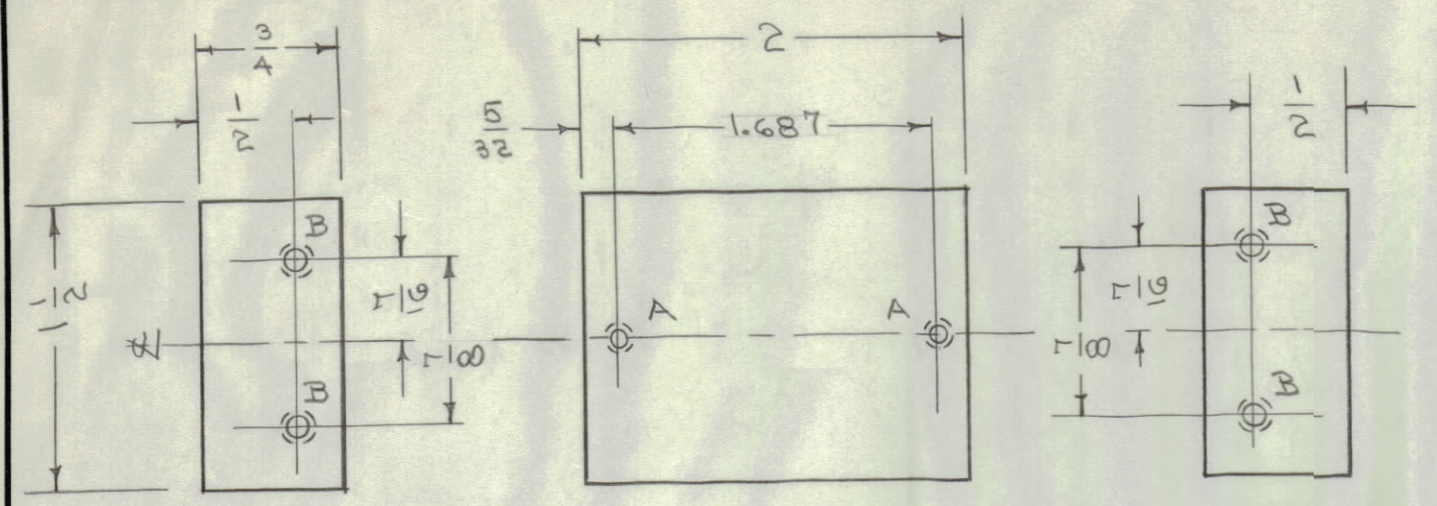
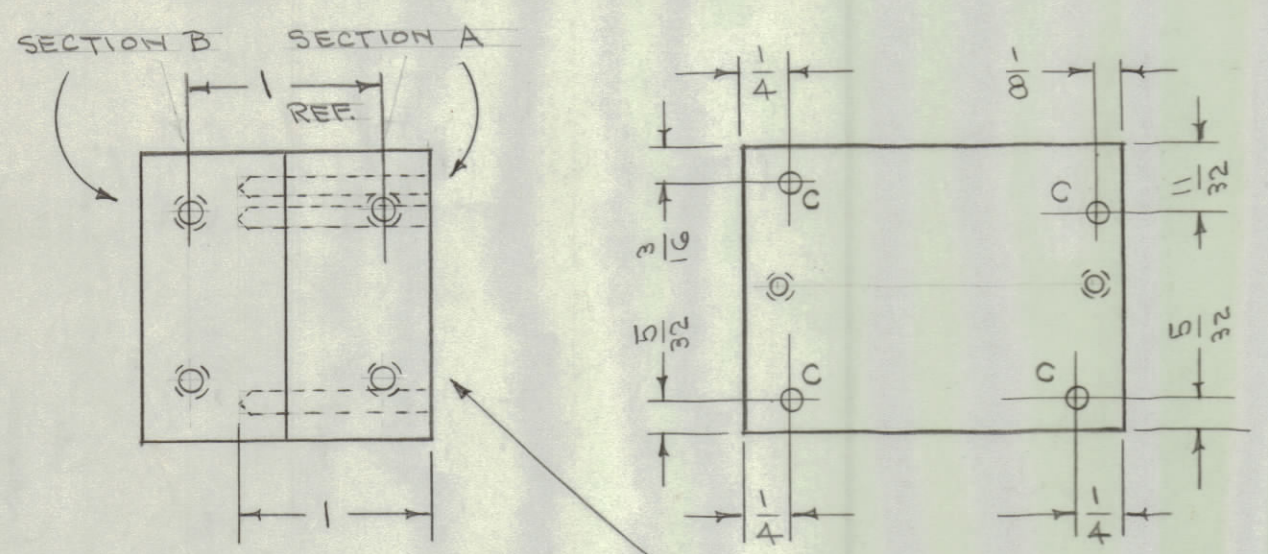


IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.
 MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

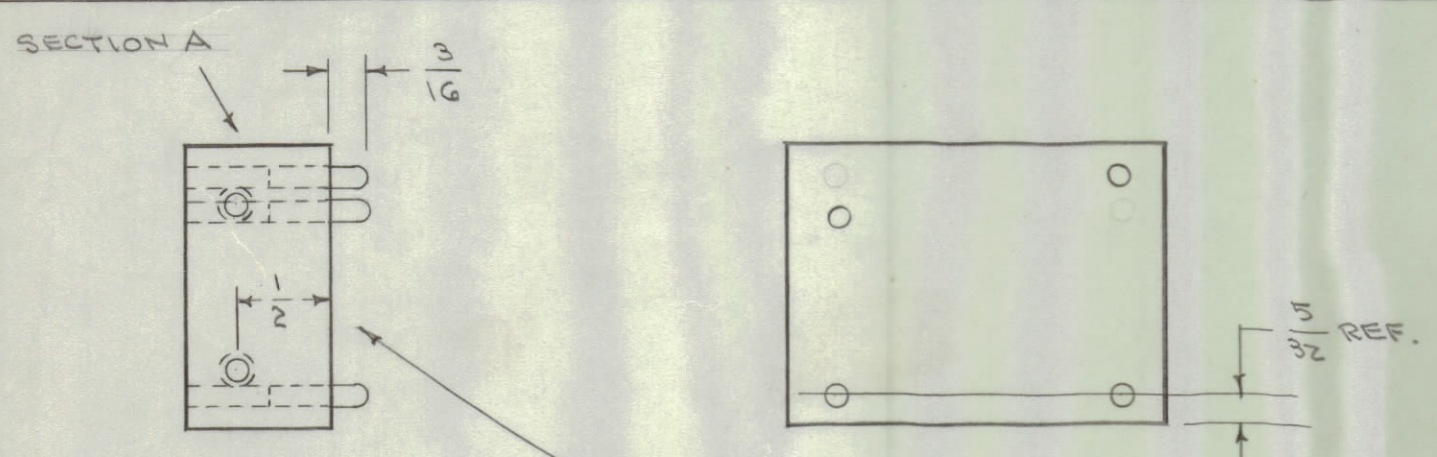
A- DRILL & TAP 6-32 X 1/4 DEEP. 2 REQ.
 B- DRILL & TAP 8-32 X 3/8 DEEP. 4 REQ.



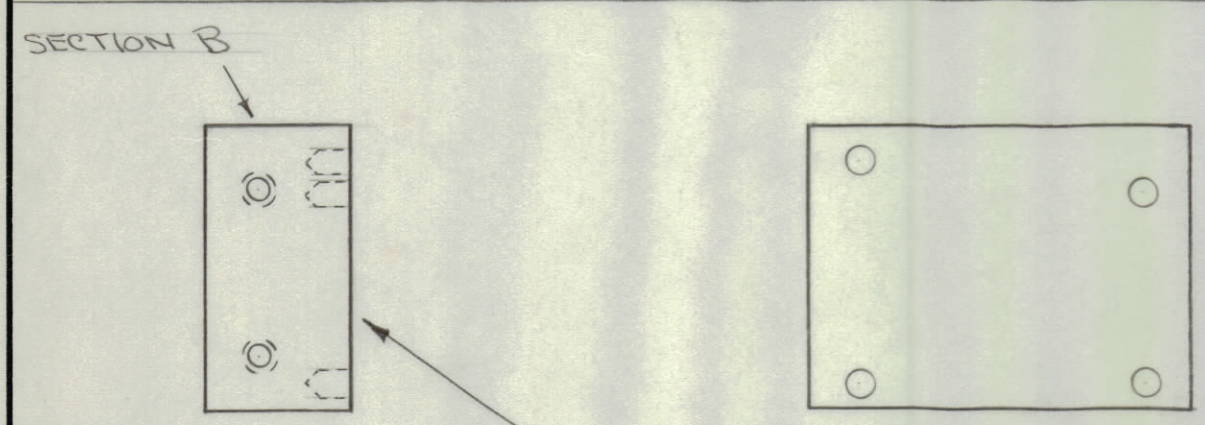
STEP 1
 2 PCS. REQ. PER UNIT.



