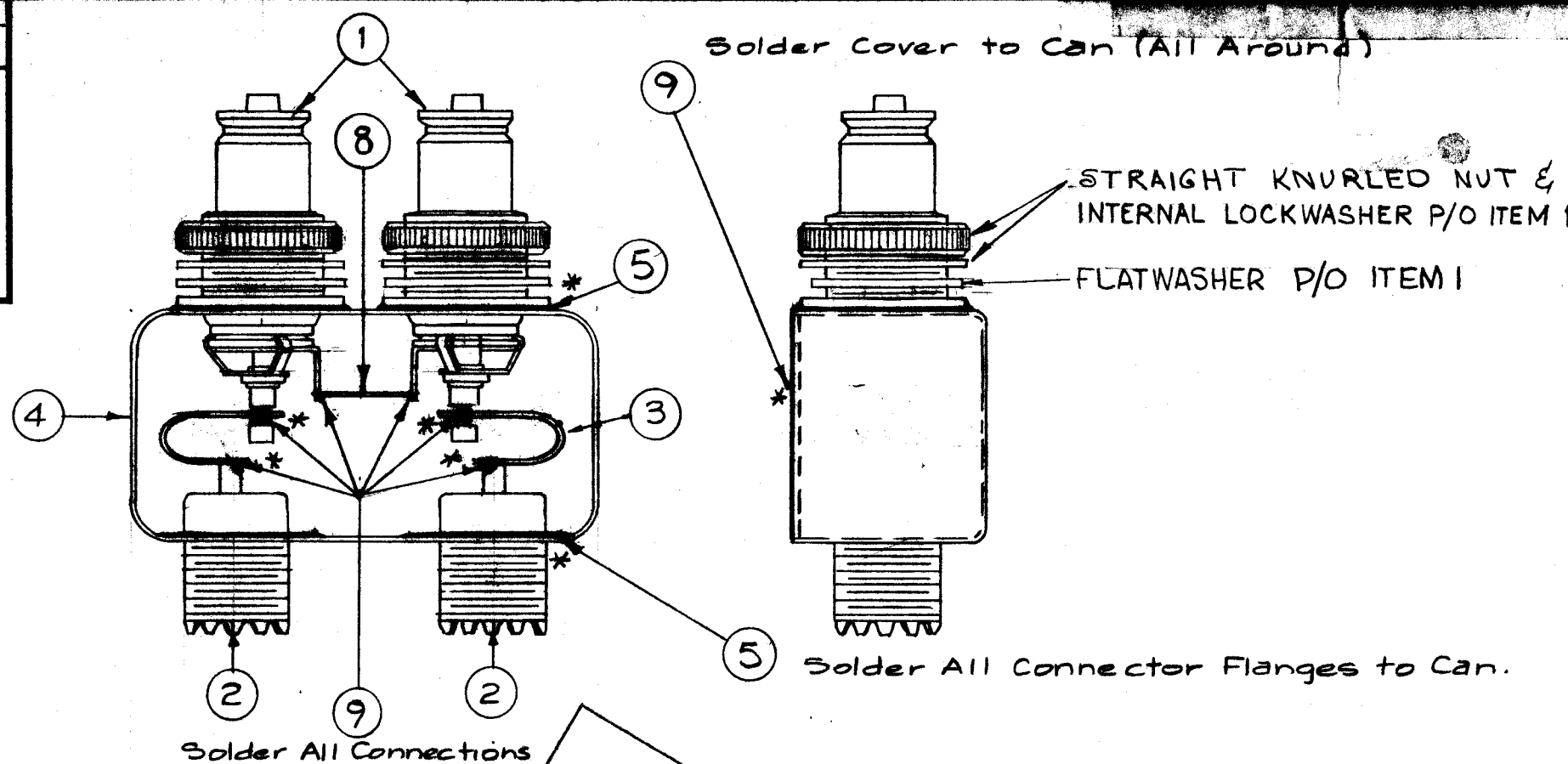


A-1489 H



Solder Cover to Can (All Around)

