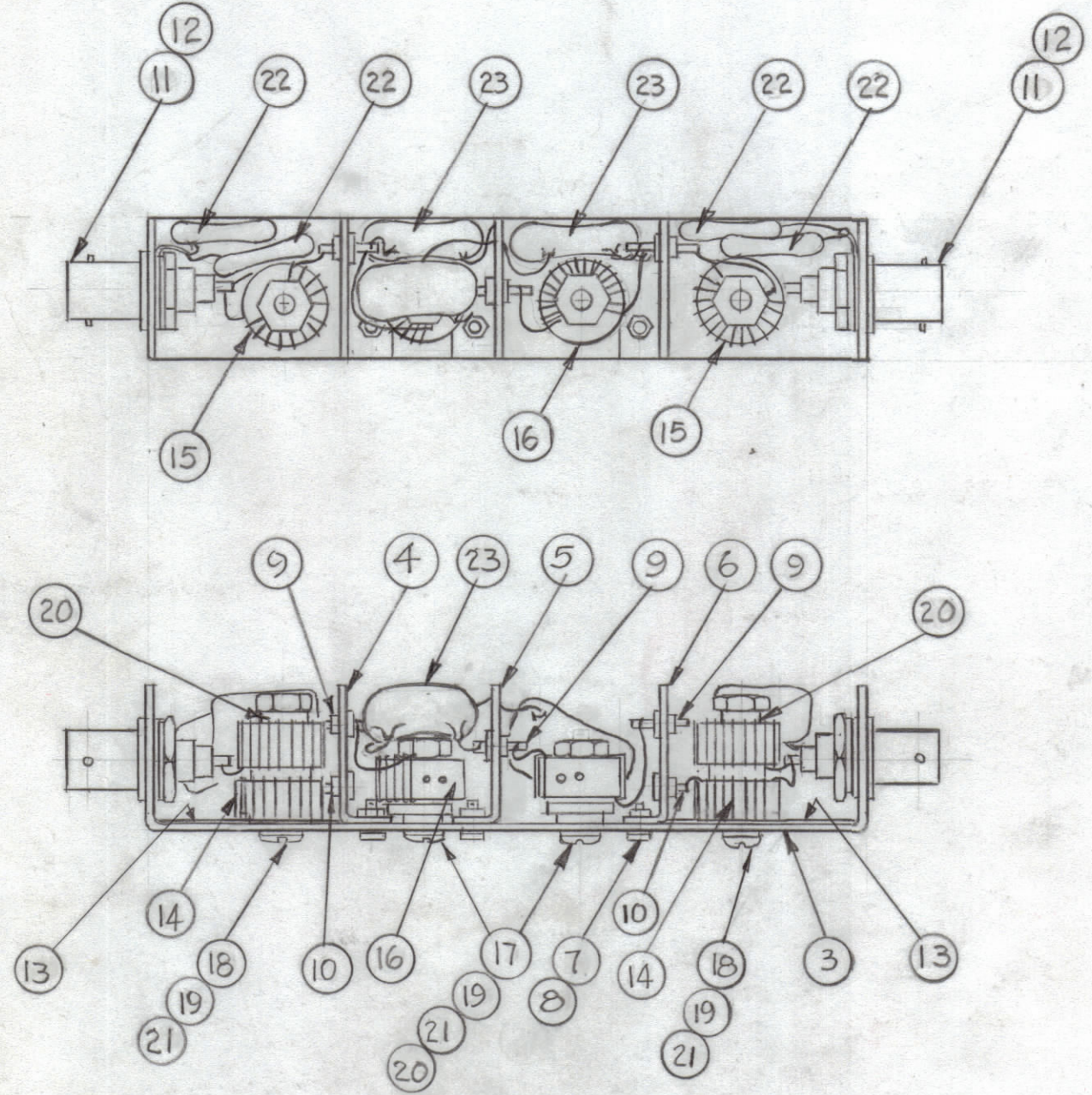
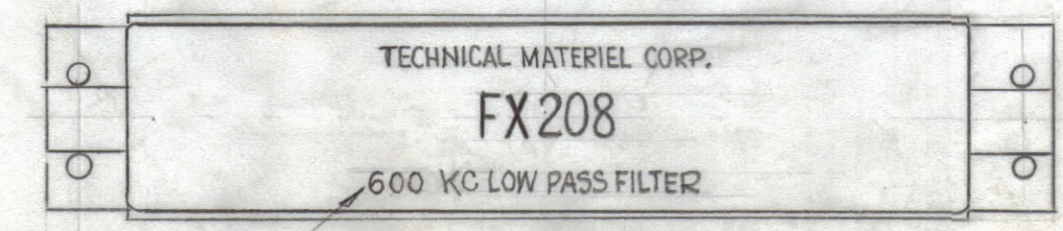
