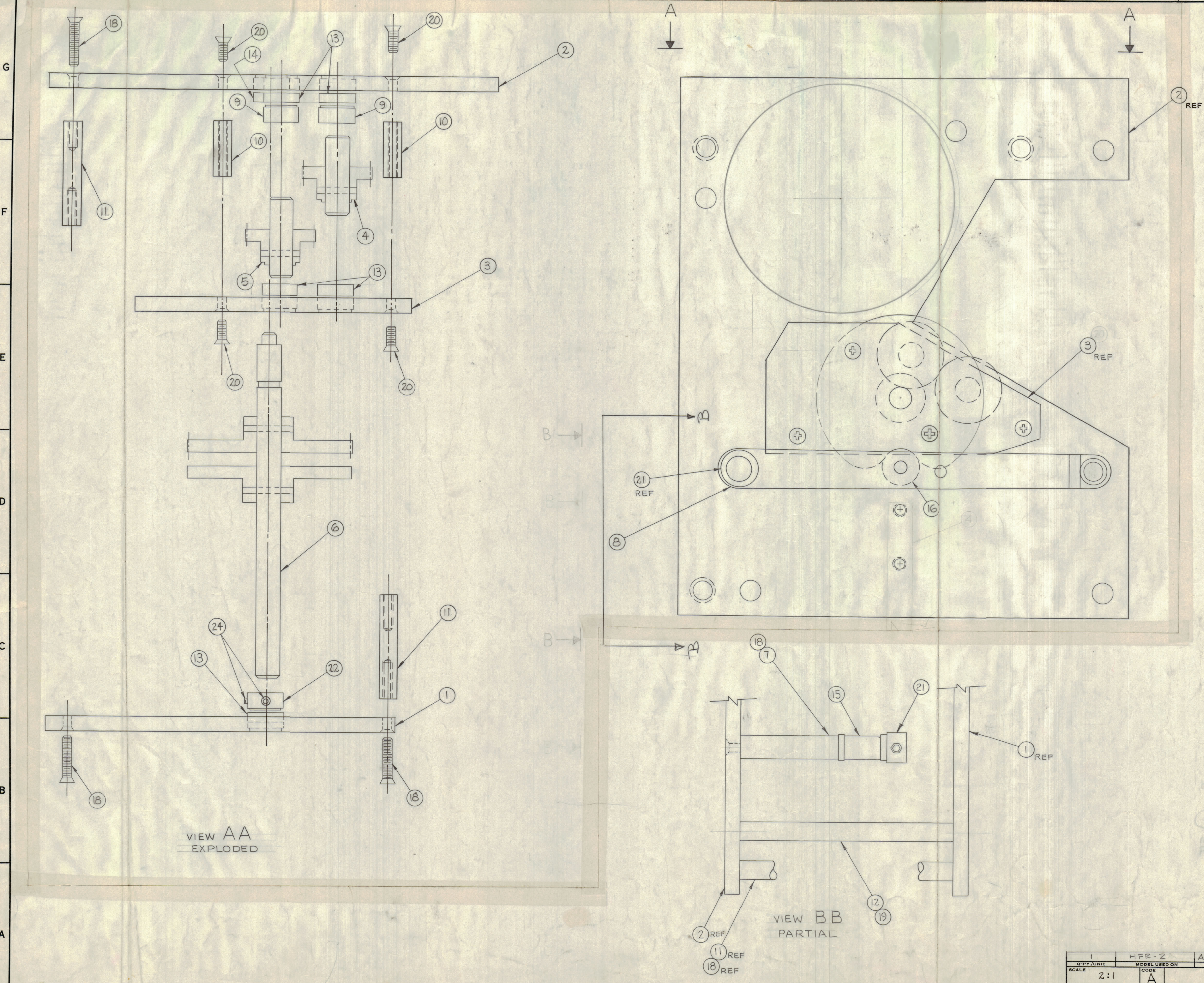


REVISIONS		DATE	E.M.N. NO.	DRAFT	CHKD	APPD
X	EXPERIMENTAL RELEASE	3/21/69				
X1	THE TITLE WAS MECHANICAL GEAR ASSY.	7-30-69	#	GDL		
X2	ITEM 8 WAS PD 241	8-4-69	#	GDL		
#	ORIGINAL RELEASE FOR PRODUCTION	8-14-69	#	GDL		
A	B/M UPDATED; IT. 23 & 24 ADD; STEP 14 ADDED TO ASSY. PROCEDURE; PICT. IT. 24 ADD TO IT. 22; IT. 3 REVISED.	12-31-69	13149			



