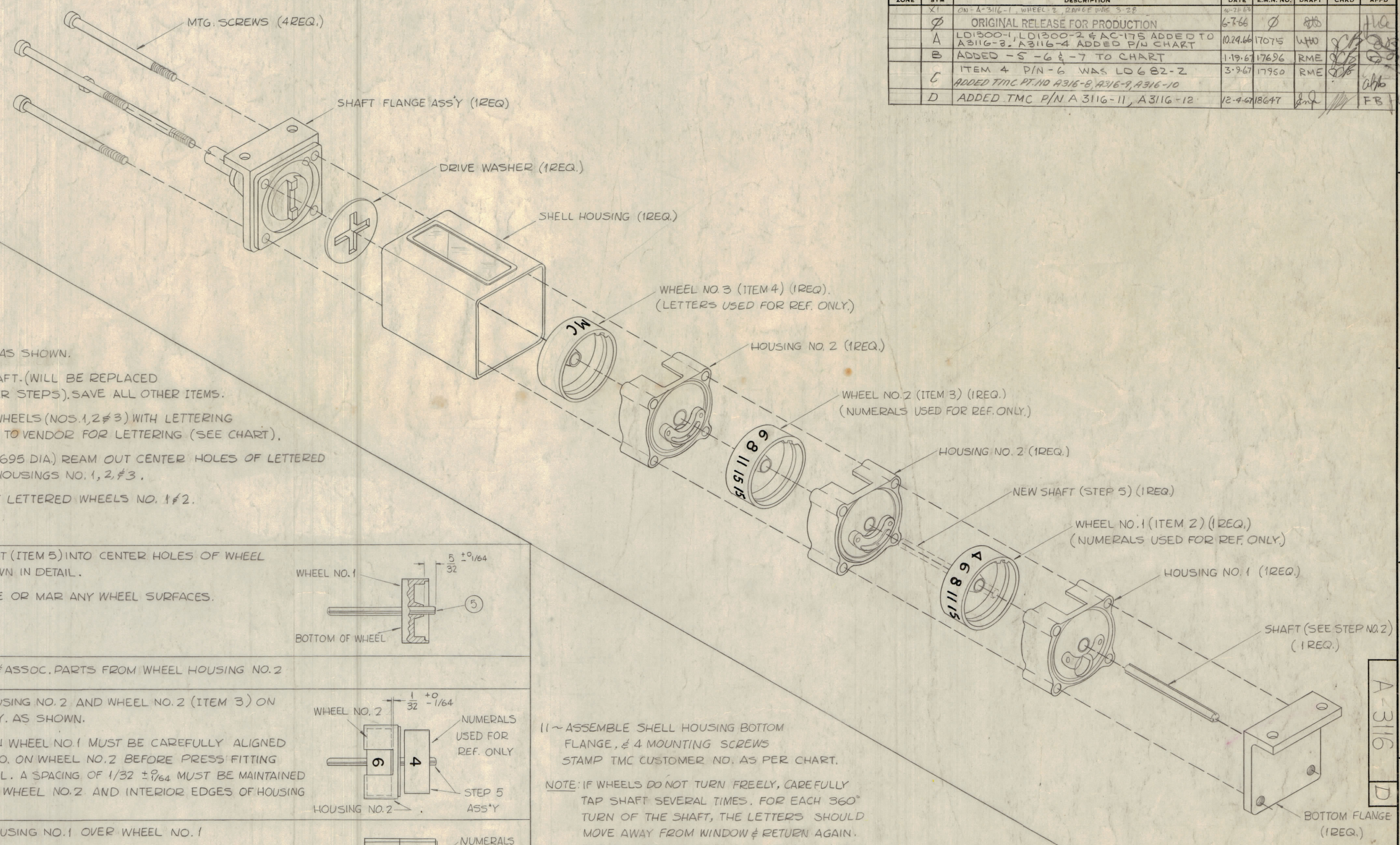


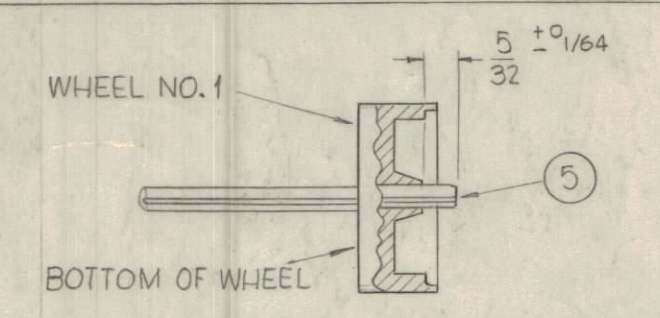
11		10		9		8		7		6		5		4		3		2		1	
TMC PART NO.	ITEM 1	ITEM 2 WHEEL #1	ITEM 3 WHEEL #2	ITEM 4 WHEEL #3	ITEM 5	TMC CUSTOMER NO.															
A 3116-1	CY 106	LD 1188-1	2-22	LD 1188-2	5-28	LD 617	MC	PN 115-1	AC-173												
A 3116-2	CY 106	LD 1189-1	2-22	LD 1189-2	3-28	LD 617	MC	PN 115-1	AC-174												
A 3116-3	CY 106	LD 1300-1	2-24	LD 1300-2	3-28	LD 617	MC	PN 115-1	AC-175												
A 3116-4	CY 106	LD 978-1	2-24	LD 978-2	3-28	LD 617	MC	PN 115-1	AC-138												
A 3116-5	CY 106	LD 980-1	2-20	LD 980-2	2-28	LD 980-3	MC	PN 115-1	AC-139												
A 3116-6	CY 106	LD 682-1	—	LD 682-2	—	LD 682-3	—	PN 115-1	AC-108												
A 3116-7	CY 106	LD 767-1	2-24	LD 767-2	3-28	LD 617	MC	PN 115-1	AC-124												