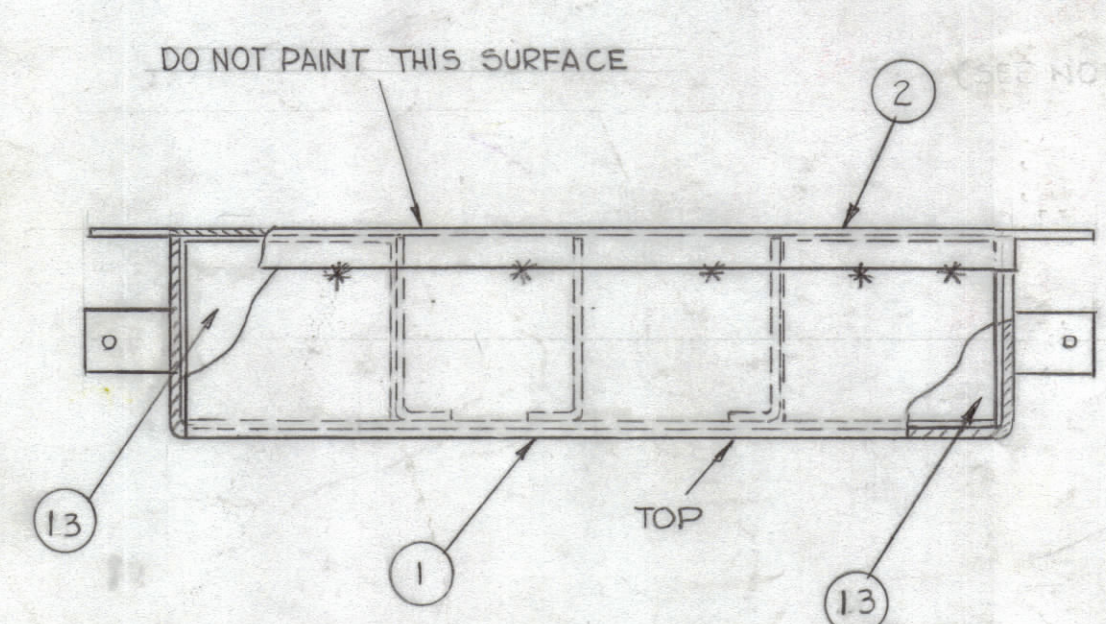


