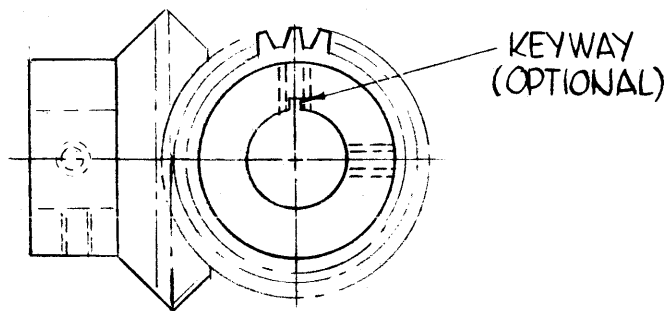
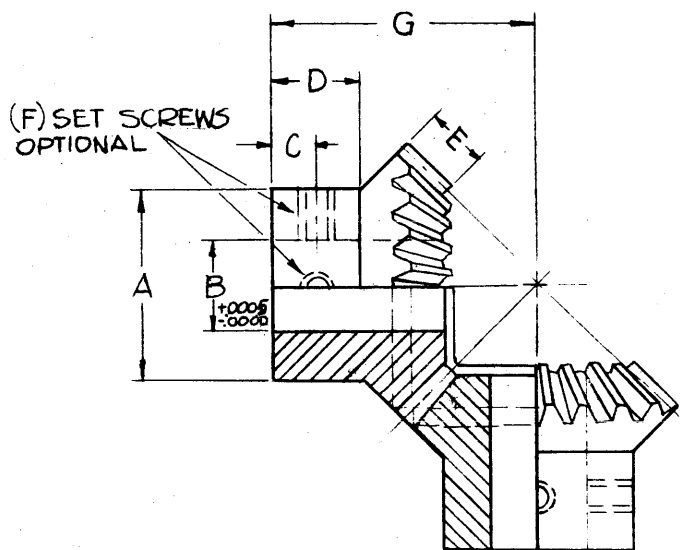


GR-200

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TMC. NO.	MFG. NO.	A	B	C	D	E	F	G	P.D.	TEETH	PITCH	PRESS. A	MATERIAL	FINISH	KEYWAY
+ GR-200-1		406	$\begin{smallmatrix} +.0002 \\ -.0005 \\ .1875 \end{smallmatrix}$	—	.205	.125	—	.495	.500	16	32	20°	STAINLESS STL.303	S104 PASSIVATE	—
* -2	L-110Y (MOD.)	5/8	3/8	7/32	7/16	.22	4-40	1-1/16	1.000	16	16	20°	STAINLESS STL.303	S104 PASSIVATE	—
+ -3		406	$\begin{smallmatrix} +.0002 \\ -.0005 \\ .1875 \end{smallmatrix}$.062	.125	.125	2-56	.409	.500	16	32	20°	STAINLESS STL.303	S104 PASSIVATE	1/16 X .035 DP

FOR PURCHASING ONLY

* S401-15
+ S401-194

REQ.	ITEM	PART NO.	F. BUDETTI	DESCRIPTION	SYMBOL
				THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		STOCK SIZE		GEAR, MITER	
		MATERIAL			
			SRG	aa	RE 3-30-64
				TYPE & TEMPER	HEAT TREAT. SPEC.
				8-6-63	
				FINISH & SPEC. NO.	
				ELEC. DES. APP.	MECH. DES. APP.
				GR-200	10

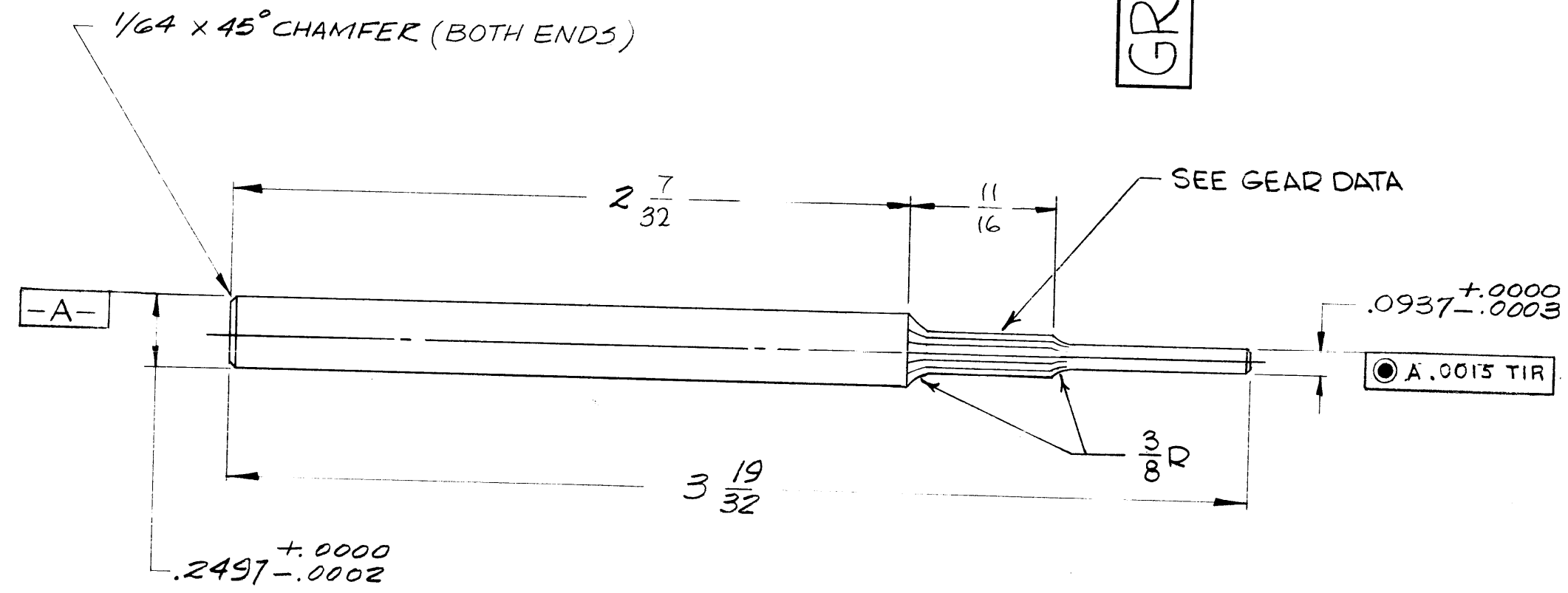
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
	UNLESS OTHERWISE SPECIFIED:					
	DIMENSIONS ARE IN INCHES					
	TOLERANCES ON FRACTIONS ± 1/64					
	DECIMALS ± .005					
	ANGLES ± 1/2					
	SCALE:					
	MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION.					
	REMOVE ALL BURRS AND SHARP EDGES					

REQ. PER UNIT	MODEL	SECTION	ASS'Y. NO.	DATE

USED ON

GR 208 A

REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD APPD
X	EXPERIMENTAL RELEASE	4-11-64		<i>[Signature]</i>	
Ø	ORIGINAL RELEASE FOR PRODUCTION	9-14-64		qe	
A	3/8 REF ADDED, 11/16 WAS 1/2 OVERALL 2 7/32 WAS 2 5/8, STAMPING NOTE DELETED	11.1.66	17120	lhw	<i>[Signature]</i>



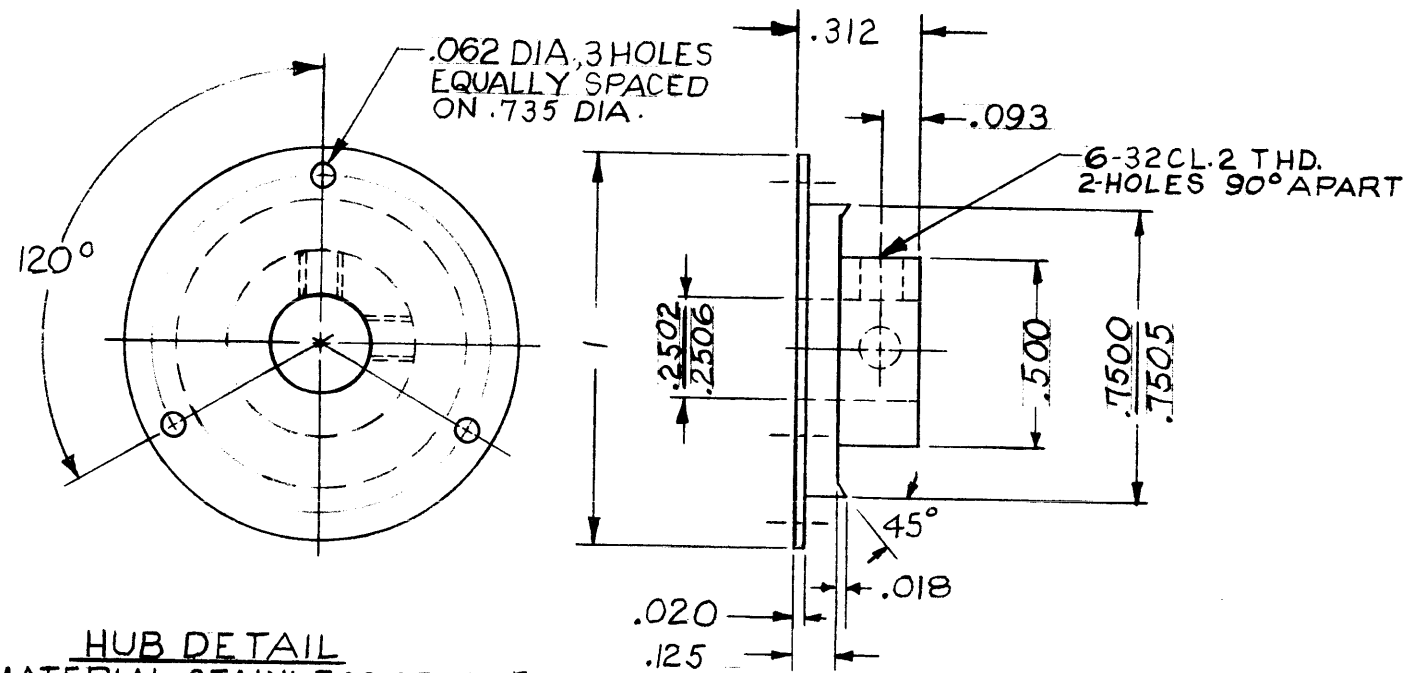
GEAR DATA	
PITCH	80
NO OF TEETH	10
PITCH DIA	.1250
P.A.	20°

Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
1	HFR-2	A3625
1	HFR-2	A3624
SCALE	CODE	
NONE	A	