A 3116-8	CY 106	LD 615	4-24	LD 616	6-28	LD 617	MC	PN 115-1	AC-107												
A 3116-9	CY 106	LD 780-1	2-20	LD 780-2	12-30	LD 780-3	MC	PN 115-1	AC-133												
A 3116-10	CY 106	LD 779-1	2-24	LD 779-2	3-30	LD 779-3	MC	PN 115-1	AC-134												
A 3116-11	CY 106	LD 1300-1	2-24	LD 1300-3	3-30	LD 617	MC	PN 115-1	AC-175-2												
A 3116-12	CY 106	LD 767-1	2-24	LD 767-3	3-30	LD 617	MC	PN 115-1	AC-124-2												

REVISIONS										
ZONE	SYM	DESCRIPTION	DATE	E.M. NO.	DRAFT	CHKD	APPD			
X1		ON A-3116-1, WHEEL 3, PART NO. 3-28	4-28-64							
	Ø	ORIGINAL RELEASE FOR PRODUCTION	6-7-66							
A		LD 1300-1, LD 1300-2 & AC-175 ADDED TO A 3116-2, A 3116-4 ADDED P/U CHART	10-24-66	17075	WHD					
B		ADDED -5 -6 & -7 TO CHART	1-19-67	17696	RME					
C		ITEM 4 P/N-6 WAS LD 682-2	3-9-67	17960	RME					
D		ADDED TMC P/N A 3116-5, A 3116-9, A 3116-10	12-4-68	18647						



