

TMC SPECIFICATION

NO. 1014

REV:

0A

COMPILED:

RJE

CHECKED:

J. Ector

APPD:

JEC

SHEET 1

OF 4

TITLE:

MMH
2/22/65

typed by vab 9-15-65

I N S T R U C T I O N S

FOR

CONVERSION OF HFA-1 TO HFAR-1A

(KIT-222A)

CAUTION: DO NOT ROTATE ANY LEDEX SHAFTS UNTIL ENTIRE INSTRUCTIONS
HEREIN CONTAINED ARE REVIEWED.

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SHEET 2 OF 4

TITLE: INSTRUCTION FOR THE CONVERSION OF HFA-1 TO HFAR-1A (KIT-222A)

typed by vab 9-15-65

I. PURPOSE:

To provide modification instructions for conversion of an HFA-1 to an HFAR-1A. This modification will be referred to as KIT-222A.

II. MATERIALS SUPPLIED:

<u>ITEM</u>	<u>QTY.</u>	<u>PART NO.</u>	<u>DESIGNATION</u>
1	1	AX-541	Auto-Ass'y, Chan "B"
2	1	AX-600	Auto-Ass'y, Chan "A"
3	2	MC-130	Cplg. Rigid
4	2	MC-131-1	Cplg. Rigid
5	1	NP362-30	Plate Identification
6	2	PM691RF8.500S	Shaft Ext.
7	2	PN59-062-8	Pin Spring
8	8	SCBPO832BN5	Scr. Mach.
9	8	LWEO8MRN	Wash, LK. Ext.
10	8	NTHO832BN10	Nut, Plain, Hex
11	1	CA-1093-14.00	Cable Ass'y S.P.

III. PROCEDURE:

1. Place template TP-138 against rear flange (MS-2820) so pilot plugs engage with "P" detail holes. Use MS2820 print to locate these holes on the rear of HFA-1.
2. Using tool TP-133, center punch through all 1/8" Dia. holes on template.

NOTE: DO NOT DRILL THROUGH TEMPLATE.

3. With a 1/8" Dia. drill bit, pilot all center punch marks.
4. All "W" holes shown on MS2820 as then opened up to 13/64" to accomodate for 8-32 hardware.

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5. Next, 3/8" holes on rear of chassis wrap-around are to be opened to 5/8" to accept shaft coupling MC-131. This is accomplished by centering 5/8" round style "R" punch in 3/8 hole, as per instructions accompanying TP113. Cutout to be orientated as per MS2820.
6. All holes necessary in rear panel have been accomplished so as to mount Ledex brackets to their respective channel detection switches.
7. On each Ledex Assembly mount a MC131 multi-jaw coupling on to their shafts to an approximate depth of 3/8", and fasten set screw to flat surface.
8. CAUTION: BOTH LEDEX ASSEMBLIES HAVE BEEN PREALIGNED AT THE FACTORY, AND EXTREME CARE MUST BE EXERCISED TO AVOID MOVING THE SHAFT.
9. Place both detection switches in the "AM" position.
10. Place AX-600 orientated with connector plugs facing upward over Channel "A" detection "W" detail mounting holes, as indicated on MS2820. Fasten in place with 8-32 mounting hardware.
11. With PM691RF8-5005 extension shaft, insert into MC-130 rigid coupling to a depth of 7/16", tighten set screw, then drill through pilot hole with #52 drill. Then insert pin PN59-062-8.
12. Then, repeat steps 9 thru 11, mounting AX-541 over Channel "B" detection "W" detail mounting holes.
13. Place MC-131 multi-jaw coupling over each round shaft and allow to

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remain free. Then fasten broached end to each detection selection switch shaft. Next, mate extension shaft multi-jaw coupling, by sliding free shaft coupling forward to mate snugly with ledex drive unit assembly.

14. Connect CA-1093-14 cable assembly between J7014-1 (female side) channel "A" and J7014-4 (male side) channel "B".

This completes the conversion of an HFA-1 to an HFAR-1A.

IV. TOOLS REQUIRED:

- One take off tool (or transfer punch) TP133
- One #52 High Speed Drill
- One 1/8" High Speed Drill
- One 13/64" High Speed Drill
- One 5/8" Round style "R" punch (TP113RO-5/8)
- One MS2820 Chassis, Elec, Print
- One TP-138 Template Print
- One TP-138 Template

REVISION SHEET

THE TECHNICAL MATERIEL CORP.
MAMARONECK NEW YORK

S1014



LIST NO.

DATE	REV.	SHEET	EMN #	DESCRIPTION	APP.
9/21/65		1 of 4	4	O=ORIGINAL RELEASE FOR PRODUCTION.	
7/26/66	A	2,4	16618	Revised per EMN	