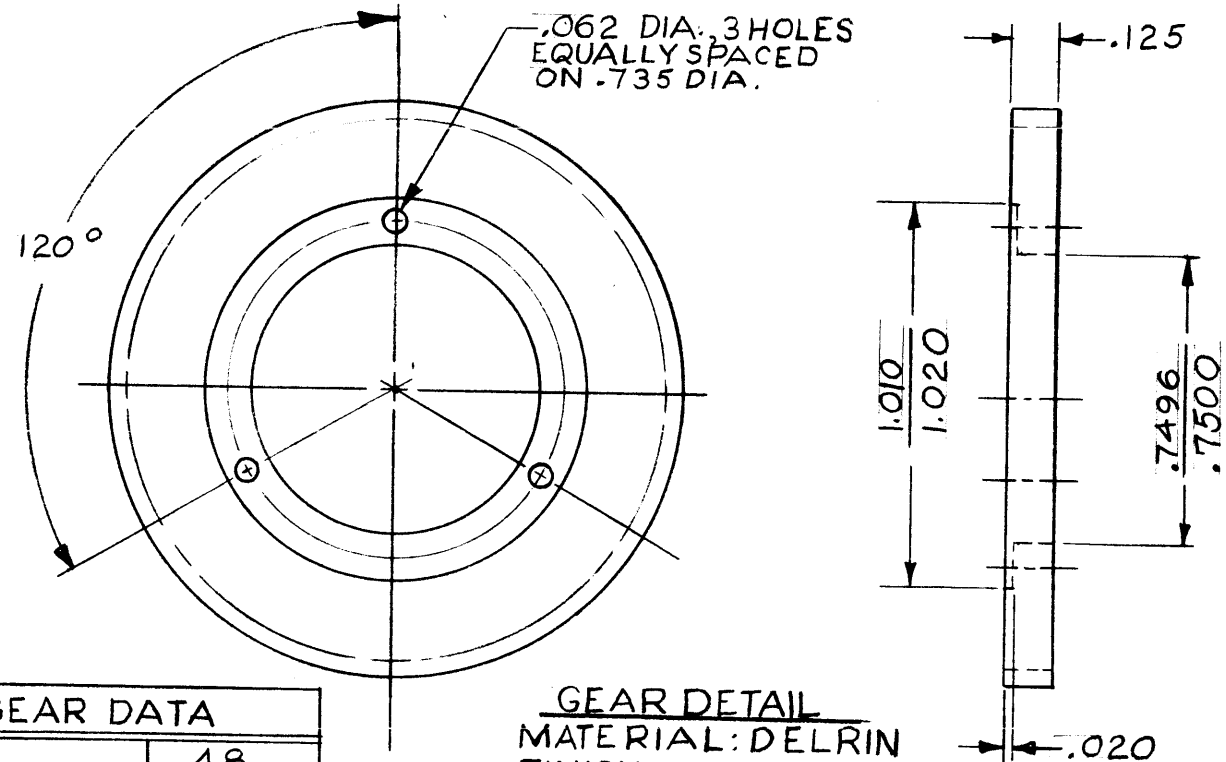
NOTES

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REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
	T. KRUY	E 3112B	LIST OF MATERIAL	
MATERIAL		#303 STAINLESS STEEL		
FINISH		S104 PASSIVATE		
THE TECHNICAL MATERIEL CORP.		MAMARONECK, NEW YORK		
TITLE		GEAR SHAFT, SPUR		
DRAWN	<i>[Signature]</i>	DATE	4-11-64	FINAL APPROVAL
CHECKED	@	DATE	9-11-64	<i>[Signature]</i>
ELECT. DES.		DATE		
MECH. DES.	T. Kruy	DATE		
SHEET				REV. LTR.
GR 208				A



HUB DETAIL
 MATERIAL: STAINLESS STEEL #303
 FINISH: PASSIVATE, S104



GEAR DETAIL
 MATERIAL: DELRIN
 FINISH: NONE

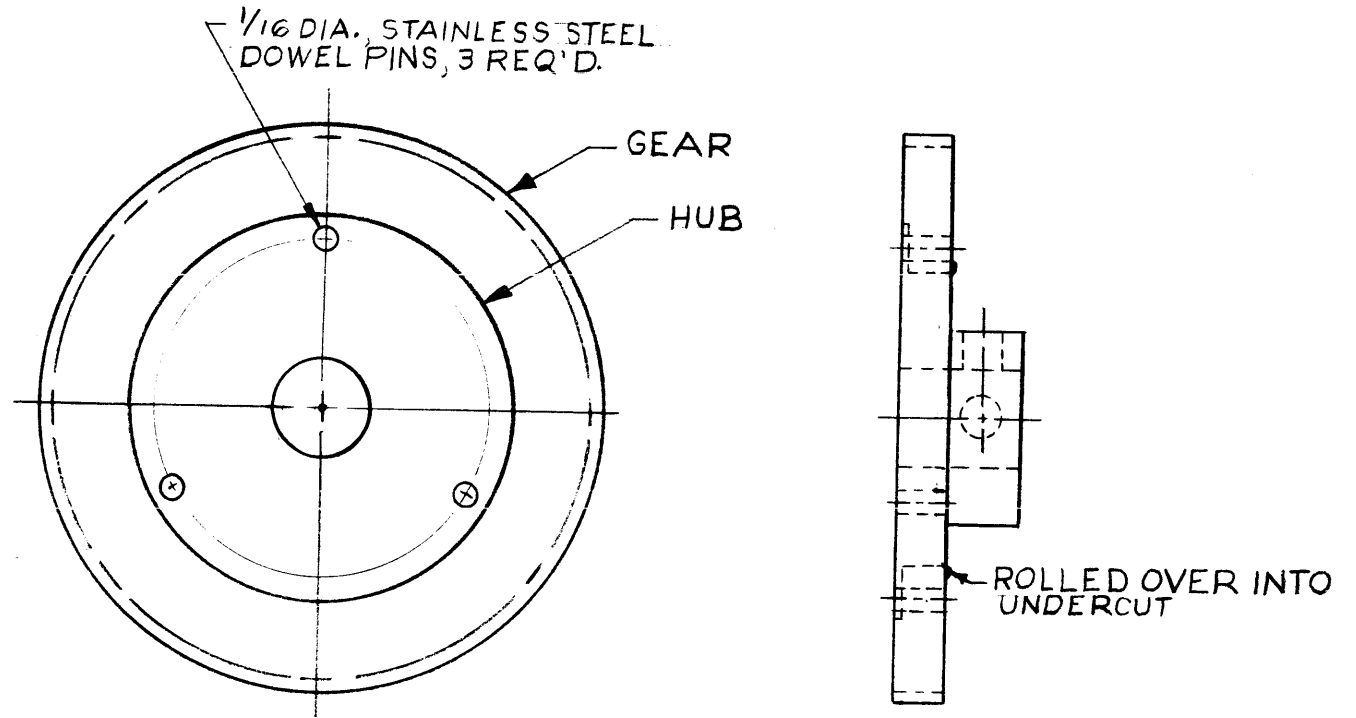
GEAR DATA	
PITCH	48
NO. OF TEETH	72
P.D.	1.500
O.D.	1.5416 ± .002
PRESSURE ANGLE	20°

NOTES

1	HFS-1	MC UNIT
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE 2:1	CODE C	S401-232
THE CONTENTS OF THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE TECHNICAL MATERIEL CORP. ITS UNAUTHORIZED USE OR REPRODUCTION IN WHOLE OR IN PART IS STRICTLY FORBIDDEN.		

GR-210

REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD
X	EXPERIMENTAL RELEASE	4-9-64	X	A.M.	@
O	ORIGINAL RELEASE FOR PRODUCTION	4-10-64	O	A.M.	

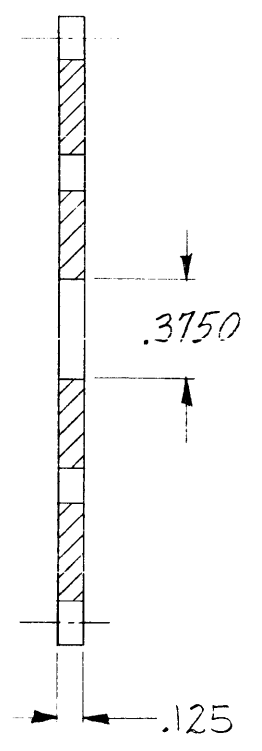
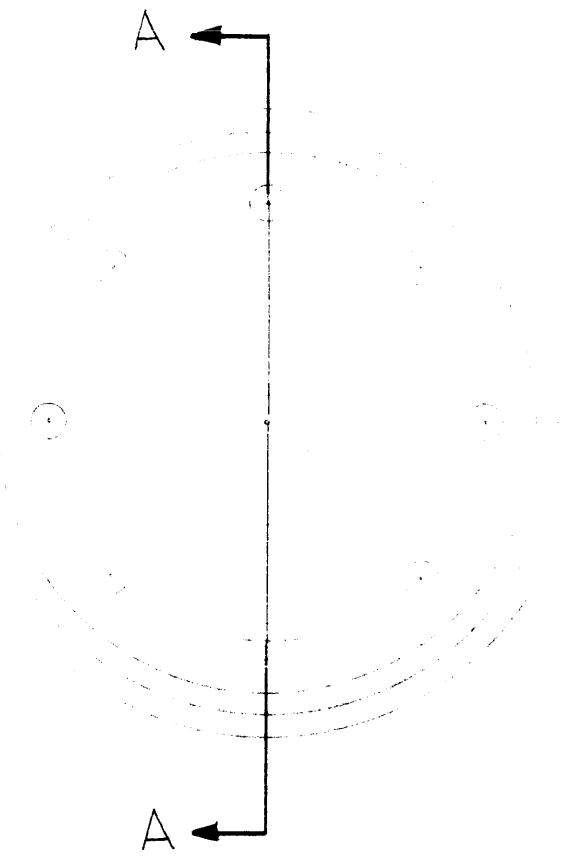


GEAR & HUB ASSEMBLY

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
	EATON		LIST OF MATERIAL	E-3071
MATERIAL		SEE DETAILS	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
FINISH		SEE DETAILS	TITLE GEAR, SPUR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN A. MARINO	DATE 4-9-64	FINAL APPROVAL [Signature]
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		CHECKED @	DATE 4-10-64	DATE 4-10-64
FRACTIONS ± 1/64 ANGLES ± 0° 30'		ELECT. DES. [Signature]	DATE 4-10-64	DATE 4-10-64
TOLERANCES		MECH. DES. [Signature]	DATE 4-10-64	DATE 4-10-64
			SHEET	REV. LTR.

GR212

REVISIONS						
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
X	EXPERIMENTAL RELEASE	5-13-64		JD		
Ø	ORIGINAL RELEASE FOR PRODUCTION	9-11-64		EL		



GEAR DATA	
Nº OF TEETH	144
PITCH	48
PITCH DIA	3.000
PRESSURE ANGLE	20°

SECTION AA

NOTE:
REMOVE ALL BURRS & SHARP EDGES

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
T. KRWY	E3112B	LIST OF MATERIAL		
MATERIAL		#303 STAINLESS STEEL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
FINISH		S104 PASSIVATE	TITLE GEAR, SPUR, W/O HUB	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN <i>Ad Jones</i>	DATE 5-13-64	FINAL APPROVAL <i>RAC</i>
		CHECKED <i>@</i>	DATE 7-11-64	
		ELECT. DES.	DATE	GR212
		MECH. DES. <i>T. KRWY</i>	DATE	Ø
			SHEET	REV. LTR.