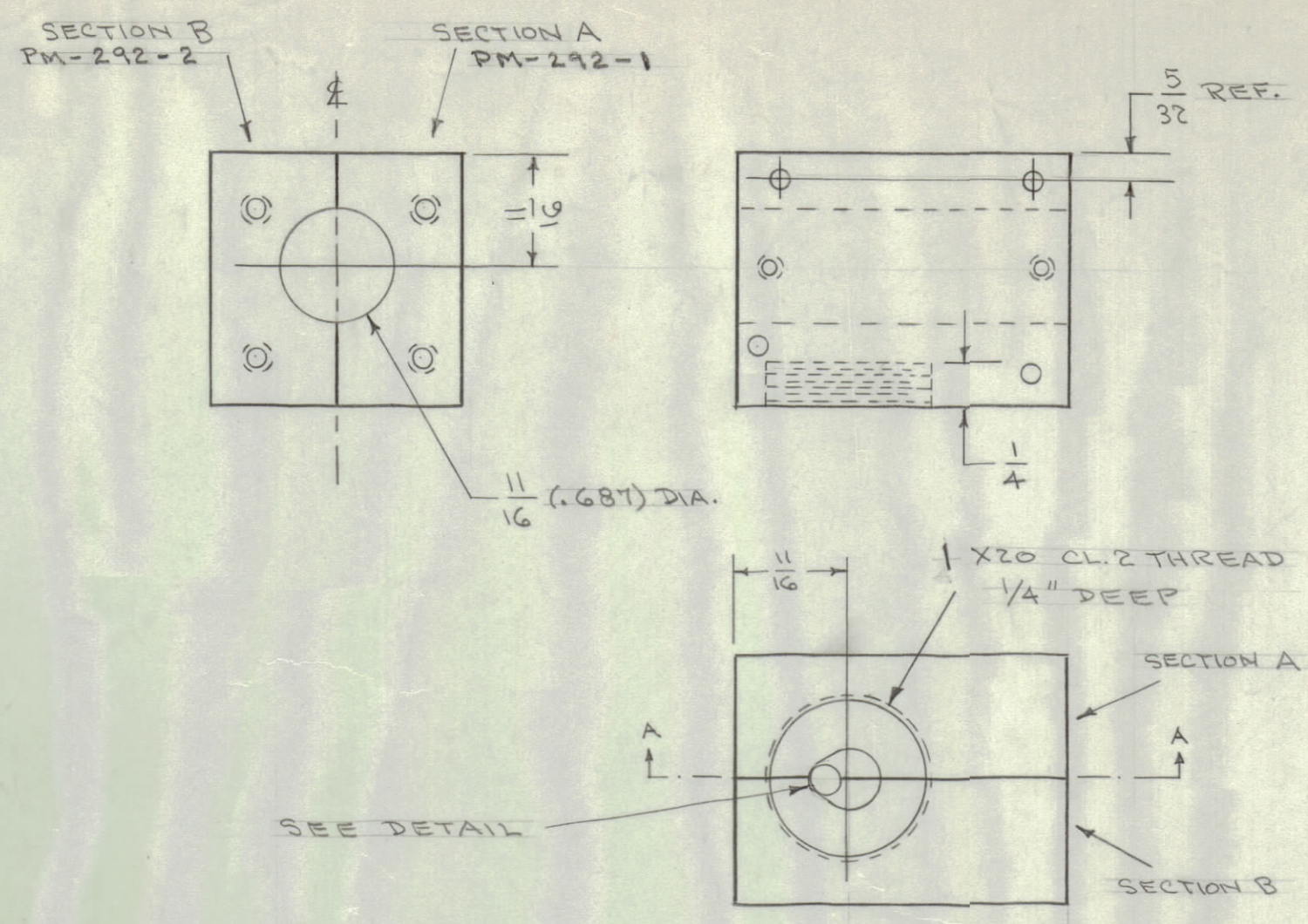
STEP 2
 CLAMP TWO PIECES IN POSITION SHOWN. DRILL A "C" HOLES 1 INCH DEEP FOR PRESS FIT OF 1/8 DRILL ROD (SEE DWG. PN-110).



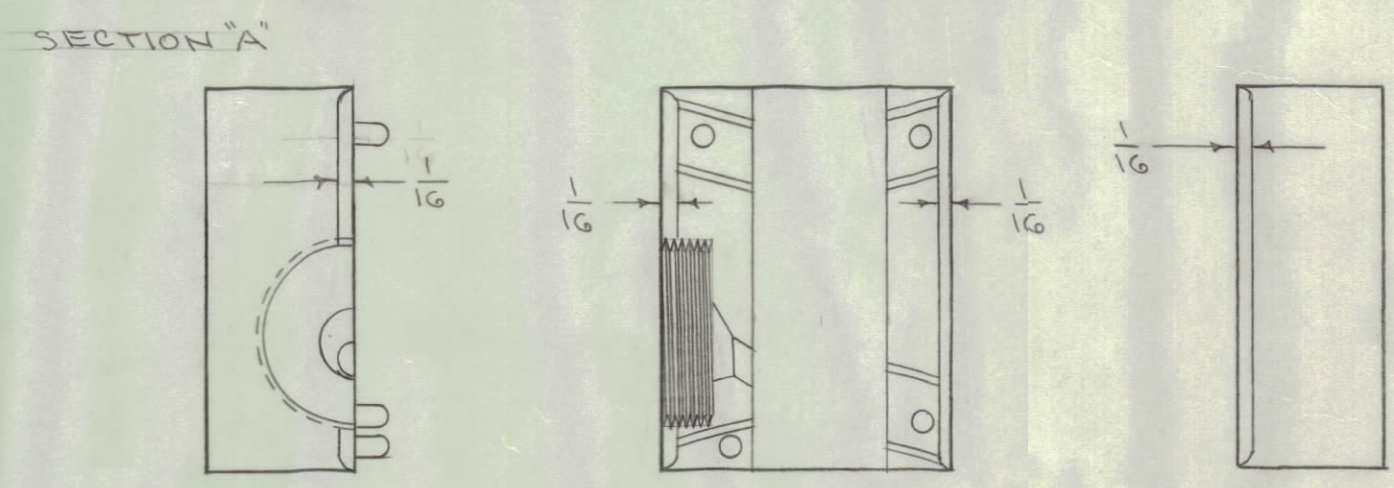
STEP 3
 WITH SECTION "A" IN POSITION SHOWN, PRESS PINS (PN-110) INTO "C" HOLES TO 3/16 DIMENSION SHOWN. 4 PINS REQ'D.



