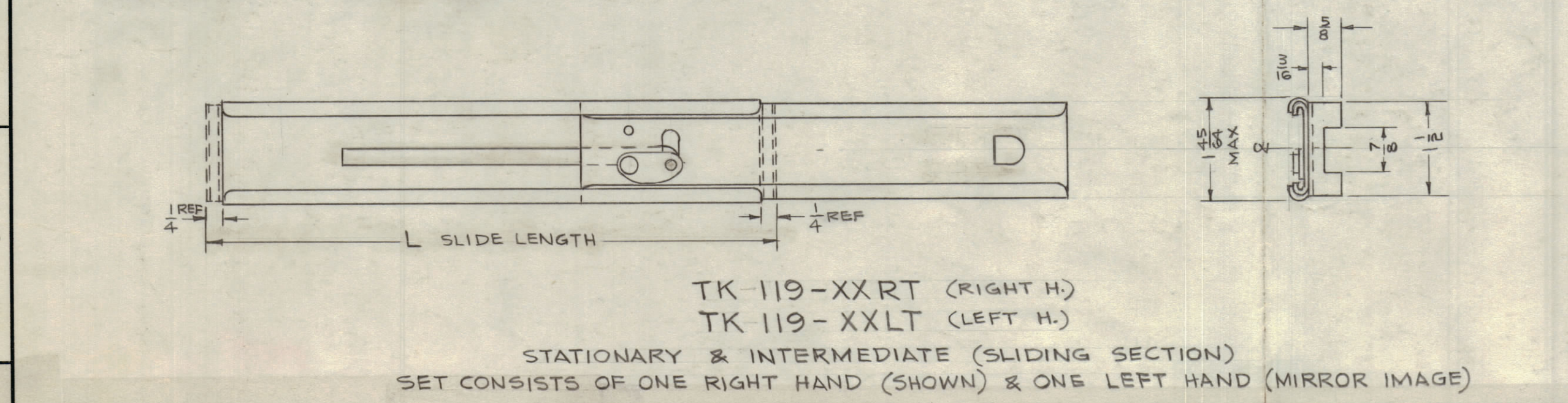
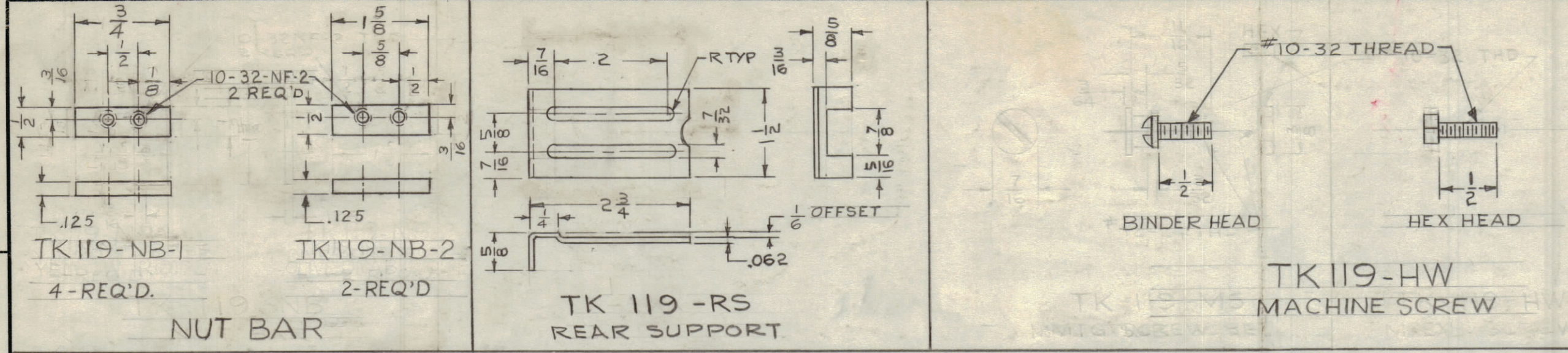


REVISIONS						
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD
#	X	EXPERIMENTAL RELEASE	4-7-64	X	A.M.	
#	X1	NUT BAR DET. REV., SPOT WELD WAS 2 RIVET HOLES, 12 HEX SCREWS WERE 8 MACH SCREWS.	5/1/64	X1	A.M.	
#	X2	SPECIFICATIONS UPDATED; TK119-MS, MOUNTING SCREW DELETED; BINDER HD. ADD.	6/9/64	X2	A.M.	(A)
Ø		ORIGINAL RELEASE FOR PROD	12/5/66	Ø		



SPECIFICATIONS

MATERIAL: TK119-XXRT & LT, TK119-XXRC & LC, TK119-RS & TK119-NB-1, TK119NB-2 ARE TEMPER COLD ROLLED STEEL (PER SPEC QQ-S-636) TK-119-HW ARE CARBON STEEL. SPRINGS, RIVETS, PINS, & STOPS ARE 18-8 STAINLESS STEEL.

FINISH: TK119-XXRT & LT, TK119-XXRC & LC, TK119-NB-1&NB-2, TK119-RS, ARE ZINC PLATED (PER MIL QQ-Z-325), & OLIVE DRAB IRIDITE COATED. STAINLESS STEEL PARTS PASSIVATED.

