

STANDARD DRAWING

IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

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

GL-102

USED ON

MODEL PROJECT NO. ASSY. NO. DATE

Q-MAX A-27 (Lacquer)

Ref. COMMUNICATION PRODUCTS CO., INC.

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
#		THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
	STOCK SIZE		
#		Lacquer	
	MATERIAL		
#			
	TYPE & TEMPER		
#			
	HEAT TREAT. SPEC.		
#			
	FINISH & SPEC. NO.		

ISSUE ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.

TOLERANCES
DEC. DIM. \pm
FRAC. DIM. \pm
ANGULAR DIM. \pm

DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.

DRAWN	MECH. DES. APP.
JAD 11-5-52	<i>[Signature]</i>
CHECKED	FINAL APPROVAL
JAD	GL-102

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

STANDARD DRAWING

GL-103

USED ON

DATE

ASSY. NO.

PROJECT NO.

MODEL

SPECIFICATIONS

MATERIAL- NITRO-CELLULOSE BASE PLASTICIZER

SOLVENT (ETHYL ACETATE OR METHYL ETHYL KETONE)

USES: CEMENTING WOOD, PAPER, CERAMICS, LEATHER, ETC. NOT RECOMMENDED FOR STYRENE, METAL OR RUBBER

SHELF LIFE: 3 TO 5 YEARS

FLASH POINT: 20 TO 80°F (BEFORE DRYING)

DRYING TIME: 10 TO 30 MINUTES

MAXIMUM TEMP: 200°F (AFTER DRYING)

DIELECTRIC STRENGTH: 300 TO 500 VOLTS PER MIL

DIELECTRIC CONSTANT: 1.0Kc-6.7 TO 8.8
1.0Mc-6.15 TO 6.2

TRADE NAME: DUCO CEMENT

NOTICE TO PERSONS RECEIVING THIS DRAWING

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Property of:

THE TECHNICAL MATERIEL CORPORATION
MAMARONECK, NEW YORK

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
#	#	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
#	#	ADHESIVE, NITRO-CELLULOSE BASE	
#	#	STOCK SIZE	
#	#	MATERIAL	
#	#	WEIGHT PER PC.	
#	#	TYPE & TEMPER	
#	#	HEAT TREAT. SPEC.	
#	#	FINISH & SPEC. NO.	

ISSUE ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS CHECKER	ENG. APP.
A 1	REVISED, SPECS ADDED	7-29-41	11721	SRC	JAL
TOLERANCES					
SCALE 3/401-261 (DUCO)					
DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.					
ALL OTHERS	DEC. DIM. \pm	FRAC. DIM. \pm	ANGULAR DIM. \pm		

MECH. DES. APP. *JAL*
ELEC. DES. APP. *JAL*
DRAWN *JAL*
CHECKED *JAL*
FINAL APPROVAL *JAL*

A

GL-103

STANDARD DRAWING

GL-105

A

IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

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

USED ON

MODEL

PROJECT NO.

ASSY. NO.

DATE

GENERAL SPECS.

1. RESISTANT TO HEAT, HUMIDITY, ALKALI, ACID & OIL.
2. RESIN BASE

BAKING TIME - HRS.		AVERAGE AIR DRYING TIME	COLOR	GE THINNER NO.
100	2	150C	GLOSS RED	1500
5	2	8		

GENERAL ELECTRIC CO. #1201 GLYPTAL

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
	#	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
	#	LACQUER, GLYPTAL	
	#	STOCK SIZE	
	#	MATERIAL	
	#	WEIGHT PER PC.	
	#	TYPE & TEMPER	
	#	HEAT TREAT. SPEC.	
	#	FINISH & SPEC. NO.	

ISSUE ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
A 1	UPDATED	12/18/63	10622	<input checked="" type="checkbox"/>	<i>[Signature]</i>	<i>[Signature]</i>

SCALE

TOLERANCES

DEC. DIM. \pm
FRAC. DIM. \pm
ANGULAR DIM. \pm

DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.

C.D.P. 10-22-54

DRAWN *[Signature]*

ELEC. DES. APP.

MECH. DES. APP.

CHECKED *[Signature]*

FINAL APPROVAL

GL-105

A

IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

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

STANDARD DRAWING

GL-106

A

USED ON

DATE

ASS'Y. NO.

PROJECT NO.

MODEL

TO (ANY QUANTITY) LAMINAC 4116 (RESIN)
 ADD 10% (WT. OF RESIN) STYRENE (THINNER)
 0.33% (WT. OF RESIN+THINNER) NUODEX (ACCELERATOR)
 30% (WT. OF RESIN+THINNER) ASP 400 (FILLER)
 MIX WELL UNTIL ALL OF FILLER IS IN SUSPENSION.