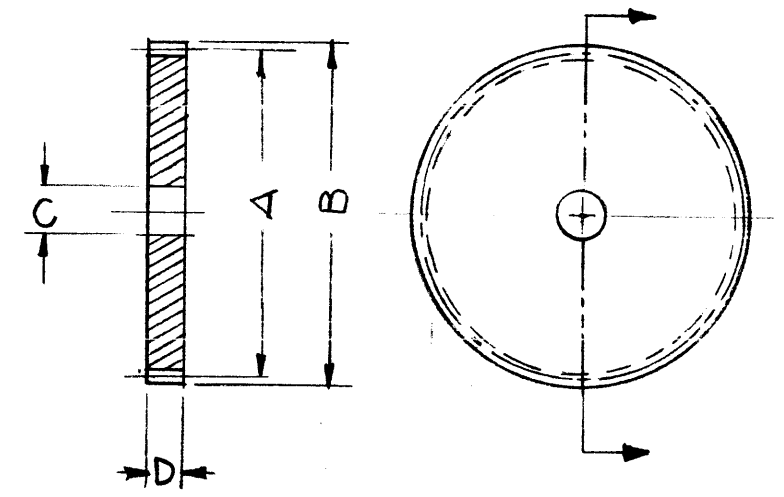
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
1	HFR-2	A3625
1	HFR-2	A3624
SCALE	CODE	
DO NOT SCALE	A	
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NOTES

TMC P/N	MFG P/N	GEAR INFORMATION							REMARKS
		PITCH	NO. OF TEETH	A (PD)	B (OD)	C	D	PRESSURE ANGLE	
GR217-1	G7-80 OR EQUIV.	48	80	1.6666	1.7083	+.0003 -.0000 .250 BORE	.187	20	HUB TO BE MACH OFF FLUSH WITH GEAR WALL

GR217

REVISIONS					
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD
Ø	ORIGINAL RELEASE	4-2-65		G.D.L	<i>[Signature]</i>



STANDARD DRAWING

1	CHGR-3	A 4175
Q'TY./UNIT	MODEL USED ON	ASS'Y. NO.
SCALE 1:1	CODE C	S401-350

NOTES

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REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
J. ANGER LIST OF MATERIAL				
MATERIAL		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
FINISH		TITLE		
S104 CLEAR PASSIVATED (AFTER CUTTING)		GEAR SPUR		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES				
DRAWN	G.D.L	DATE	1-25-65	FINAL APPROVAL
CHECKED	<i>[Signature]</i>	DATE	4/2/65	<i>[Signature]</i>
ELECT. DES.	J. Anger	DATE	4/2/65	DATE
MECH. DES.		DATE		DATE
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005				FRACTIONS ± 1/64 ANGLES ± 0° 30'
TOLERANCES				
SHEET				REV. LTR.
GR 217				Ø

5

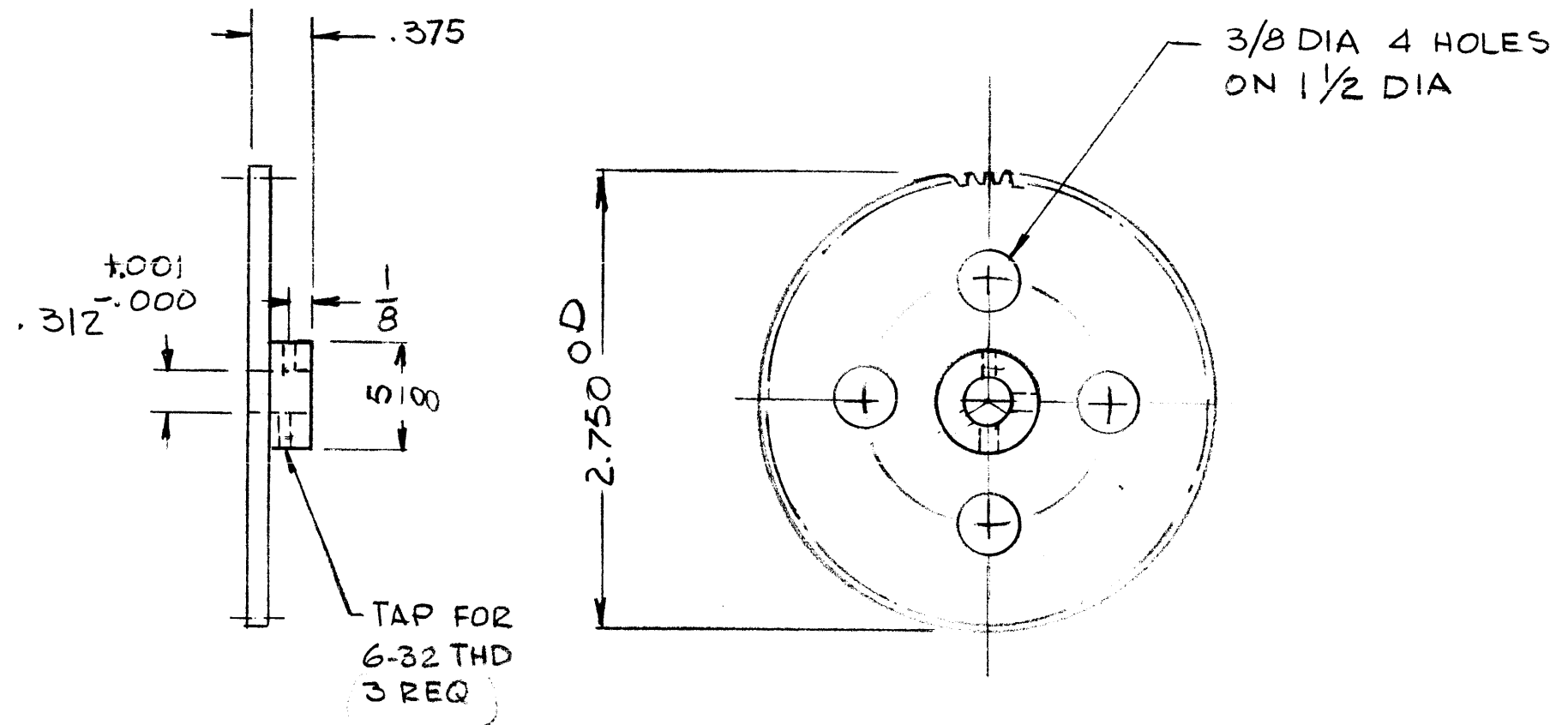
4

3

2

1

REVISIONS							
E.M.N. NO.	DRAFT	CHKD	ZONE	LTR	DESCRIPTION	DATE	APPROVED
	PH			4	RED TOOTH TOLERANCE	12-29-77	<i>OB</i>
				φ	ORIG REL	10-2-80	



— SPECIFICATIONS —
 NO. OF TEETH = 130
 DIAMETRAL PITCH = 48
 PITCH DIA. = 2.7083
 PRESSURE ANGLE = 20°
 FACE = 1/8

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
LIST OF MATERIAL				
			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
			GEAR, SPUR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		FINAL APPROVAL <i>OB</i>	DATE 10-26-80	
DECIMALS .X ± .05 FRACTIONS 1/64 TOLS. ANGLES 0°-30'		MECH. DES.	DATE	
.XX ± .01		ELECT. DES.	DATE	
.XXX ± .005		CHECKED	DATE	
MATERIAL STEEL, STAINLESS # 302		DRAWN G.D.L.	DATE 1-30-77	
FINISH 5104 PASSIVATE		SIZE B	CODE IDENT. NO. 82679	DWG NO. GR 244
NOTICE TO PERSONS RECEIVING THIS DRAWING THE TECHNICAL MATERIEL CORPORATION claims proprietary right in the material disclosed hereon. This drawing is issued in confidence for engineering information only and may not be reproduced or used to manufacture anything shown hereon without permission from THE TECHNICAL MATERIEL CORPORATION to the user. This drawing is loaned for mutual assistance and is subject to recall at any time.		SCALE	SHEET	OF

1	HFTA-10K	A5248
QTY / UNIT	MODEL USED ON	ASS'Y NO.
APPLICATION		
	CODE	

D

D

C

C

B

B

A

A

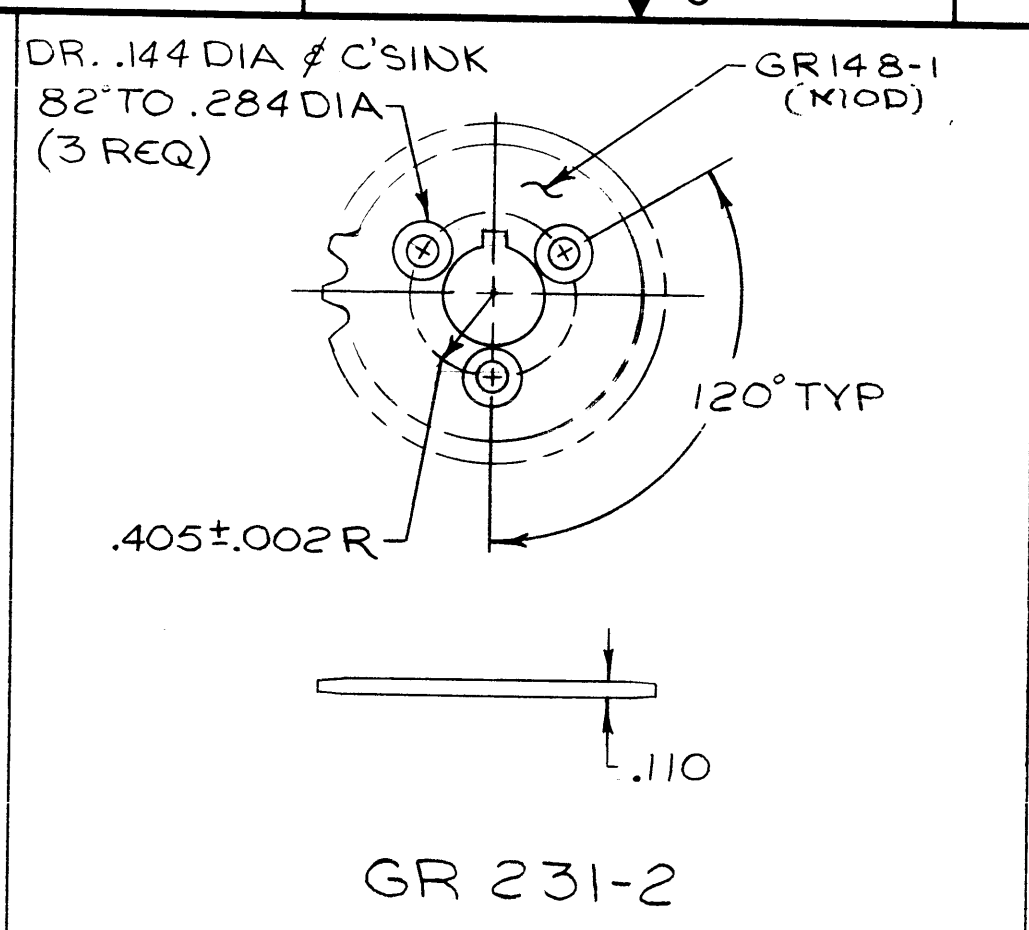
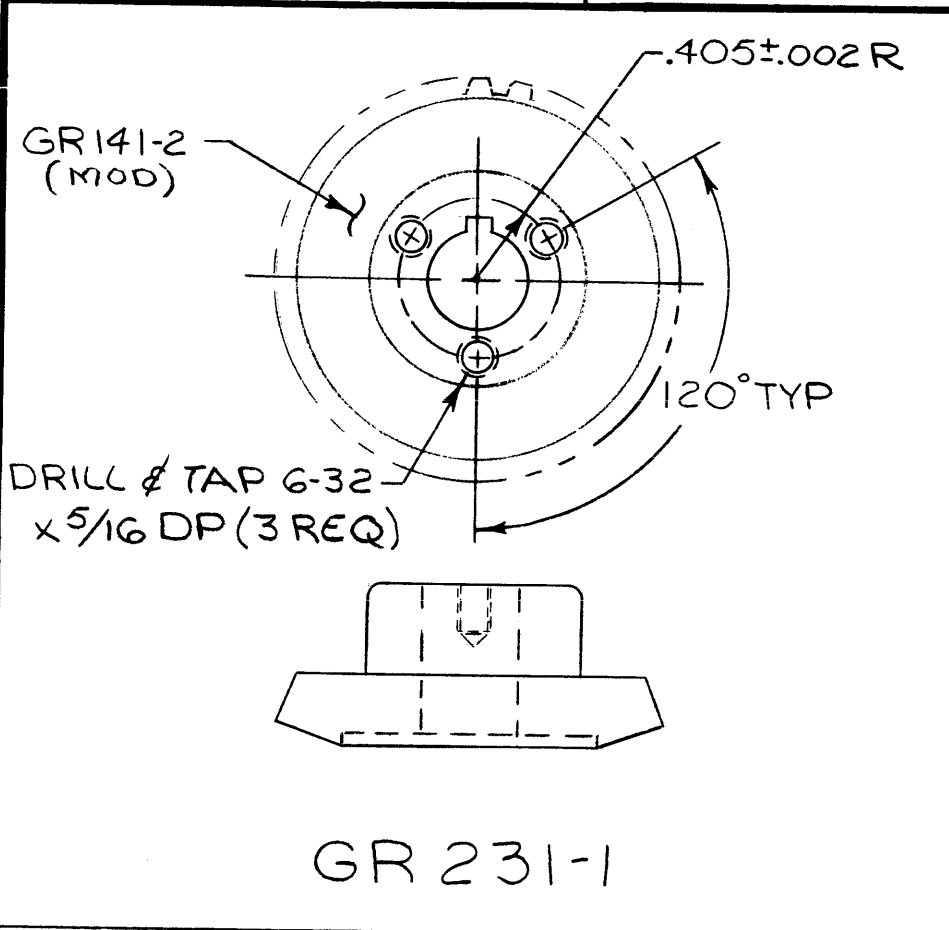
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4

