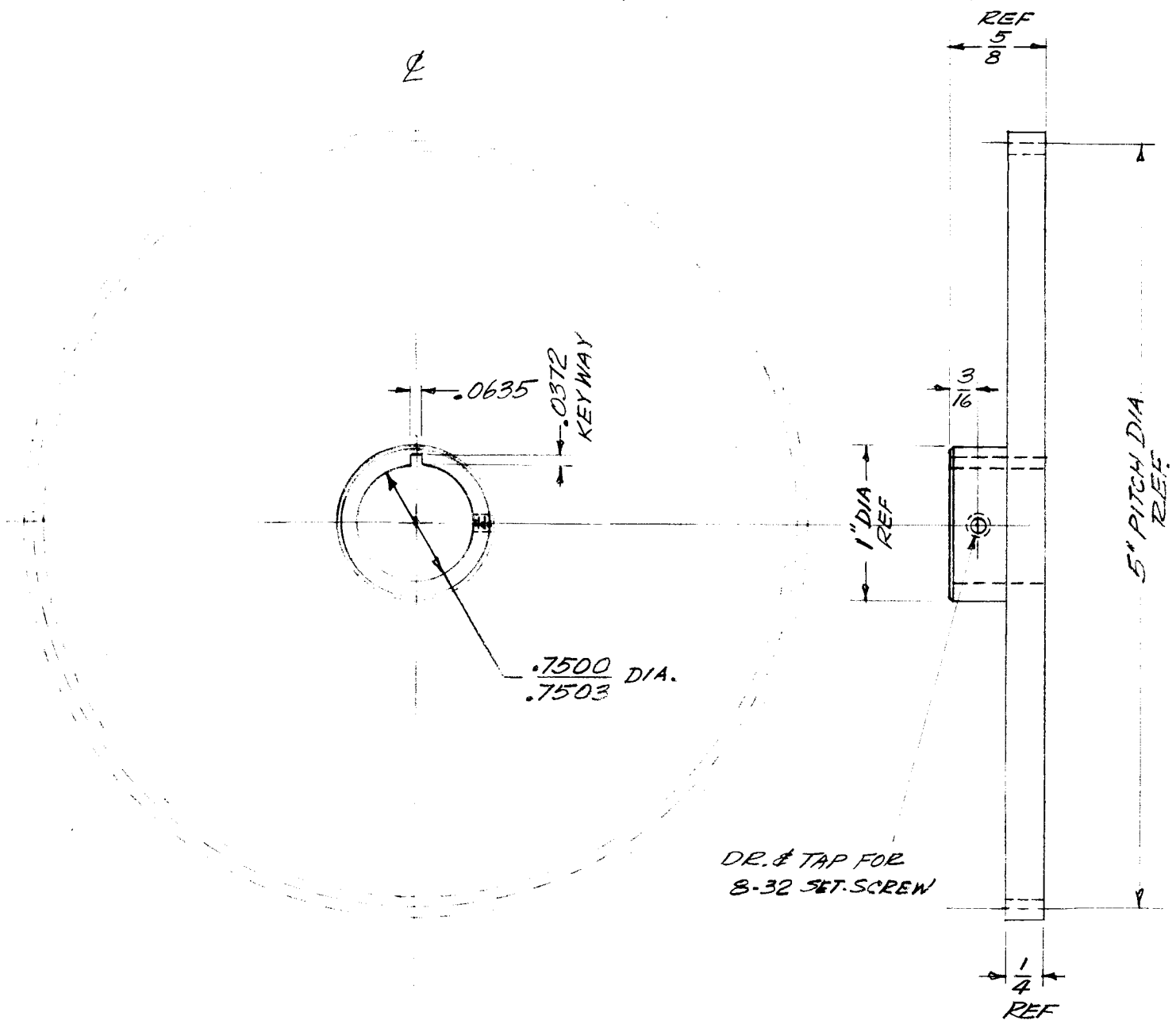
REQ. ITEM		PART NO.	F. BUDETTI	DESCRIPTION	SYMBOL
		STOCK SIZE		THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
		MATERIAL		GEAR, PINION	
	# 303	HEAT TREAT. SPEC.	6-10-66	GO.L	
	5104 PASSIVATE	FINISH & SPEC. NO.		DRAWN	CHECKED
					FINAL APPR. VAL
					GR228