STEP 4
 WITH SECTION "B" IN POSITION SHOWN, DRILL OUT 4 "C" HOLES FOR SLIP FIT OF PN-110.

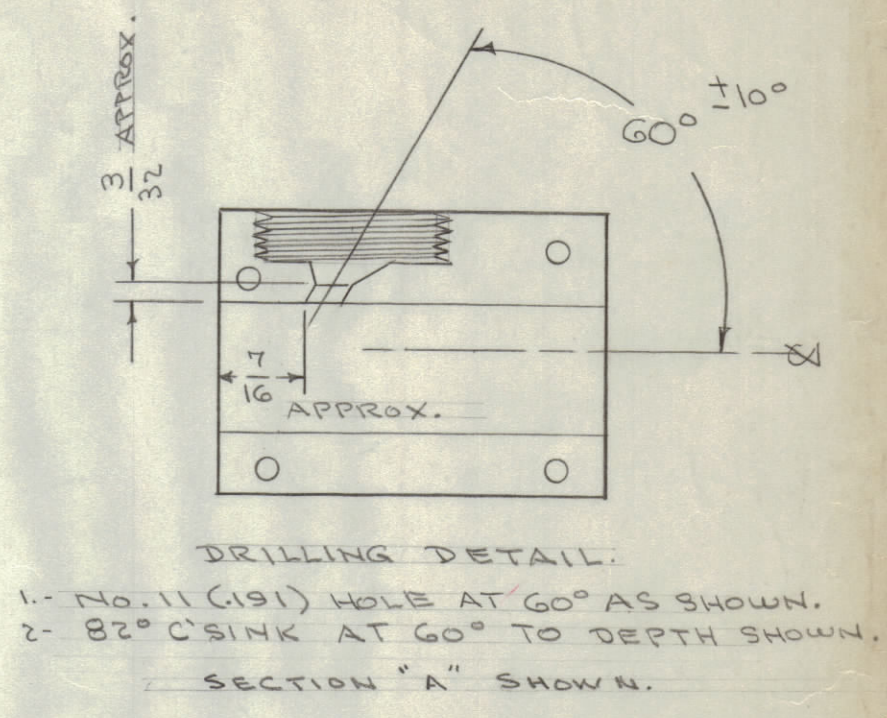


STEP 5
 CLAMP SECTIONS A & B TOGETHER. DRILL 11/16 HOLE AS SHOWN. DRILL & TAP 1X20 AS SHOWN. DRILL FEEDER HOLE AS SHOWN IN DETAIL.



STEP 6
 V SLOTS 1/32 DEEP. 7 REQ.
 SLOTS TO BE APPROX. IN POSITIONS SHOWN.

NOTE: SECTIONS A & B TO BE SHIPPED AND STOCKED AS MATCHING PAIRS.



DRILLING DETAIL:
 1- No. 11 (.191) HOLE AT 60° AS SHOWN.
 2- 82° C'SINK AT 60° TO DEPTH SHOWN.
 SECTION "A" SHOWN.

PM-292

ISSUE	ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES		SCALE:					
ALL OTHERS	DEC. DIM. ± .005 FRAC. DIM. ± 1/64 ANGULAR DIM. ±	DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.					

SEE NOTE	MODEL	PROJECT NO.	ASS'Y. NO.	DATE
KS-85-X	J-227	A-502	12-30-54	

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
3/4 X 1 1/2		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
BRASS	#	CENTER SECTION, MOLD, DIELECTRIC	
HALF HARD			
TYPE & TEMPER			
HEAT TREAT. SPEC.			
FINISH & SPEC. NO.			