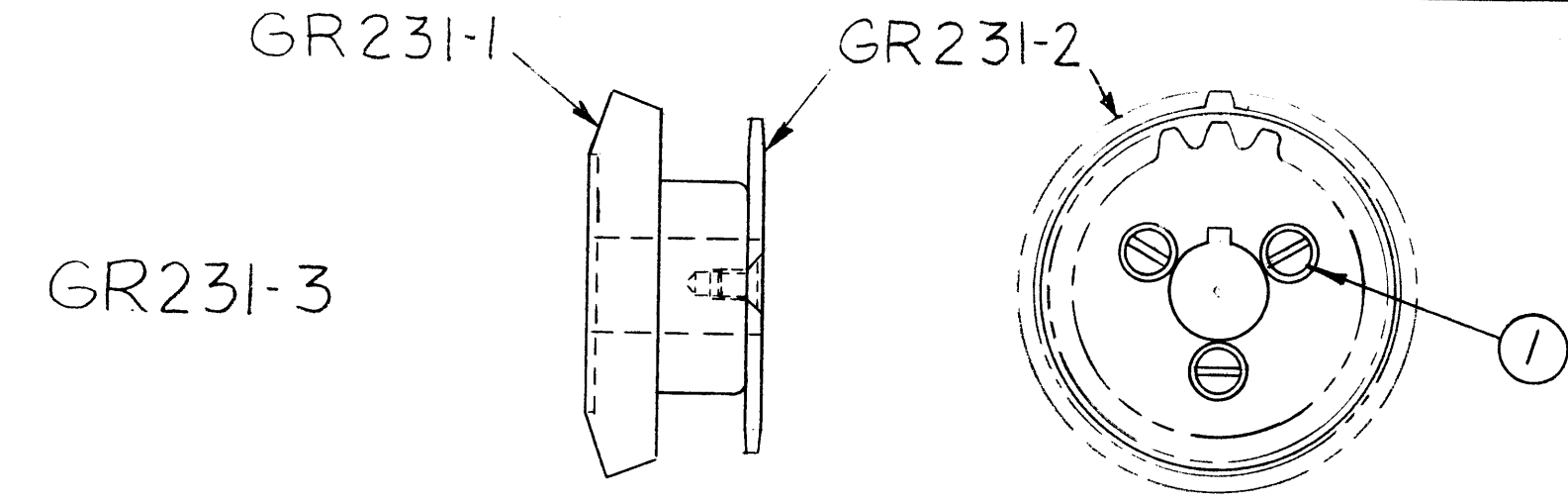
3

2

1



REVISIONS							
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	X	EXP. RELEASE	5-13-68				
	B	ORIG. RELEASE FOR PROCD	5-20-68	Φ			
	A	UPDATED & REV.	9-26-68	19053			



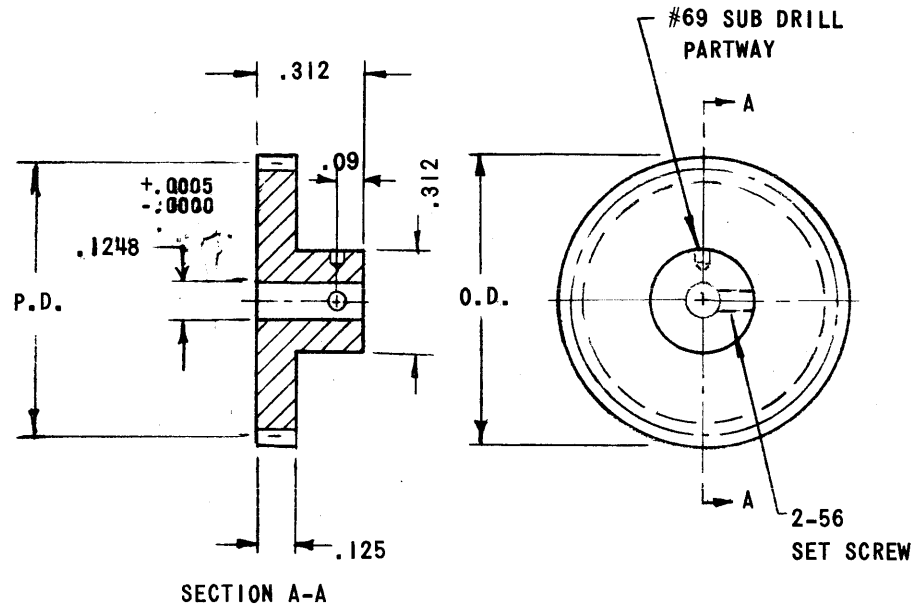
ASSEMBLY

3	1	SCFP0632SS5	SCREW, MACHINE	
REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
F. BUDETTI LIST OF MATERIAL				
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
BEVEL GEAR & SPROCKET ASS'Y				
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE	
B	82679	GR 231	A	
SCALE 1:1			SHEET OF	

1	BCT-IOKA	
QTY / UNIT	MODEL USED ON	ASS'Y NO.
APPLICATION		
	CODE A	S401-451
<p>NOTICE TO PERSONS RECEIVING THIS DRAWING</p> <p>THE TECHNICAL MATERIEL CORPORATION claims proprietary right in the material disclosed hereon. This drawing is issued in confidence for engineering information only and may not be reproduced or used to manufacture anything shown hereon without permission from THE TECHNICAL MATERIEL CORPORATION to the user. This drawing is loaned for mutual assistance and is subject to recall at any time.</p>		
MATERIAL		
FINISH		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	
DECIMALS	FRACTIONS
.X ± .05	1/64
.XX ± .01	TOLS. ANGLES
.XXX ± .005	0° - 30'

GEAR DATA				MATERIAL DATA	
TMC CODE	TEETH	P.D. +.000 -.001	O.D. +.000 -.002	* S STAINLESS STEEL MFR P/N	* A ALUMINUM MFR P/N
021	21	.4375	.479	G61-21	G62-21
022	22	.4583	.500	-22	-22
023	23	.4792	.521	-23	-23
024	24	.5000	.542	-24	-24
025	25	.5208	.562	-25	-25
026	26	.5416	.583	-26	-26
027	27	.5625	.604	-27	-27
028	28	.5833	.625	-28	-28
029	29	.6042	.646	-29	-29
030	30	.6250	.666	-30	-30
032	32	.6667	.708	-32	-32
034	34	.7083	.750	-34	-34
036	36	.7500	.792	-36	-36
038	38	.7917	.833	-38	-38
040	40	.8333	.875	-40	-40
042	42	.8750	.917	-42	-42
044	44	.9167	.958	-44	-44
046	46	.9583	1.000	-46	-46
048	48	1.0000	1.042	-48	-48
050	50	1.0417	1.083	-50	-50
055	55	1.1458	1.187	-55	-55
056	56	1.1667	1.208	-56	-56
060	60	1.2500	1.292	-60	-60
064	64	1.3333	1.375	-64	-64
065	65	1.3541	1.396	-65	-65
070	70	1.4583	1.500	-70	-70
072	72	1.5000	1.542	-72	-72
075	75	1.5625	1.604	-75	-75
080	80	1.6667	1.708	-80	-80
084	84	1.7500	1.792	-84	-84
085	85	1.7708	1.812	-85	-85
090	90	1.8750	1.916	-90	-90
092	92	1.9166	1.958	-92	-92
095	95	1.9791	2.021	-95	-95
096	96	2.0000	2.042	-96	-96
100	100	2.0833	2.125	G61-100	G62-100

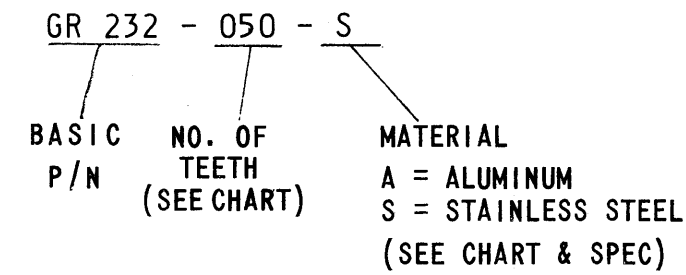


PRESSURE α : 20°
 CLASS OF GEAR: PRECISION I
 TOTAL COMPOSITE ERROR: .001
 TOOTH TO TOOTH COMPOSITE ERROR: .0004

MATERIAL AND FINISH:
 * STAINLESS STEEL: #303, CLEAR PASSIVATED (AFTER CUTTING)
 * ALUMINUM: 24ST, CHROMIC ACID ANODIZED (BEFORE CUTTING)

REVISIONS						
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD APPD
	X	EXPERIMENTAL RELEASE	7/18/68		C.V.	<i>[Signature]</i>
	Ø	ORIG. RELEASE FOR PROD.	9-24-68	Ø	R.G.	<i>[Signature]</i>