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	SCALE	2:1
FRACTIONS ± 1/64 ANGLES ± 0° 30'	DATE	6-6-67
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005	CH. NO.	11-2-66
TOLERANCES	CHECKER	RG
	DRAFTS	
	ENG. APP.	
	CODE	5401-194





APPLICATION			REVISIONS						
QTY	MODEL USED ON	ASS'Y NO.	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
1	GPTR 10K1	AF109	X	EXPERIMENTAL RELEASE	10/19/63		J.A.		
			⊕	ORIGINAL RELEASE	5/13/73		C.S.		



REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
1	1	GR 205-45	GEAR	

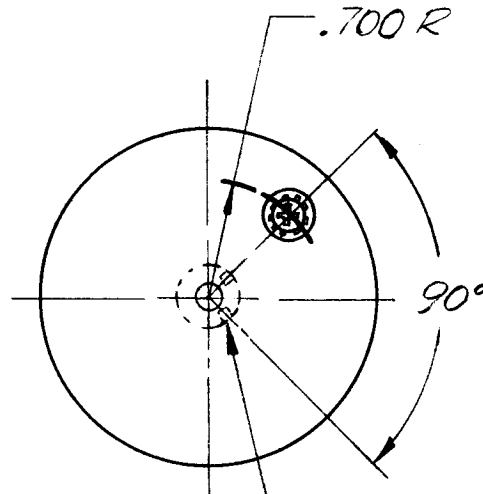
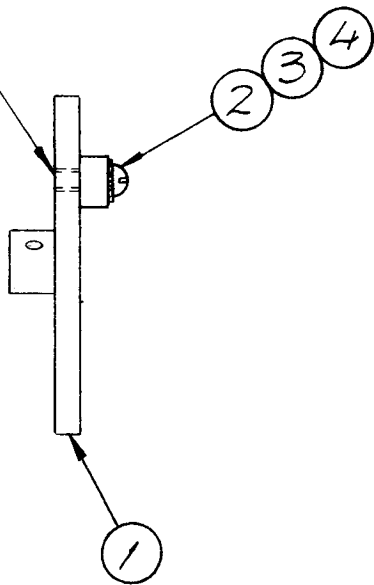
**LIST OF MATERIAL**

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		<b>THE TECHNICAL MATERIEL CORP.</b> MAMARONECK, NEW YORK	
DECIMALS X ± .05 .XX ± .01 .XXX ± .005	FRACTIONS 1/64 ANGLES 0° - 30'	FINAL APPROVAL <i>J. ANGER</i>	DATE 10/19/69
MATERIAL SEE ITEM 1.	MECH. DES. ELECT. DES.	DATE DATE	GEAR, MACHINING
FINISH	CHECKED	DATE	
	DRAWN <i>J. ANGER</i>	DATE 10/19/69	

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	SCALE 1:1	SHEET OF		

APPLICATION			REVISIONS						
QTY	MODEL USED ON	ASS'Y NO.	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
1	HFTA 10 K	AX5113	X	EXP RELEASE	3.31.70		GE		
			Ø	ORIG RELEASE FOR PROD	4/16/70		CV		
			A	REVISED	6/29/70	19917	KH	<del>WB</del>	FBI

DRILL & TAP THRU # 6-32  
FOR IT. 3 IN LINE WITH  
SUB-HOLE



\* DRILL & TAP #4-40  
(2 REQ.)