STRAIGHT KNURLED NUT & INTERNAL LOCKWASHER P/O ITEM 1

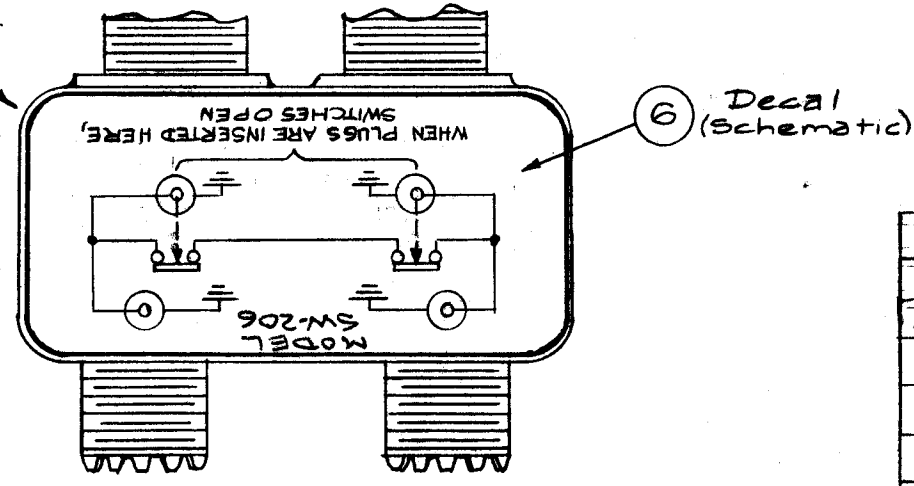
FLATWASHER P/O ITEM 1

Solder All Connector Flanges to Can.

Solder All Connections

Place Schematic on Cover as Shown

NAMEPLATE NP-488



NOTES:

1. INDUCTION HEATING EQUIPMENT SET AT:
 AMPERES -
 SECONDS -
2. USE ITEM (5) FOR MOUNTING ITEM (1) AND (2).
3. USE ITEM (9) FOR MOUNTING ITEM (3), (8) AND FOR SEALING COVER ITEM (4).
4. STRAP ITEM (3) MUST BE KEPT AS FLEXIBLE AS POSSIBLE; DO NOT ALLOW SOLDER TO RUN OVER STRAP. LAY STRAP IN SO THAT IT CANNOT TOUCH CAN OR CONNECTOR BODIES.
5. FINISH AS FOLLOWS:
 S-114 - ZINC CHROMATE PRIMER
 S-115 - T M C SMOOTH GRAY ENAMEL
 (DO NOT PAINT CONNECTOR BODIES.)
6. AFFIX ITEM (6) TO FRONT AS SHOWN.
7. AFFIX ITEM (7) TO REAR AS SHOWN.
8. * DENOTES SOLDER ALL AROUND.
9. SW-206 REPLACES 2 RF JACK SWITCHES, NAVY TYPE NT-491388.

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
H		IT 2 WAS 33214. IT 4 WAS BX157. IT 0 WAS BS106-2. IT 5 WAS BS106-4	4-19-64	16102	WAW	JCB	MM
G	3	PICTORIAL CLARIFIED	2-28-63	8214	JCB	JCB	JCB
F	2	ITEM (5) WAS BS-106-1					
E	1	ITEM (9) & NOTES ADDED					
D	1	ITEM (7) WAS NP-224	12-18-62	7880	JCB	JCB	JCB
C	2	FLATWASHERS ADDED	4-26-62	6649	JCB	JCB	JCB
B	1	ITEM (2) WAS SO-239A					
A	1	Item 5 Was BS-100	5-3-61	4808	JCB	JCB	JCB
	1	ITEM 8 ADDED	4-10-61	4620	JCB	JCB	JCB
	4	QDS added to Item 1					
	3	foil Cal added to Item 6 & 7	3/30/61	4570	JCB	JCB	JCB
	2	Item 2 was SO-239					
	1	Item 3 was WL-105-1					
	1	IT 1 WAS 33-150; IT 2 WAS LD-375	5/19/58	1	JCB	JCB	JCB

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
X 9	BS-100	SOLDER, TIN ALLOY	
I 8	WL-100-5	WIRE, BUSS-BAR #18	
I 7	NP-488	NAMEPLATE (foil Cal.)	
I 6	NP-225-1	Schematic Diagram (foil Cal.)	
X 5	BS-100-2	Solder, TIN ALLOY	
I 4	BX-157-1	Case & Cover	
I 3	MS-1769	STRAP, CONNECTING	
I 2	JJ-218	RECEPTACLE, BULKHEAD UHF SERIES	
I 1	JJ-162	Connector, Receptacle, QDS	

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINAL ASS'Y.			
SW-206			
MATERIAL			
TYPE & TEMPER			
HEAT TREAT. SPEC.			
DRAWN		CHECKED	
DATE		FINAL APPROVAL	
USED ON		ELEC. DES. APP. MECH. DES. APP.	

TOLERANCES: DEC. DIM. ±, FRAC. DIM. ±, ANGULAR DIM. ±

SCALE: MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

REQ. PER UNIT	SW-206	PROJECT NO.	SPP-3	DATE	12-23-57
	MODEL		USED ON		

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