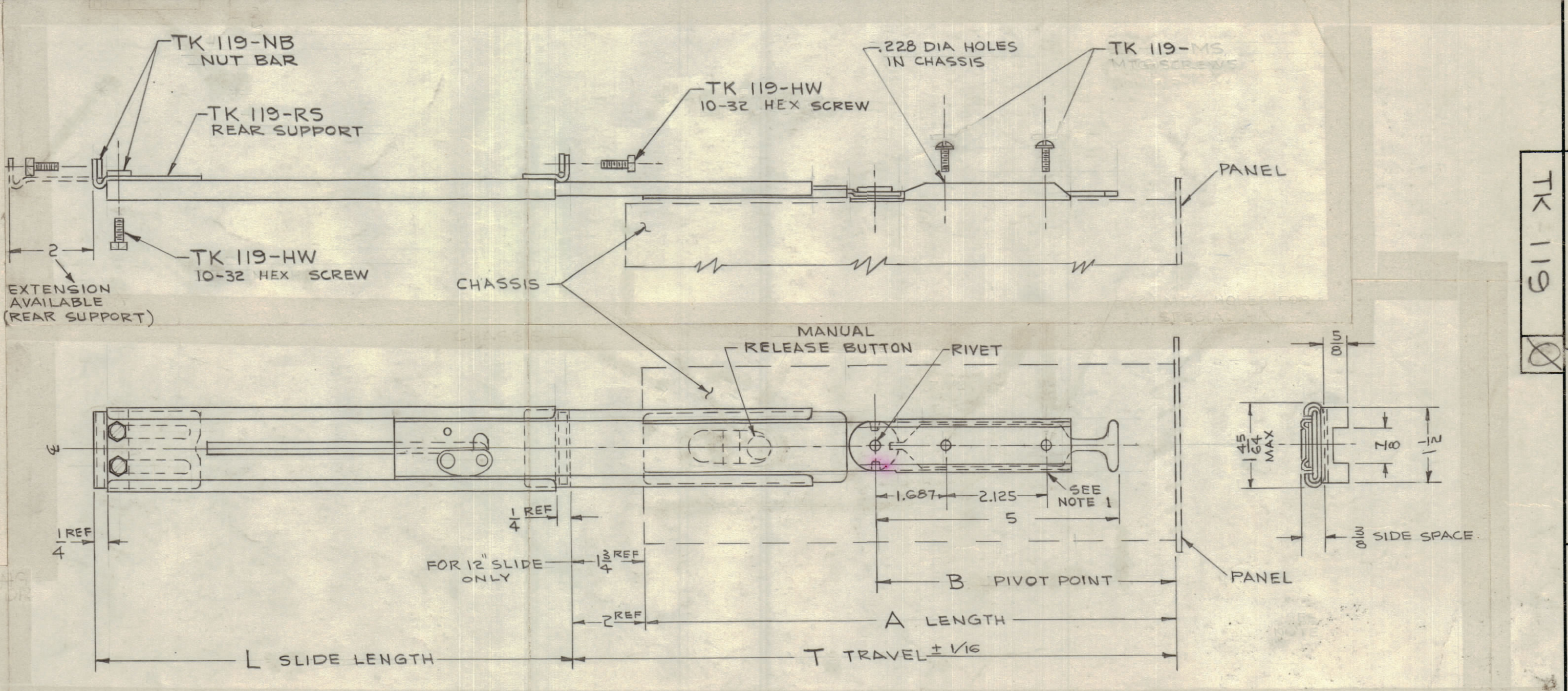
LUBRICATION: MOLYBDENUM DISULPHIDE WITH AN EPOXY BASE PER MIL-L-22273 IS BAKED ON AT 375° TO WITHSTAND TEMPERATURE OF -100° +500°F & PRESSURE LOADINGS OF MORE THAN 50M AT 25 F.P.M.

SALT SPRAY: MEETS OR EXCEEDS 100 HOURS 20% SALT FOG AT 95° TEMP.

LOAD RATING: 75 LBS/PAIR AT FULL EXTENSION, WITH 100% SAFETY FACTOR WITHOUT STRUCTURAL FAILURE.

TILT VARIATION: PIVOTS & LOCKS IN PLUS OR MINUS 90° TILTED POSITION.

MANUAL RELEASE BUTTON: TO REMOVE OR RETURN CHASSIS DEPRESS BUTTON.



FOR COMPLETE SET SET TMC PART NO. SHALL BE IN THE FOLLOWING FORM:

TK 119 - XX

TMC PART NO. MODEL LENGTH NO. (SEE CHART)

TMC PURCH. & PART NO.	MFRS PART NO.	MODEL LENGTH NO.	DIMENSIONS				REQUIRED TMC PART NOS PER EACH TRACK & SLIDE SET							
			A	B	L	T	STATIONARY & INTERMEDIATE	CHASSIS SECTION	REAR SUPPORT	NUT BAR	BINDER SCREW	HEX SCREW		
TK 119-18	55-168-D-18	18	17	8 1/2	17 7/8	19	TK 119-18RT	TK 119-18LT	TK 119-18RC	TK 119-18LC	TK 119-R5	TK 119-NB	TK 119-HW	TK 119-HW

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
I. JOHNSON				
LIST OF MATERIAL				
MATERIAL			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
FINISH			TITLE TRACK AND SLIDE SET PLUS OR MINUS 90° TILT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES			DRAWN	DATE
DECIMALS X ± .05 .XX ± .01 .XXX ± .005			CHECKED	DATE
FRACTIONS ± 1/64 ANGLES ± 0° 30'			ELECT. DES.	DATE
TOLERANCES			MECH. DES.	DATE
			SHEET	REV. LTR.

NOTES:

- WHEN MOUNTING CHASSIS TO SLIDE, DRILL HOLES IN CHASSIS .025 ABOVE CENTER LINE OF SLIDE
- HARDWARE FURNISHED BY MANUFACTURER.

1 RAK-31A		
Q'TY./UNIT	MODEL USED ON	ASSY. NO.
SCALE NONE	CODE C	5401-209
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