1	4	LWED8MRN	WASHER, LOCK, EXTERNAL
1	3	SCBP0632BN5	SCREW MACHINE
1	2	TE-135-22	SPACER
1	1	GR 205-47	GEAR SPUR (MODIFIED)*

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
AND INCLUDE CHEMICALLY APPLIED  
OR PLATED FINISHES

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
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LIST OF MATERIAL

DECIMALS	FRACTIONS
X ± .05	1/64
.XX ± .01	TOLS. ANGLES
.XXX ± .005	0° - 30°

FINAL APPROVAL	<i>[Signature]</i>	DATE	4.6.70
MECH. DES.	<i>[Signature]</i>	DATE	4/2/70
ELECT. DES.	<i>[Signature]</i>	DATE	4/16/70
CHECKED		DATE	
DRAWN	G. EVANGELIS	DATE	3.31.70

THE TECHNICAL MATERIEL CORP.  
MAMARONECK, NEW YORK

GEAR, ASSY.

MATERIAL
FINISH

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SIZE	A	CODE IDENT. NO.	82679	DWG NO.	GR 239	ISSUE	A
SCALE		SHEET		OF			

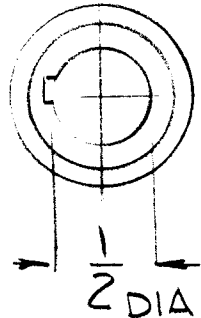
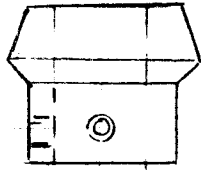
APPLICATION			REVISIONS							
QTY	MODEL USED ON	ASS'Y NO.	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD	
1	GPR-110	A5673	X	EXP. RELEASE						
				Original Release	1/19/77		GDL		*	

MFG. STERLING INSTRUMENT  
 CATALOG NO. H26-210  
 120 D.P., .2498 BORE  
 .125 FACE. P.D. 1.7500  
 2D. 17007

<small>UNLESS OTHERWISE SPECIFIED          DIMENSIONS ARE IN INCHES          AND INCLUDE CHEMICALLY APPLIED          OR PLATED FINISHES</small> <small>DECIMALS      FRACTIONS</small> <small>.X ± .05      1/64</small> <small>.XX ± .01 TOLS.      ANGLES</small> <small>.XXX ± .005      0°-30'</small>	REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.		
	LIST OF MATERIAL						
MATERIAL STAINLESS STEEL	FINAL APPROVAL	DATE	<b>THE TECHNICAL MATERIEL CORP.</b> MAMARONECK, NEW YORK  GEAR PIN TYPE				
FINISH	MECH. DES.	DATE					
	ELECT. DES.	DATE					
	CHECKED	DATE					
	DRAWN	DATE					
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				SCALE		SHEET	OF



APPLICATION			REVISIONS							
QTY	MODEL USED ON	ASS'Y NO.	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD	
1	MFTA-10K	AX805	Ø	ORIGINAL RELEASE	5-1889	~		DL		