TMC PART NUMBER WILL APPEAR IN THE FOLLOWING FORM



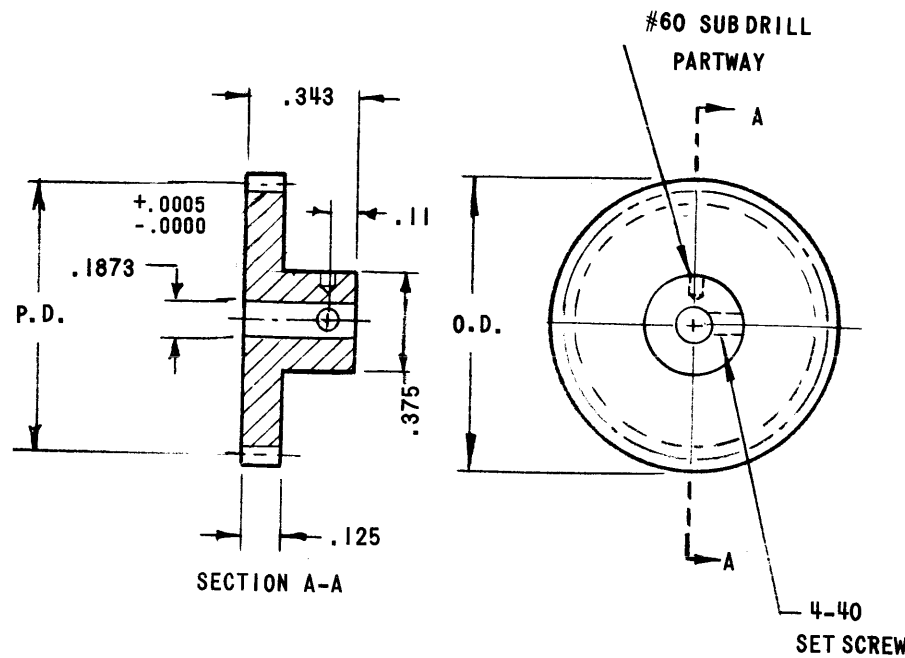
QTY / UNIT	MODEL USED ON	ASS'Y NO.
	HFRR-4	
APPLICATION		
CODE	S401-350	

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 THE TECHNICAL MATERIEL CORPORATION claims proprietary right in the material disclosed hereon. This drawing is issued in confidence for engineering information only and may not be reproduced or used to manufacture anything shown hereon without permission from THE TECHNICAL MATERIEL CORPORATION to the user. This drawing is loaned for mutual assistance and is subject to recall at any time.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005	FRACTIONS 1/64 ANGLES 0°-30'
MATERIAL	
FINISH	

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
			O. POSE LIST OF MATERIAL	
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
GEAR, SPUR, PRECISION (48 PITCH, 1/8 FACE, 1/8 BORE)				
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE	
B	82679	GR 232	Ø	
SCALE			SHEET	OF

GEAR DATA				MATERIAL DATA	
TMC CODE	NO.	P.D. +.000 -.001	O.D. +.000 -.002	* S STAINLESS STEEL MFGR P/N	* A ALUMINUM MFGR P/N
021	21	.4375	.479	G1-21	G2-21
022	22	.4583	.500	-22	-22
023	23	.4792	.521	-23	-23
024	24	.5000	.542	-24	-24
025	25	.5208	.562	-25	-25
026	26	.5416	.583	-26	-26
027	27	.5625	.604	-27	-27
028	28	.5833	.625	-28	-28
029	29	.6042	.646	-29	-29
030	30	.6250	.666	-30	-30
032	32	.6667	.708	-32	-32
034	34	.7083	.750	-34	-34
036	36	.7500	.792	-36	-36
038	38	.7917	.833	-38	-38
040	40	.8333	.875	-40	-40
042	42	.8750	.917	-42	-42
044	44	.9167	.958	-44	-44
046	46	.9583	1.000	-46	-46
048	48	1.0000	1.042	-48	-48
050	50	1.0417	1.083	-50	-50
055	55	1.1458	1.187	-55	-55
056	56	1.1667	1.208	-56	-56
060	60	1.2500	1.292	-60	-60
064	64	1.3333	1.375	-64	-64
065	65	1.3541	1.396	-65	-65
070	70	1.4583	1.500	-70	-70
072	72	1.5000	1.542	-72	-72
075	75	1.5625	1.604	-75	-75
080	80	1.6667	1.708	-80	-80
084	84	1.7500	1.792	-84	-84
085	85	1.7708	1.812	-85	-85
090	90	1.8750	1.916	-90	-90
092	92	1.9166	1.958	-92	-92
095	95	1.9791	2.021	-95	-95
096	96	2.0000	2.042	-96	-96
100	100	2.0833	2.125	G1-100	G2-100



PRESSURE $\angle 20^\circ$
 CLASS OF GEAR: PRECISION I
 TOTAL COMPOSITE ERROR: .001
 TOOTH TO TOOTH COMPOSITE ERROR: .0004

MATERIAL AND FINISH
 * STAINLESS STEEL: #303, CLEAR PASSIVATED (AFTER CUTTING)
 * ALUMINUM: 24ST, CHROMIC ACID ANODIZED (BEFORE CUTTING)

REVISIONS						
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD APPD
	X	EXPERIMENTAL RELEASE	7/22/68		C.V.	<i>[Signature]</i>
	Ø	ORIG. RELEASE FOR PROD	9-24-68	Ø	R.G.	<i>[Signature]</i>

TMC P/N WILL BE IN THE FOLLOWING FORM

GR 233 - 050 - S
 BASIC P/N NO. OF TEETH MATERIAL
 A = ALUMINUM
 S = STAINLESS STEEL
 (SEE CHART AND SPEC)

HFRR-4		
QTY / UNIT	MODEL USED ON	ASS'Y NO.
APPLICATION		
CODE	S401-350	

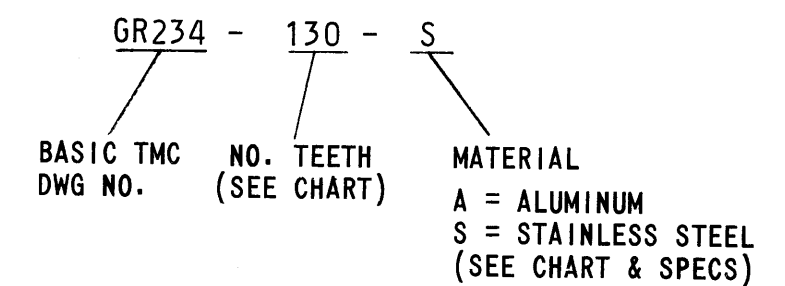
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REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
O. POSE LIST OF MATERIAL				
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
GEAR, SPUR, PRECISION (48 PITCH, 1/8 FACE, 3/16 BORE)				
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE	
B	82679	GR-233	Ø	
SCALE			SHEET OF	

TMC CODE	NO TEETH	P.D. +.000 -.001	P.D. +.000 -.002	STAINLESS STEEL CAT NO.	ALUMINUM CAT NO.
060	60	1.2500	1.292	J1-60	J2-60
064	64	1.3333	1.375	J1-64	J2-64
065	65	1.3541	1.396	J1-65	J2-65
070	70	1.4583	1.500	J1-70	J2-70
072	72	1.5000	1.542	J1-72	J2-72
075	75	1.5625	1.604	J1-75	J2-75
080	80	1.6667	1.708	J1-80	J2-80
084	84	1.7500	1.792	J1-84	J2-84
085	85	1.7708	1.812	J1-85	J2-85
090	90	1.8750	1.916	J1-90	J2-90
092	92	1.9166	1.958	J1-92	J2-92
095	95	1.9791	2.021	J1-95	J2-95
096	96	2.0000	2.042	J1-96	J2-96
100	100	2.0833	2.125	J1-100	J2-100
105	105	2.1875	2.229	J1-105	J2-105
110	110	2.2916	2.333	J1-110	J2-110
115	115	2.3958	2.438	J1-115	J2-115
120	120	2.5000	2.541	J1-120	J2-120
130	130	2.7083	2.750	J1-130	J2-130
140	140	2.9166	2.958	J1-140	J2-140

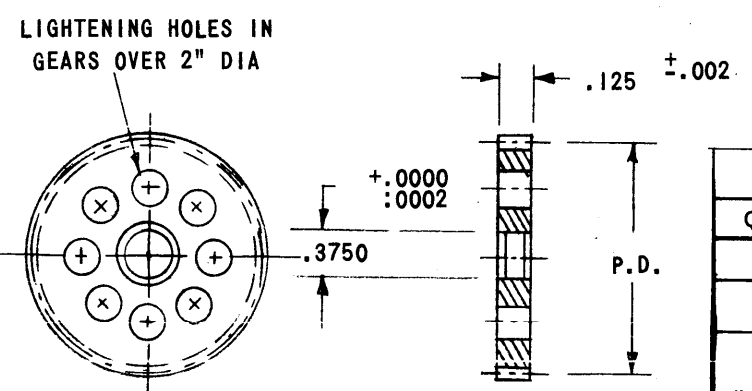
REVISIONS						
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD APPD
	X	EXPERIMENTAL RELEASE			C.V.	<i>[Signature]</i>
	Ø	ORIG. RELEASE FOR PROD	7-24-68	Ø	R.G.	<i>[Signature]</i>

TMC PART NUMBER SHALL BE IN THE FOLLOWING FORMAT:



SPECIFICATIONS

PRESSURE ϕ : 20°
 CLASS OF GEAR: PRECISION I
 TOTAL COMPOSITE ERROR: .001
 TOOTH TO TOOTH COMPOSITE ERROR: .0004
 MATERIAL & FINISH
 STAINLESS STEEL: #303, CLEAR PASSIVATED (AFTER CUTTING)
 ALUMINUM: 24ST, CHROME ACID ANODIZED (BEFORE CUTTING)



HFR-4		ASS'Y NO.	
APPLICATION			
QTY / UNIT	MODEL USED ON	CODE S401-350	
<p>NOTICE TO PERSONS RECEIVING THIS DRAWING THE TECHNICAL MATERIEL CORPORATION claims proprietary right in the material disclosed hereon. This drawing is issued in confidence for engineering information only and may not be reproduced or used to manufacture anything shown hereon without permission from THE TECHNICAL MATERIEL CORPORATION to the user. This drawing is loaned for mutual assistance and is subject to recall at any time.</p>			

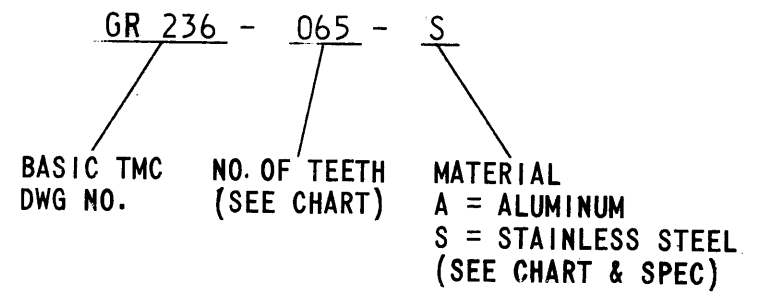
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		APPROVAL <i>[Signature]</i>	DATE 9-23-68
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005	FRACTIONS 1/64 ANGLES 0°-30'	ELECT. DES. <i>[Signature]</i>	DATE 9/23/68
MATERIAL		CHECKED <i>[Signature]</i>	DATE 8-21-68
FINISH		DRAWN <i>[Signature]</i>	

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
LIST OF MATERIAL				
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
GEAR, SPUR, DISC PRECISION 48 PITCH, 1/8 FACE, 3/8 BORE				
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE	
B	82679	GR 234	Ø	
SCALE			SHEET	OF