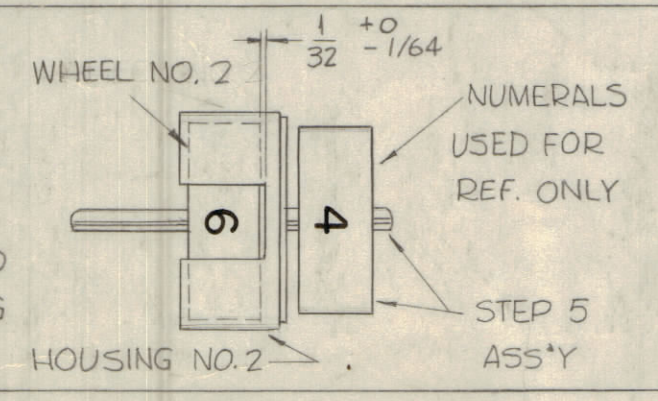
1~ DIS-ASSEMBLE ITEM 1 AS SHOWN.
 2~ DISCARD EXISTING SHAFT. (WILL BE REPLACED BY NEW SHAFT IN LATER STEPS). SAVE ALL OTHER ITEMS.
 3~ SEND THE 3 BLANK WHEELS (NOS. 1, 2 & 3) WITH LETTERING DWGS. (ITEMS 2, 3 & 4) TO VENDOR FOR LETTERING (SEE CHART).
 4~ WITH A NO. 18 DRILL (.1695 DIA) REAM OUT CENTER HOLES OF LETTERED WHEEL NO. 3 AND HOUSINGS NO. 1, 2, & 3.
 NOTE: DO NOT REAM OUT LETTERED WHEELS NO. 1 & 2.

5~ PRESS FIT NEW SHAFT (ITEM 5) INTO CENTER HOLES OF WHEEL NO. 1 (ITEM 2) AS SHOWN IN DETAIL.
 CAUTION: DO NOT DAMAGE OR MAR ANY WHEEL SURFACES.

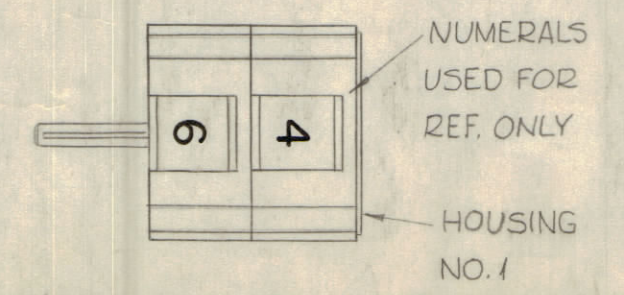


6~ REMOVE SMALL GEAR & ASSOC. PARTS FROM WHEEL HOUSING NO. 2

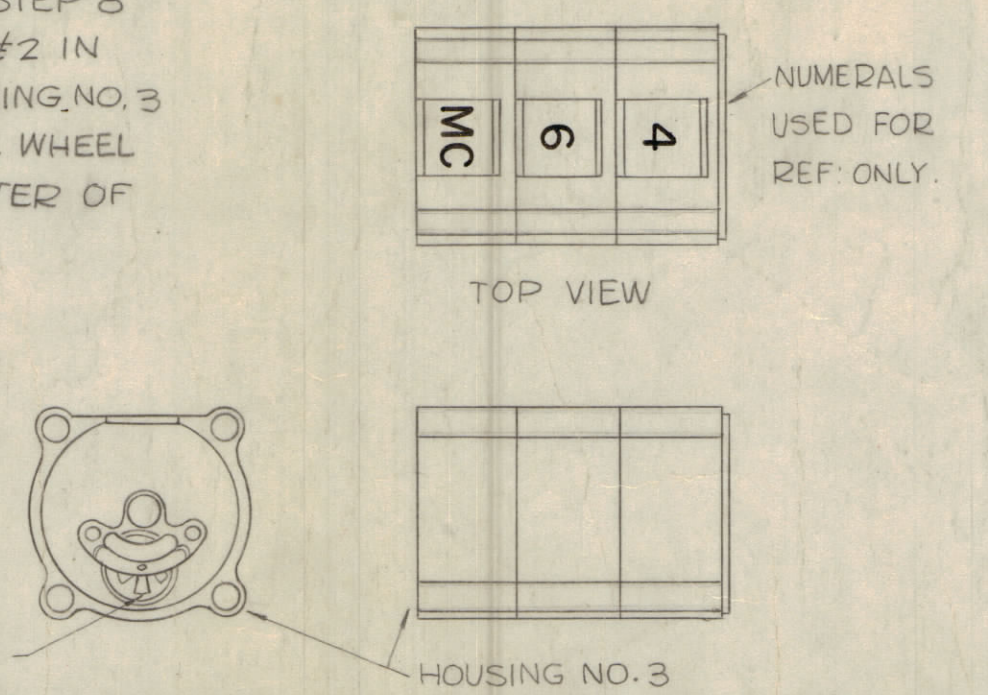
7~ ASSEMBLE WHEEL HOUSING NO. 2 AND WHEEL NO. 2 (ITEM 3) ON TO STEP 5 SHAFT ASS'Y. AS SHOWN.
 NOTE: LOWEST FIG. NO. ON WHEEL NO. 1 MUST BE CAREFULLY ALIGNED WITH LOWEST FIG. NO. ON WHEEL NO. 2 BEFORE PRESS FITTING AS SHOWN IN DETAIL. A SPACING OF 1/32 ± 1/64 MUST BE MAINTAINED BETWEEN EDGES OF WHEEL NO. 2 AND INTERIOR EDGES OF HOUSING WINDOW CUT OUT.