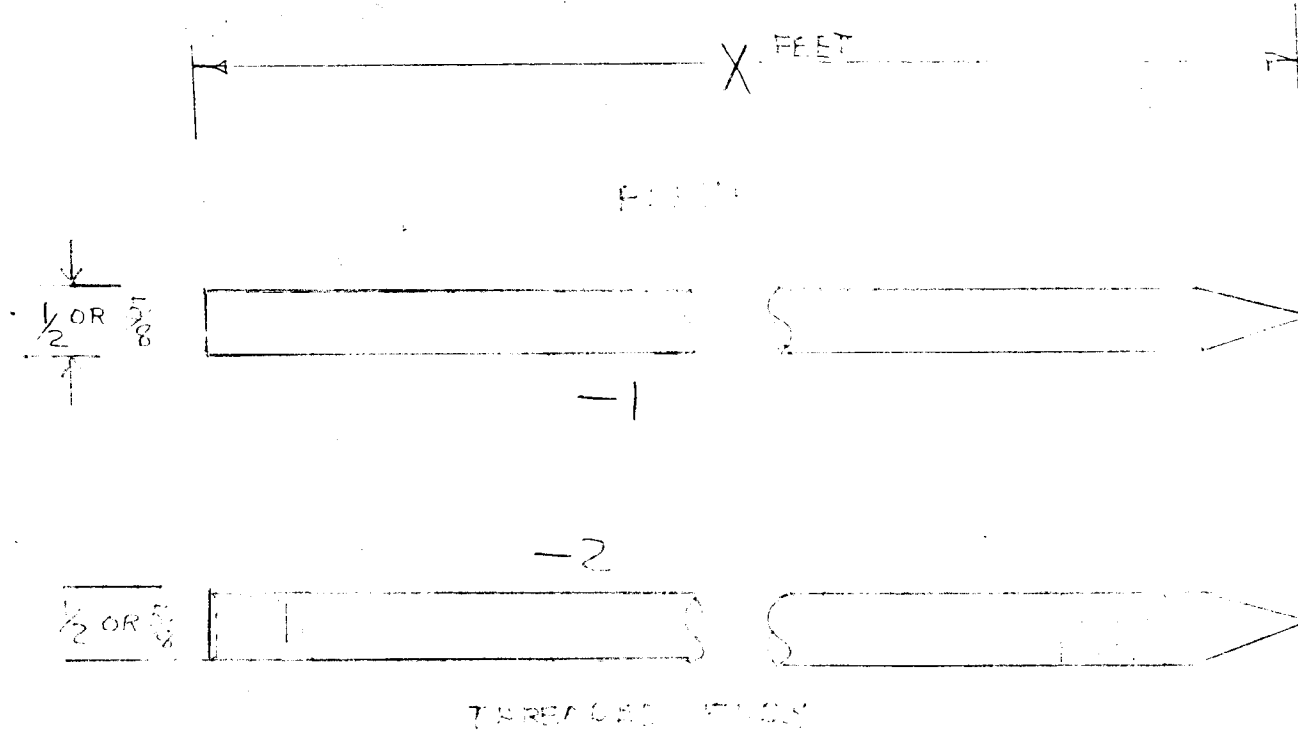
REF: GR 141-1 MODIFIED

<small>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES</small> <small>DECIMALS      FRACTIONS</small> <small>.X ± .05      1/64</small> <small>.XX ± .01    TOLS.    ANGLES</small> <small>.XXX ± .005    0° - 30'</small>	REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.		
	LIST OF MATERIAL						
MATERIAL	MECH. DES.	DATE	<b>THE TECHNICAL MATERIEL CORP.</b> MAMARONECK, NEW YORK  GEAR, BEVEL				
FINISH	ELECT. DES.	DATE					
	CHECKED	DATE					
	DRAWN	DATE					
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				A	82679	GR 245	Ø
				SCALE	-	SHEET	OF

APPLICATION

REVISIONS

QTY	MODEL USED ON	ASS'Y NO.	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
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BOTH STYLES ARE AVAILABLE  
IN LENGTHS OF 7 FEET OR SHORTER  
AS REQUIRED

REF. DRAWING  
750112  
1/73

EXAMPLE FOR ORDERING  
6 FT LONG THREADED END  
(1/2 DIA)

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		FRACTIONS 1/64 ANGLES 0° - 30'		LIST OF MATERIAL		
MATERIAL STEEL		FINAL APPROVAL GEB	DATE 10/7/74	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
FINISH BLACK PLATE		MECH. DES.	DATE	ROD, GROUND		
MATERIAL HEAVY GROUND PLATE		ELECT. DES.	DATE			
		CHECKED	DATE			
		DRAWN G-D	DATE 10/73			
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SCALE				SHEET	OF	