- ASSEMBLY PROCEDURE**
- STEP 1. PRESS ITEMS 13 & 14 INTO ITEMS 1, 2 & 3.
 - STEP 2. ASSEMBLE ITEM 10 TO ITEM 2.
NOTE: USE CORRECT HARDWARE AS SHOWN ITEM 20.
 - STEP 3. ASSEMBLE ITEM 9 TO ITEMS 4 & 5.
 - STEP 4. ASSEMBLE ITEMS 4 & 5 TO ITEM 2.
 - STEP 5. ASSEMBLE ITEM 3 TO ITEM 10.
NOTE: USE CORRECT HARDWARE AS SHOWN ITEM 20.
 - STEP 6. ASSEMBLE ITEM 11 TO ITEM 2.
NOTE: USE CORRECT HARDWARE AS SHOWN ITEM 18.
 - STEP 7. ASSEMBLE ITEM 6 INTO ITEM 3, & INTO ITEM 2.
 - STEP 8. ASSEMBLE ITEM 22 TO ITEM 6.
 - STEP 9. ASSEMBLE ITEM 1 TO ITEM 11.
NOTE: USE CORRECT HARDWARE AS SHOWN ITEM 18.
 - STEP 10. ASSEMBLE ITEM 12 TO ITEM 1 & 2.
NOTE: USE CORRECT HARDWARE AS SHOWN ITEM 19.
 - STEP 11. ADJUST ALL COLLARS & BUSHINGS (ITEMS 9 & 22) & TIGHTEN.
 - STEP 12. MOUNT KNOB ON SHAFT EXTENDING THRU ITEM 1, & TURN.
NOTE: AT THIS TIME ALL GEARS SHOULD MESH PROPERLY AND TURN WITH NO BIND.
- DETENT ASSEMBLY**
- STEP 13. USING ITEM 8, ASSEMBLE ITEMS 7, 15, 16, & 21 TO ITEM 2 WITH ITEM 18.
NOTE: TIGHTEN SET SCREWS ON ITEM 21 SO ARM WILL SPIN FREE WITH NO PLAY.
 - STEP 14. LUBRICATE ALL GEARS WITH ITEM 23.

REQD.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
2	24	SLHC0440SS2	SET SCREW	
X	23	LUI06	GREASE	
1	22	PM 1062-3	COLLAR, SHAFT	
1	21	PM 786-44	COLLAR, SHAFT	
8	20	SCFP0832 556	SCREW, MACHINE	
2	19	SCFP0632 556	SCREW, MACHINE	
7	18	SCFP1032 558	SCREW, MACHINE	
#	17		DELETED	
1	16	PM 1037	SPACER, DETENT ARM	
1	15	PO 244-2	SPACER, DETENT ARM	
1	14	BB 126-15	BEARING, BALL	
5	13	BB 126-6	BEARING, BALL	
1	12	TE 0632 5-5-78R	SPACER, STANDOFF	
3	11	TE 1032-5-5-78R	SPACER, STANDOFF	
4	10	TE 0832 5586R	SPACER, STANDOFF	
2	9	PM 1062-4	COLLAR, SHAFT	
1	8	PO 307	ARM, DETENT	
1	7	PM 1038	SHAFT, (DETENT ARM)	
1	6	A 3489	GEAR, ASSY	
1	5	A 3516	GEAR, ASSY	
1	4	A 3487	GEAR, ASSY	
1	3	MS 3703	PLATE, IDLER	
1	2	MS 3702	PLATE, BOTTOM, TURRET	
1	1	MS 3701	PLATE, TOP, TURRET	

LIST OF MATERIAL		THE TECHNICAL MATERIEL CORP.	
MATERIAL	FINISH	MAMARONECK, NEW YORK	
		TITLE: BAND SWITCH GEAR ASSY (MANUAL)	
		DRAWN: <i>ADW</i>	DATE: 3/24/69
		CHECKED: <i>@</i>	DATE: 3-24-69
		ELECT. DES.:	DATE:
		MECH. DES.:	DATE:
		A 3548 A	

1	HFR-2	AX 513-1
SCALE	2:1	CODE A
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DECIMALS	FRACTIONS	ANGLES
.1 ± .05	1/64	± 0° 30'
.01 ± .01	1/32	
.005 ± .005		

NOTES

A 3548 A