TMC CODE	NO. TEETH	P.D. +.000 -.001	P.D. +.000 -.002	ALUM GEARS CAT NO.	STAINLESS GEARS CAT NO.
065	65	1.3541	1.396	P14-1-65	P17-1-65
070	70	1.4583	1.500	P14-1-70	P17-1-70
072	72	1.5000	1.542	P14-1-72	P17-1-72
075	75	1.5625	1.604	P14-1-75	P17-1-75
080	80	1.6667	1.708	P14-1-80	P17-1-80
084	84	1.7500	1.792	P14-1-84	P17-1-84
085	85	1.7708	1.812	P14-1-85	P17-1-85
090	90	1.8750	1.916	P14-1-90	P17-1-90
095	95	1.9791	2.021	P14-1-95	P17-1-95
096	96	2.0000	2.042	P14-1-96	P17-1-96
100	100	2.0833	2.125	P14-1-100	P17-1-100
105	105	2.1875	2.229	P14-1-105	P17-1-105
110	110	2.2916	2.333	P14-1-110	P17-1-110
115	115	2.3958	2.438	P14-1-115	P17-1-115
120	120	2.5000	2.541	P14-1-120	P17-1-120
125	125	2.6041	2.646	P14-1-125	P17-1-125
130	130	2.7083	2.750	P14-1-130	P17-1-130
132	132	2.7500	2.791	P14-1-132	P17-1-132

REVISIONS						
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD APPD
	X	EXPERIMENTAL RELEASE	9/9/68		C.V.	<i>[Signature]</i>
	Ø	ORIG. RELEASE FOR PROD.	9-24-68	Ø	R.G.	<i>[Signature]</i>

TMC P/N SHALL BE IN THE FOLLOWING FORMAT:

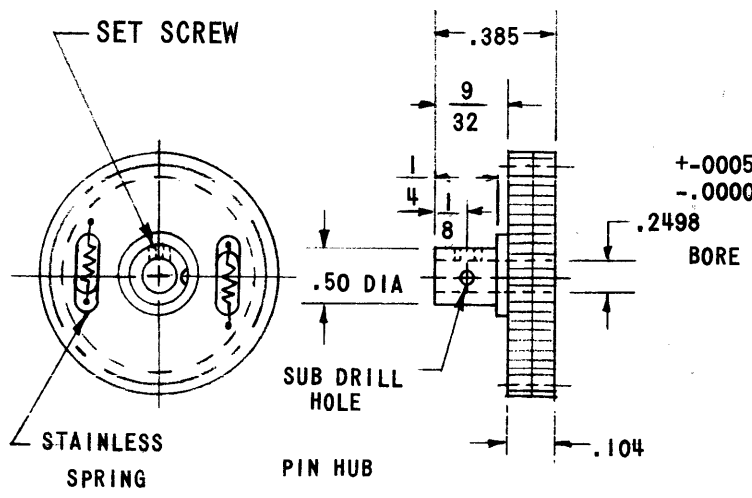


SPECIFICATIONS

PRESSURE α : 20°
 CLASS OF GEAR: PRECISION I
 TOTAL COMPOSITE ERROR: .001
 TOOTH TO TOOTH COMPOSITE ERROR: .0004

MATERIAL AND FINISH:

ALUMINUM: 24ST, BLACK ANODIZE
 STAINLESS STEEL: #303, CLEAR PASSIVATED
 HUBS: STAINLESS STEEL #303, CLEAR PASSIVATED



QTY / UNIT	MODEL USED ON	ASS'Y NO.
	HFRR-4	
APPLICATION		
CODE	S401-350	
NOTICE TO PERSONS RECEIVING THIS DRAWING THE TECHNICAL MATERIEL CORPORATION claims proprietary right in the material disclosed hereon. This drawing is issued in confidence for engineering information only and may not be reproduced or used to manufacture anything shown hereon without permission from THE TECHNICAL MATERIEL CORPORATION to the user. This drawing is loaned for mutual assistance and is subject to recall at any time.		

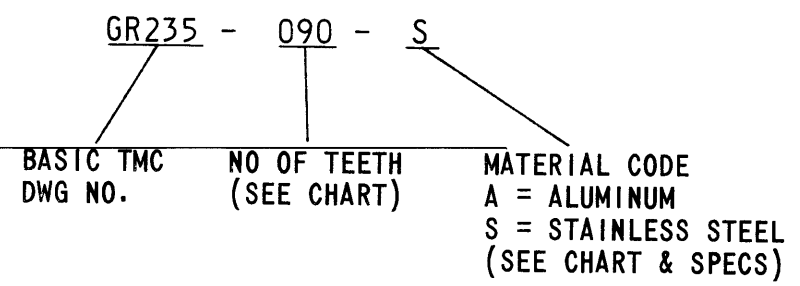
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	FINAL APPROVAL <i>[Signature]</i>	DATE 9-23-68
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005	FRACTIONS 1/64 ANGLES 0° - 30'	ELECT. DES. DATE 9/20/68
MATERIAL	CHECKED <i>[Signature]</i>	DATE 9-22-68
FINISH	DRAWN <i>[Signature]</i>	DATE 9-22-68

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
LIST OF MATERIAL				
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
GEAR, SPUR (ANTI-BACKLASH) 48 PITCH, 1/4 BORE, .104 FACE				
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE	
B	82679	GR 236	Ø	
SCALE			SHEET	OF

TMC CODE	NO. TEETH	P.D. +.000 -.001	P.D. +.000 -.002	ALUM GEARS CAT NO	STAINLESS GEARS CAT NO.
065	65	1.3541	1.396	P13-1-65	P16-1-65
070	70	1.4583	1.500	P13-1-70	P16-1-70
072	72	1.5000	1.542	P13-1-72	P16-1-72
075	75	1.5625	1.604	P13-1-75	P16-1-75
080	80	1.6667	1.708	P13-1-80	P16-1-80
084	84	1.7500	1.792	P13-1-84	P16-1-84
085	85	1.7708	1.812	P13-1-85	P16-1-85
090	90	1.8750	1.916	P13-1-90	P16-1-90
095	95	1.9791	2.021	P13-1-95	P16-1-95
096	96	2.0000	2.042	P13-1-96	P16-1-96
100	100	2.0833	2.125	P13-1-100	P16-1-100
105	105	2.1875	2.229	P13-1-105	P16-1-105
110	110	2.2916	2.333	P13-1-110	P16-1-110
115	115	2.3958	2.438	P13-1-115	P16-1-115
120	120	2.5000	2.541	P13-1-120	P16-1-120
125	125	2.6041	2.646	P13-1-125	P16-1-125
130	130	2.7083	2.750	P13-1-130	P16-1-130
132	132	2.7500	2.791	P13-1-132	P16-1-132

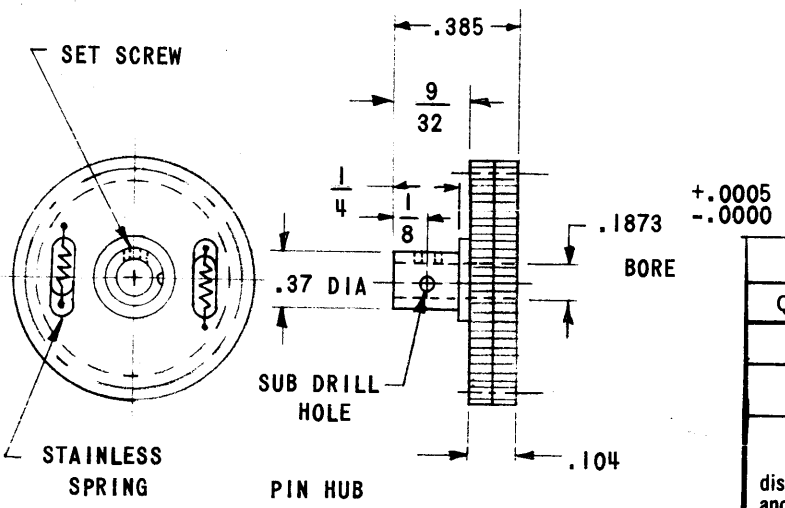
REVISIONS						
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD APPD
	X	EXPERIMENTAL RELEASE	9/10/68		C.V.	<i>[Signature]</i>
	Ø	ORIG. RELEASE FOR PROD	9-24-68	Ø	R.G.	<i>[Signature]</i>

TMC PART NUMBER SHALL BE IN THE FOLLOWING FORMAT:



SPECIFICATIONS

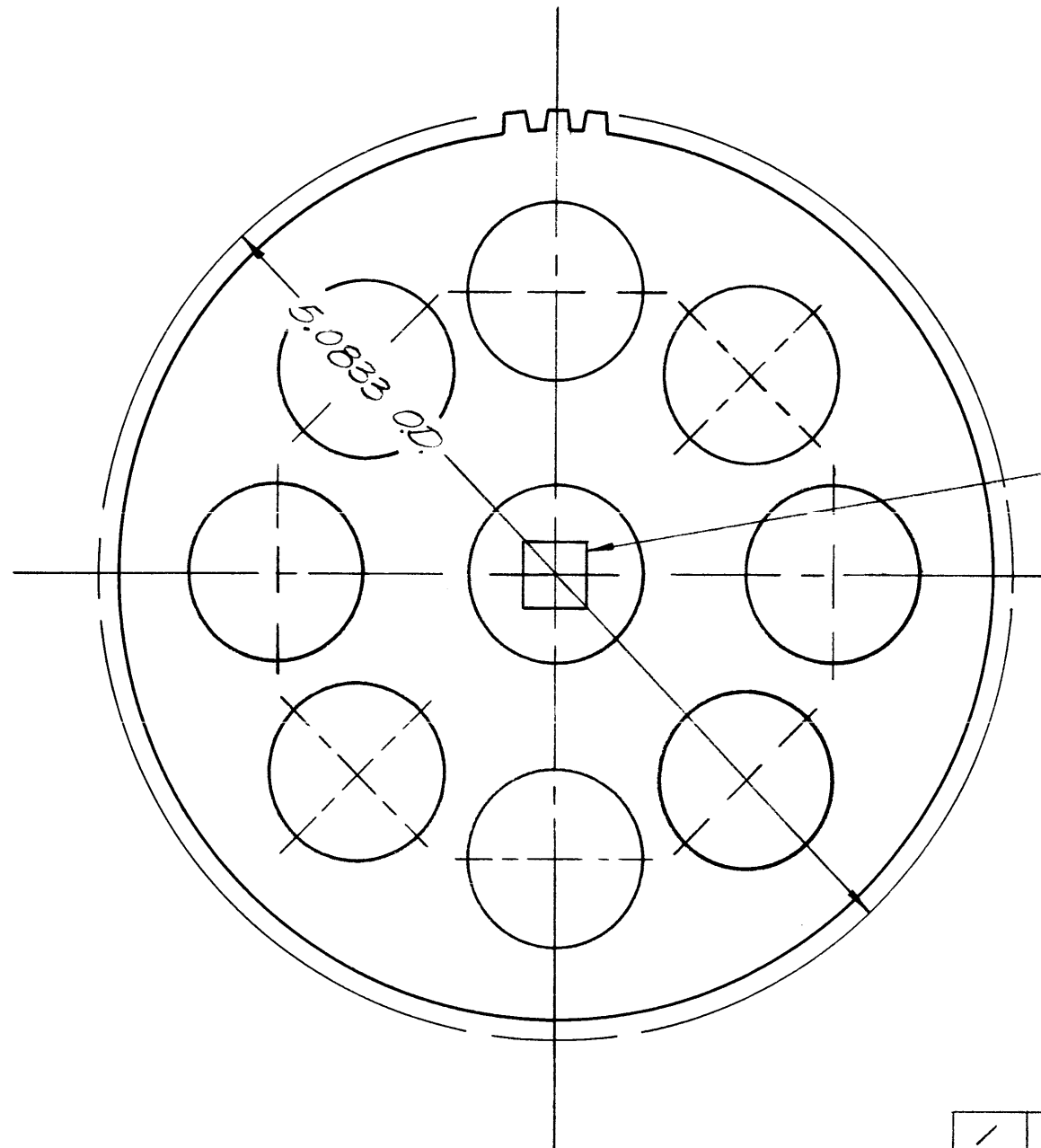
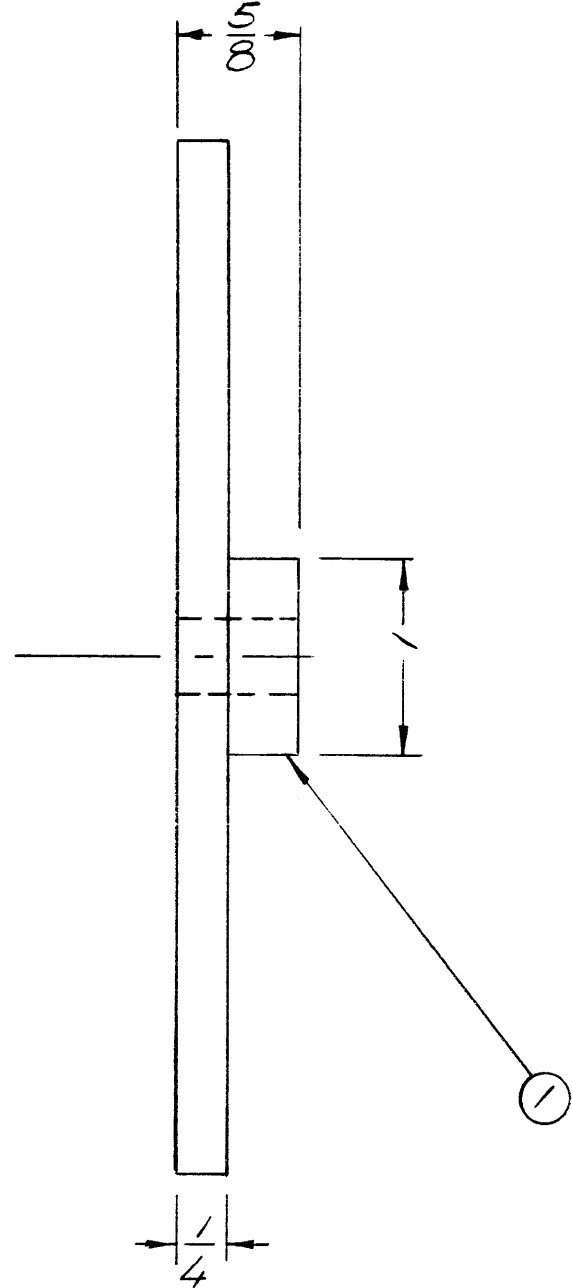
PRESSURE \angle : 20°
 CLASS OF GEAR: PRECISION I
 TOTAL COMPOSITE ERROR: .001
 TOOTH TO TOOTH COMPOSITE ERROR: .0004
 MATERIAL & FINISH (GEARS)
 ALUMINUM: 24ST, BLACK ANODIZED
 STAINLESS STEEL: #303, CLEAR PASSIVATED
 HUBS: #303, CLEAR PASSIVATED