WHEN READY TO CAST -
 ADD 1% (WT. OF RESIN+THINNER) LAMINAC CATALYST #347

MIX WELL AND POUR IMMEDIATELY

NOTE:

MAXIMUM HEAT GENERATED DURING REACTION AFTER ADDITION OF CATALYST #347 AT ROOM TEMP. IS APPROXIMATELY 125°C. APPROX. SETTING TIME: 3 HOURS.

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
#		THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
#		COMPOUND (PLASTIC) CASTING & POTTING.	
MATERIAL	WEIGHT PER PC.		
#		C.D.D. 12-5-57	G.T.O
TYPE & TEMPER		DRAWN	ELEC. DES. APP. <i>AKG</i>
#		CHECKED	MECH. DES. APP.
HEAT TREAT. SPEC.			FINAL APPROVAL
#			GL-106
FINISH & SPEC. NO.			A

ISSUE ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS CHECKER	ENG. APP.
A 1	NOTE ADDED	5-19-61	4926	MAR	<i>AKG</i>
TOLERANCES					
SCALE					
DEC. DIM. ±					
FRAC. DIM. ±					
OTHERS ANGULAR DIM. ±					
DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.					

IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.		GL-108	
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES		USED ON	
MODEL	PROJECT NO.	ASSY. NO.	DATE
KS-85-X	I-227		8-20-53

NOTE:
 DO NOT HEAT MORE THAN 375°F
 POURING TEMP. 280°F

REF: OKONITE - CALLENDER Cable Co. #25

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
STOCK SIZE		COMPOUND, FILLING	
MATERIAL	WEIGHT PER PC.		
TYPE & TEMPER			
HEAT TREAT. SPEC.			
FINISH & SPEC. NO.			

ISSUE	ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES							
SCALE							
DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.							
ALL	DEC. DIM. ±						
OTHERS	FRAC. DIM. ±						
	ANGULAR DIM. ±						

DRAWN	ELEC. DES. APP.	MECH. DES. APP.
WDR		WDR
CHECKED	FINAL APPROVAL	
WDR	GL-108	

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STANDARD DRAWING

USED ON

DATE

ASSY. NO.

PROJECT NO.

MODEL

GL-109

REF: DENNSION # 4

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
STOCK SIZE		SEALING WAX	
MATERIAL	WEIGHT PER PC.		
TYPE & TEMPER			
HEAT TREAT. SPEC.			
FINISH & SPEC. NO.			
ISSUE ITEM	CHANGED FROM	DATE	CN. NO. DRAFTS
			CHECKER
			ENG. APP.
SCALE			
TOLERANCES			
ALL DEC. DIM. \pm	DRILL, PUNCH, COMMERCIAL STOCK		
OTHERS FRAC. DIM. \pm	SIZES AND MANUFACTURERS		
ANGULAR DIM. \pm	TOLERANCES ARE NOT INCLUDED.		
	DRAWN	ELEC. DES. APP.	MECH. DES. APP.
	CHECKED		
		FINAL APPROVAL	
			GL-109

IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.		GL-110	
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES		MODEL	DATE
		PROJECT NO.	ASS'Y. NO.
		USED ON	

MELTING POINT DRIP METHOD - 235/245 F
 COLD FLOW - 221/230
 OPERATING TEMPERATURE - 250/275
 SPECIFIC GRAVITY - 1.028

REF: ZOPHAR MILLS, INC. # 1563

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
STOCK SIZE		IMPREGNATING WAX	
MATERIAL	WEIGHT PER PC.		
TYPE & TEMPER			
HEAT TREAT. SPEC.			
FINISH & SPEC. NO.			

ISSUE ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES						
SCALE						
DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.						
ALL	DEC. DIM. ±					
OTHERS	FRAC. DIM. ±					
	ANGULAR DIM. ±					

DRAWN	ELEC. DES. APP.	MECH. DES. APP.
FAID	KZ	WZ
CHECKED		
1/8/14	A. J. J.	
		FINAL APPROVAL
		GL-110

STANDARD DRAWING

GL-112

REQ. PER UNIT	MODEL	USED ON
		ASSY. NO.
		DATE

SPECIFICATIONS

COLOR DK. BROWN
 SOLIDS, %₀, MINIMUM 50
 SPECIFIC GRAVITY AT 25°C 1.00 - 1.03
 VISCOSITY AT 25°C, CENTIPOISES 100 - 200
 FLASH POINT 70-90
 DRYING TIME, MAX. HRS. AT 200°C 3
 WEIGHT LOSS, 3 HRS. AT 250°C, % 5
 SOLVENT XYLENE

TYPICAL PROPERTIES OF CURED 997 VARNISH FILMS

HEAT ENDURANCE AT 250°C
 FLEX LIFE, HOURS, MINIMUM 250
 GRAZE " " " 1000
 DIELECTRIC STRENGTH
 2 INCH ELECTRODES 1000 - 2000
 POWER FACTOR AT 25°C
 10² CYCLES 0.004
 10³ CYCLES 0.007
 DIELECTRIC CONSTANT AT 25°C
 10² CYCLES 3.06
 10³ CYCLES 2.98
 THERMAL LIFE* HOURS
 AT 300°C 200
 AT 275°C 600
 AT 250°C 2000

* HOURS AGEING NECESSARY TO REDUCE THE DIELECTRIC STRENGTH OF GLASS CLOTH IMPREGNATED WITH 997 TO 50% OF ITS INITIAL VALUE.