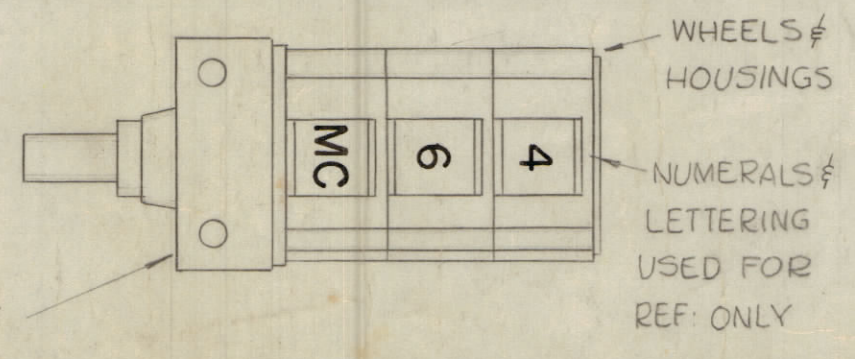
8~ ASSEMBLE WHEEL HOUSING NO. 1 OVER WHEEL NO. 1 AS SHOWN IN DETAIL.



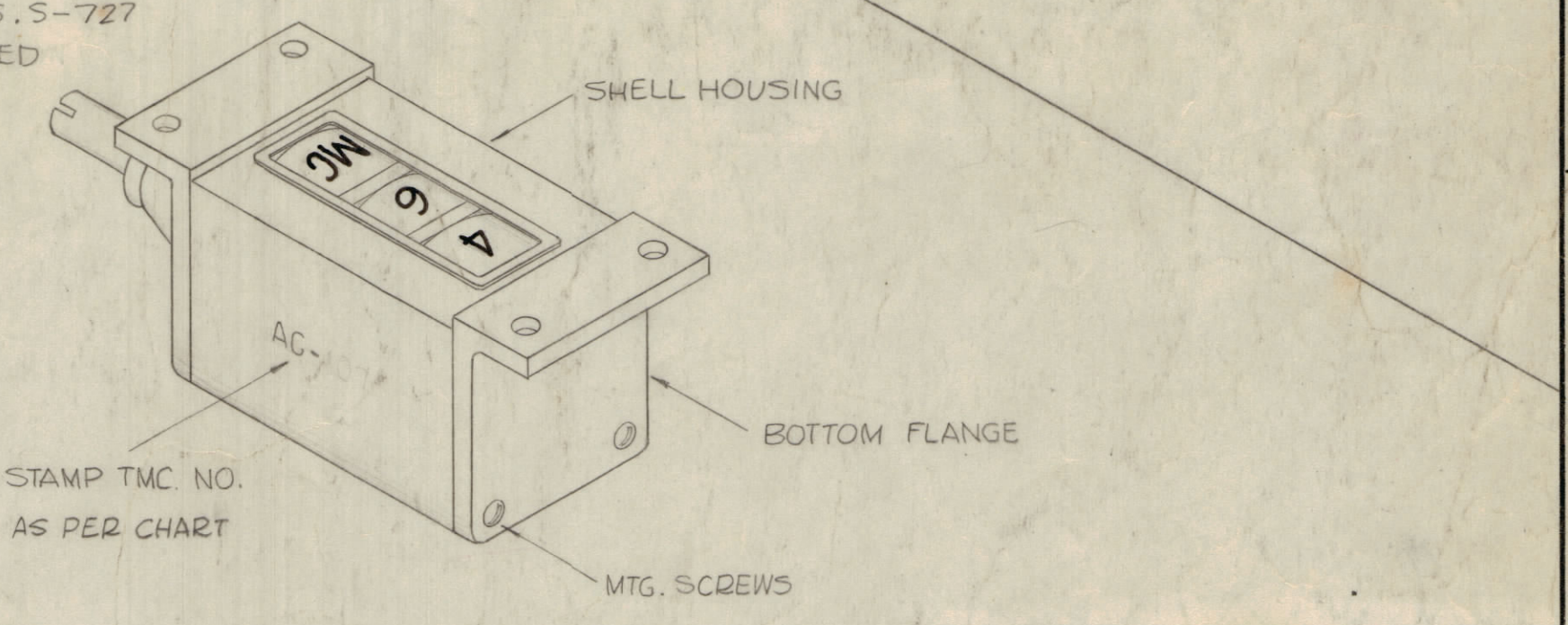
9~ ASSEMBLE WHEEL HOUSING NO. 3 OVER SHAFT OF STEP 8 ASS'Y., BEING CAREFUL TO KEEP DIGITS ON WHEELS 1 & 2 IN CENTER OF WINDOWS AND LOW GEAR TOOTH IN HOUSING NO. 3 ON VERTICAL LINE WITH CENTER OF SHAFT. ASSEMBLE WHEEL NO. 3 INTO HOUSING NO. 3, KEEPING LETTERS IN CENTER OF WINDOW.



10~ ASSEMBLE DRIVE WASHER TO WHEEL NO. 3 & ASSEMBLE SHAFT FLANGE ASS'Y. TO WHEEL & HOUSING ASS'Y.



11~ ASSEMBLE SHELL HOUSING BOTTOM FLANGE, & 4 MOUNTING SCREWS STAMP TMC CUSTOMER NO. AS PER CHART.
 NOTE: IF WHEELS DO NOT TURN FREELY, CAREFULLY TAP SHAFT SEVERAL TIMES. FOR EACH 360° TURN OF THE SHAFT, THE LETTERS SHOULD MOVE AWAY FROM WINDOW & RETURN AGAIN. THE TWO TOP WHEELS SHOULD ONLY MOVE TO NEXT TWO DIGITS.
 MARKING PROCESS - AS PER TMC SPECS. S-727 LETTERING ~ 1/8 HIGH GOTHIC WHITE LOCATED AS SHOWN.



REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
LIST OF MATERIAL				
MATERIAL			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
FINISH			TITLE COUNTER ASS'Y	
QTY./UNIT			DATE	DATE
SCALE			2-13-63	
MODEL USED ON			DRAWN	
CODE			CHECKED	
ASSY. NO.			DATE	
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.			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	
DECIMALS			ELECT. DES.	
.X ± .05			DATE	
.XX ± .01			MECH. DES.	
.XXX ± .005			DATE	
FRACTIONS			ANGLES	
± 1/64			± 0° 30'	
TOLERANCES			SHEET	

NOTES