QTY / UNIT	MODEL USED ON	ASS'Y NO.
	HFRR-4	
APPLICATION		
	CODE	S401-350
<p>NOTICE TO PERSONS RECEIVING THIS DRAWING THE TECHNICAL MATERIEL CORPORATION claims proprietary right in the material disclosed hereon. This drawing is issued in confidence for engineering information only and may not be reproduced or used to manufacture anything shown hereon without permission from THE TECHNICAL MATERIEL CORPORATION to the user. This drawing is loaned for mutual assistance and is subject to recall at any time.</p>		

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
LIST OF MATERIAL				
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
GEAR SPUR, ANTI-BACKLASH 4° PITCH, 3/16 BORE, .104 FACE				
SIZE	CODE IDENT. NO.	DWG NO.	GR 235	ISSUE
B	82679			Ø
SCALE		SHEET OF		

ZONE	LTR	DESCRIPTION	
	X	EXP RELEASE	12/5/69
	Ø	ORIGINAL RELEASE	1/4/70



.375 ^{+0.000}/_{-.001} SQ. BROACH

SPECIFICATIONS

PITCH - 24
 PRESSURE ANGLE 20°
 TEETH 120
 OUTSIDE DIAMETER 5.0833
 PITCH DIAMETER 5.000
 (TO BE MADE FROM GR 205-45)

1	1	GR 205-45	GEAR SPUR HUB	
REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
F. BUDGETTI				
LIST OF MATERIAL				
FINAL APPROVAL <i>FB</i>			DATE 12-70	
MECH. DES. <i>ALP</i>			DATE 1-12-70	
ELECT. DES.			DATE	
CHECKED			DATE	
DRAWN <i>EVANGELIS</i>			DATE 12/5/69	
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE	
B	82679	GR 237	Ø	
SCALE	SHEET		OF	

1	PALA-10K	AS145
QTY / UNIT	MODEL USED ON	ASS'Y NO.
APPLICATION		
CODE		

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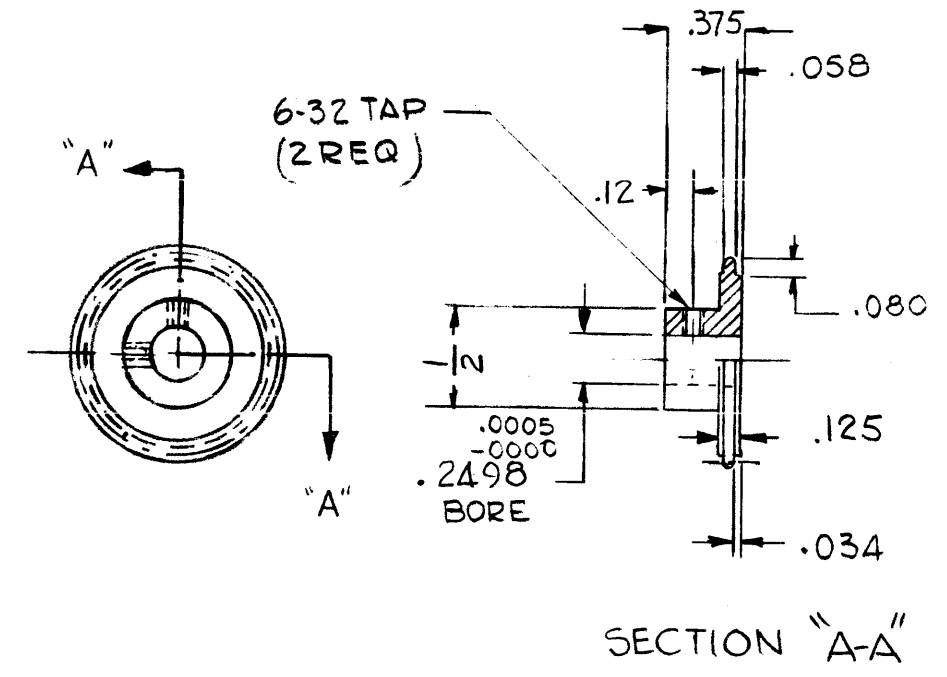
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES

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

MATERIAL **BRASS**

FINISH

5		4		3		2		1					
TMC PART NO.	MFG. STOCK No.	NO. OF TEETH	PITCH DIAMETER	OUTSIDE DIAMETER	MATERIAL	REVISIONS							
						E.M.N. NO.	DRAFT	CHKD	ZONE	LTR	DESCRIPTION	DATE	APPROVED
GR243-1	3MP26S-16	16	.800 ^{+0.00} _{-.002}	.862 ^{+0.00} _{-.004}	*303 STAINLESS STEEL		Q			Ø	FOR FINAL RELEASE FOR PRODUCTION	9/2/75	
GR243-2	3MP26S-20	20	1.000 ^{+0.00} _{-.002}	1.062 ^{+0.00} _{-.004}	*303 STAINLESS STEEL	21515	G.D.L.			A	TAP FOR 6-32 ADD #50 SUB DR DEL.	2-14-77	
GR243-3	3MP26S-32	32	1.600 ^{+0.00} _{-.002}	1.662 ^{+0.00} _{-.004}	*303 STAINLESS STEEL								
GR243-4	3MP26S-40	40	2.000 ^{+0.00} _{-.002}	2.062 ^{+0.00} _{-.004}	*303 STAINLESS STEEL								



STANDARD

QTY / UNIT	MODEL USED ON	ASS'Y NO.
401 - 453	CODE	

NOTICE TO PERSONS RECEIVING THIS DRAWING
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DECIMALS	FRACTIONS	TOLS.	ANGLES
.X ± .05	1/64		
.XX ± .01			0° - 30'
.XXX ± .005			

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
LIST OF MATERIAL				
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
GEAR, SPROCKET				