REVISIONS						
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD
	X	EXPER. RELEASE	12-17-64		G.D.L.	
	X1	ITEM 22 WAS CM112F152J35	1-7-65	+	e	
	Ø	ORIGINAL RELEASE FOR PRODUCTION	1-7-65	Ø	91.	
	A	IT(14) WAS A3223-35; IT(13) WAS A3223-36; IT(2) WAS A3223-37; DESCRIPTIONS UPDATED IT(11) WAS UG-625B/U.	2-1-65	13410	88	JOB
	B	IT(2) WAS MS3945 IT(13) WAS X UPDATED IT. (Ø) WAS UG-625B/U	9/5/65	14618	D.V.C.	907 M.M.

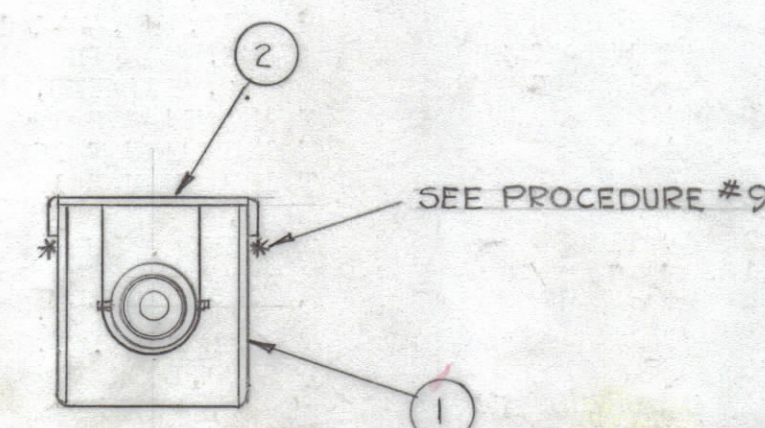


— SUB-ASSY —



SEE PROCEDURE #11

— FINAL ASSY —



- ASSEMBLY PROCEDURE
- PRESS ITEMS 9 & 10 INTO ITEMS 4, 5 & 6 AS SHOWN.
 - ASSEMBLE ITEMS 11, 12, 4, 5 & 6 TO ITEM 3 AS SHOWN, USING ITEMS 7 & 8.
 - ASSEMBLE ITEMS 14, 15 & 16 USING ITEMS 17, 18, 21, 19, 13 & 20 AS SHOWN.
 - CONNECT ITEMS 14, 15, 16 (SEE CK-811), CONNECT ITEMS 22 & 23 AND POSITION AS SHOWN. GROUND LEADS ARE SOLDERED DIRECTLY TO CHASSIS.
 - ITEM 17 SHOULD BE CUT LEVEL WITH NUT (ITEM 21)
 - PLACE COMPLETE SUB-ASSEMBLY INTO ITEM 1 AS SHOWN.
 - INSERT ITEM 13 BETWEEN COILS AND CHASSIS WALL. (4 PLACES)
 - PLACE ITEM 2 OVER ITEM 1 AND TEST.
 - SOLDER AT SEAMS INDICATED BY * AND RETEST.
 - MASK ITEM 11 AND BOTTOM SURFACE & PAINT TMC GRAY PER S115 ALL OVER.
 - MARK TOP OF CASE AS SHOWN IN BLACK.

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
X	24	BS100	SOLDER, TIN ALLOY	
3	23	CM112F103J1S	CAPACITOR, FIXED, MICA	C3,4,5
4	22	CM112F152F3S	CAPACITOR, FIXED, MICA	C1,2,6,7
4	21	NT137-0632	NUT, PLAIN, HEX, NYLON	
4	20	FW101-1	WASHER, NM, NYLON	
4	19	FW101-5	WASHER, NM, NYLON	
2	18	SC143-0632B13	SCREW, MACHINE, NYLON	
2	17	SC143-0632B10	SCREW, MACHINE, NYLON	
2	16	CL344	COIL, RF THRU T2160 ASSEMBLY	L3,4
2	15	CL343	COIL, RF THRU T2160 ASSEMBLY	L2,5
2	14	CL342	COIL, RF THRU T2160 ASSEMBLY	L1,6
2	13	PX873	INSULATOR, COIL	
2	12	TE111-2	TERMINAL, LUG	
2	11	UG-625*/U	CONNECTOR, RECEPTACLE	J1,2
2	10	TE192A3R9	TERMINAL, STUD, INS	
3	9	TE193B4S9	TERMINAL, F.D., THRU, INS.	
6	8	LWS02MRN	WASHER, LOCK, SPLIT	
6	7	SCBP0256BN4	SCREW, MACHINE	
1	6	MS4112	SHIELD, R.F.	
1	5	MS3946	SHIELD, R.F.	
1	4	MS3943	SHIELD, R.F.	
1	3	MS3947	CHASSIS, SUB	
1	2	MS3945	PLATE, BOTTOM	
1	1	MS3944	CASE, FIL.	

O. POSE		LIST OF MATERIAL	
MATERIAL	+	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
FINISH	SEE PROCEDURE 10	TITLE	FX208 ASSY
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DRAWN	G.D.L.
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005		CHECKED	12-17-64
FRACTIONS ± 1/64 ANGLES ± 0° 30'		DATE	12-31-64
TOLERANCES		ELECT. DES.	DATE
		MECH. DES.	DATE
		A3750	
		SHEET	B.
		REV. LTR.	

NOTES

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.

A3750