FINAL APPROVAL	DATE
<i>[Signature]</i>	9/2/75

MECH. DES.	DATE

ELECT. DES.	DATE

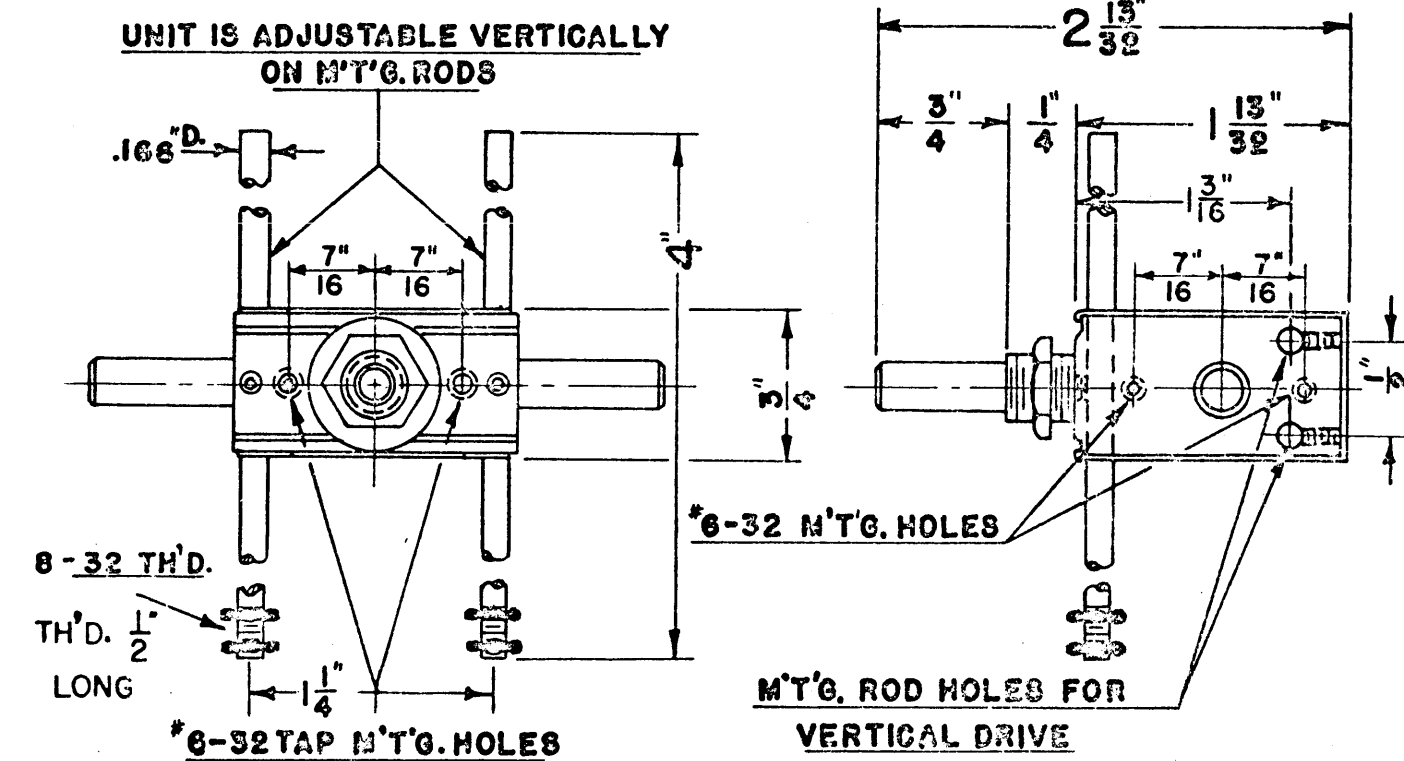
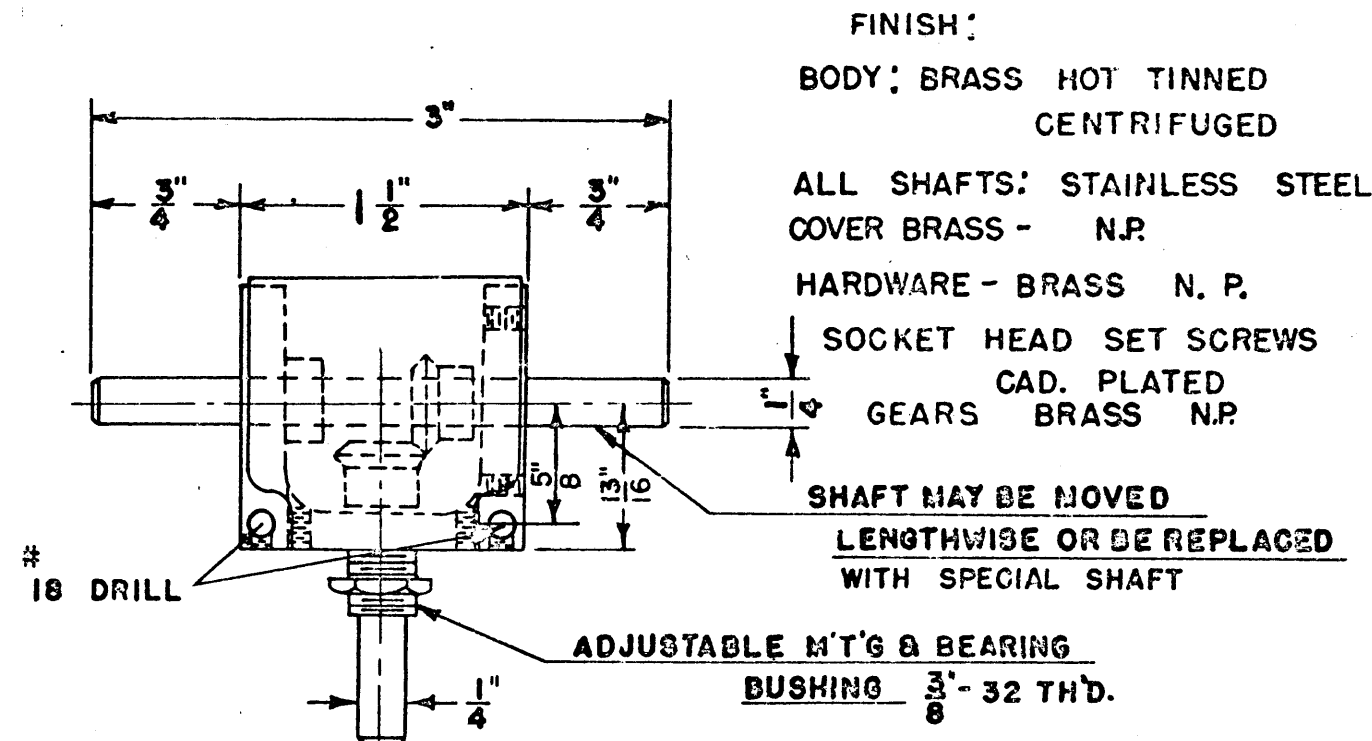
CHECKED	DATE
<i>[Signature]</i>	8-11-75

DRAWN	DATE
<i>G. De Jure</i>	8-11-75

SIZE	CODE IDENT. NO.	DWG NO.	ISSUE
B	82679	GR 243	A

SCALE 1:1 SHEET OF

REVISIONS						
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD APPD
	Ø	ORIG RELEASE FOR PROD	4-11-69		CV	J.D. H.D.



REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
LIST OF MATERIAL				
FINAL APPROVAL			THE TECHNICAL MATERIEL CORP.	
MECH. DES.			MAMARONECK, NEW YORK	
ELECT. DES.			RIGHT ANGLE DRIVE	
CHECKED				
DRAWN				
SIZE	B	CODE IDENT. NO.	82679	DWG NO.
SCALE			GR 8002	ISSUE
			SHEET	OF

2		AX 8081
2	SPT3K/VHF	AX 8080
QTY / UNIT	MODEL USED ON	ASS'Y NO.
APPLICATION		
	CODE	S401-101(10012)
NOTICE TO PERSONS RECEIVING THIS DRAWING THE TECHNICAL MATERIEL CORPORATION claims proprietary right in the material disclosed hereon. This drawing is issued in confidence for engineering information only and may not be reproduced or used to manufacture anything shown hereon without permission from THE TECHNICAL MATERIEL CORPORATION to the user. This drawing is loaned for mutual assistance and is subject to recall at any time.		

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

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

MATERIAL

FINISH

5

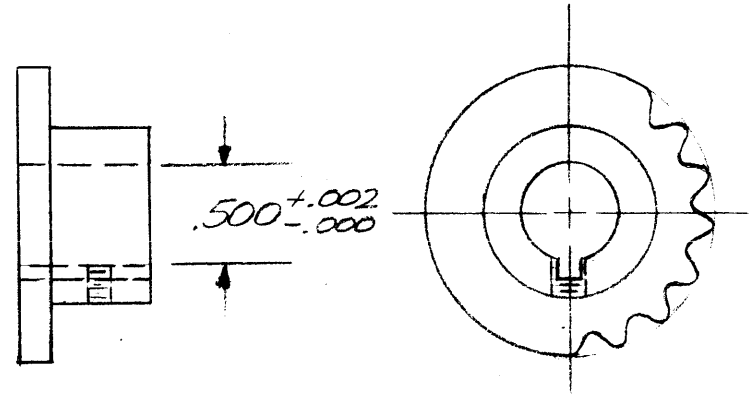
4

3

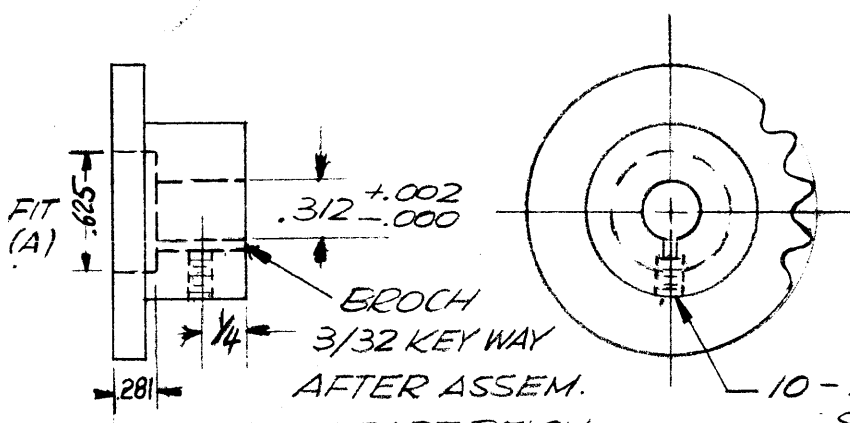
2

1

REVISIONS						
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFI	CHKD APPD
	Ø	ORIG REL FOR PROD	11/3/67	-H	GE	

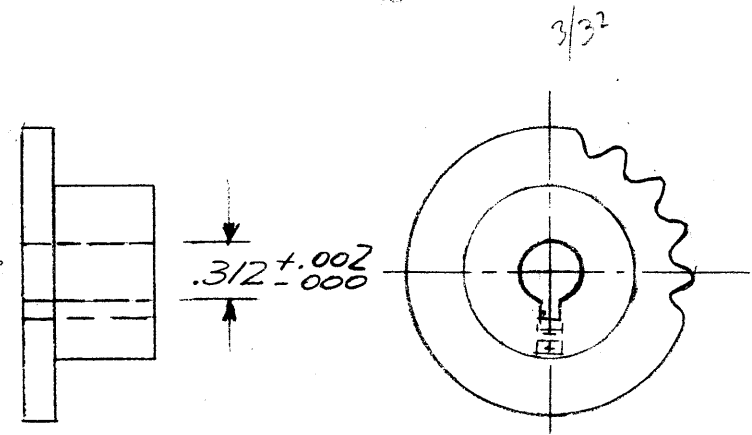


BORE HOLE TO $.500^{+.002}_{-.000}$ BROCH 1/8 KEYWAY
-4

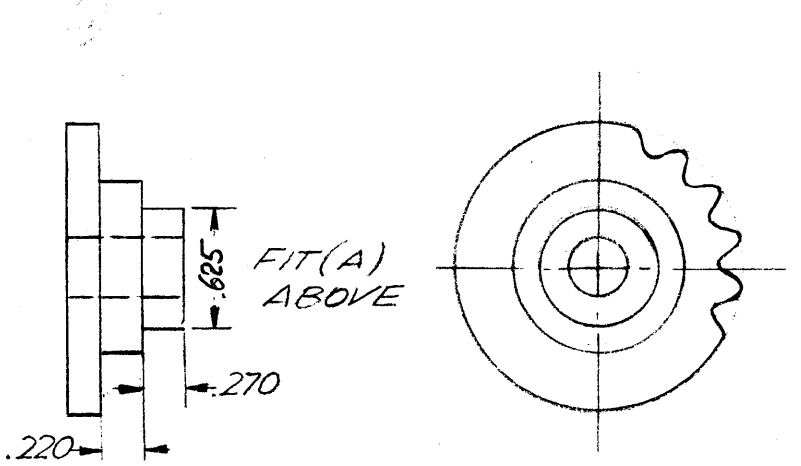


BROCH AFTER ASSEM. WITH PART BELOW
10-32 - 1/4 LONG SET SCREW

-2



BROCH FOR 3/32 KEY-WAY
-3



FIT(A) ABOVE

-1

NOTE:
USE S401-15 (# K 2517)

QTY / UNIT	MODEL USED ON	ASS'Y NO.
-4	2	SPT 3KVHF AX8080, AX8081
-3	4	SPT 3KVHF AX8080, AX8081
-2	2	SPT 3KVHF AX8080, AX8081
-1	2	SPT 3KVHF AX8080, AX8081

APPLICATION	
CODE	

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

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

MATERIAL PURCHASE

FINISH

REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
LIST OF MATERIAL				
FINAL APPROVAL		DATE	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
MECH. DES.		DATE		
ELECT. DES.		DATE		
CHECKED		DATE	SPROCKET WHEEL	
DRAWN		DATE		
SIZE	CODE IDENT. NO.	DWG NO.	ISSUE	
B	82679	GR8001	Ø	
SCALE		SHEET 1 OF 1		