REF: DOW-CORNING CORP. # 997

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
		VARNISH, 997	
ISSUE ITEM	CHANGED FROM	DATE	CH. NO.
TOLERANCES			
DEC. DIM. ±			
FRAC. DIM. ±			
ANGULAR DIM. ±			
TYPE & TEMPER	HEAT TREAT. SPEC.	DRAWN	CHECKED
		20	JABE
MATERIAL		DATE	APPROVAL
		000 1/5/56	JABE
FINISH & SPEC. NO.		ELEC. DES. APP.	MECH. DES. APP.
			GL-112

STANDARD DRAWING

REQ. PER UNIT	MODEL	USED ON ASSY. NO.	DATE

GL115 A

SPECIFICATIONS:

SPECIFIC GRAVITY AT 25°C
 BAUME AT 25°C
 VISCOSITY AT 25°C CENTIPOISES
 FORD CUP #4 AT 25°C, SECONDS
 SOLIDS, PERCENTAGE, ASTM D115
 SOLVENT
 FLASH POINT, ASTM D115
 DIELECTRIC STRENGTH -VOLTS PER MIL, APPROXIMATELY 2000
 BEST CURING METHOD FOR BEST DIELECTRIC RESULTS 2 HOURS AT 480°F
 CHEMICAL RESISTANCE:

0.955 - 0.965
 16.7 - 15.0
 300 -500
 100 -150
 50 PLUS/MINUS 2
 XYLLOL
 80°F

OIL, HOT ASTM D115
 WATER
 SALT WATER
 ACID
 ALKALI
 MOISTURE

UNAFFECTED
 EXCELLENT
 EXCELLENT
 GOOD
 EXCELLENT
 EXCELLENT

HEAT RESISTANCE

THIS COATING RETAINS ITS EXCELLENT ELECTRICAL PROPERTIES EVEN IN THE PRESENCE OF HUMID ATMOSPHERES. IT IS ARC RESISTANT AND WILL NOT TRACK OR CHAR AND IS, THEREFORE, RECOMMENDED FOR USE ON ELECTRONIC COMPONENTS WHICH ARE SUBJECTED TO HIGH VOLTAGES. BECAUSE IT IS ARC RESISTANT, AND WILL NOT TRACK, IT WILL HELP PREVENT FAILURE OF EQUIPMENT FROM CARBONIZING AND BURNING DUE TO HIGH VOLTAGE ARCING.

POUNDS PER GALLON: 8.5
 SHELF LIFE: 6 TO 8 MONTHS
 PACKAGE: SPRAY CAN OR BOTTLE

REF: G.C. ELECTRONICS CO. # 14-6

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK.	
		PRINT-KOTE RESIN, SILICONE LACQUER	
		CDD 11/23/56 JADE	AJJ
		DRAWN	CHECKED
		HEAT TREAT. SPEC.	WDC
		FINISH & SPEC. NO.	GL115 A
		ELEC. DES. APP. MECH. DES. APP.	
		TYPE & TEMPER	
		SCALE	
		DATE	
		CH. NO.	
		DRAFTS	
		CHECKER	
		ENG. APP.	
		DESCRIPTION	
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	
		TOLERANCES	
		FRACTIONS	
		DECIMALS	
		ANGLES	

REQ. PER UNIT
MODEL
TRC-5K
USED ON
ASSY. NO.
DATE
12-18-63

GL-123 A

SPECIFICATIONS

MACHINABILITY: COMPOUND CAN BE READILY CUT, DRILLED OR SANDED WITH ORDINARY TOOLS. FOR MACHINING, BULK DENSITIES OF 6LBS. PER CUBIC FOOT, OR HEAVIER, IS RECOMMENDED.
TEMPERATURE RANGE: -70°C. to +150°C. (-94°F to +304°F).
UNICELLULARITY: NOT INTERCONNECTING. FOR ABSOLUTE ASSURANCE AGAINST WATER PENETRATION, BULK DENSITIES OF 7 LBS. PER CUBIC FOOT, OR HEAVIER IS RECOMMENDED.
ELECTRICAL:

* DENSITY (POUNDS/CUBIC FOOT)

3	10	25
1.04	1.18	1.47

LESS THAN
.0001 .0004 .003

PHYSICAL:

TENSILE STRENGTH (PSI)	55	320	1,100
COMPRESSIVE STRENGTH (PSI)	65	340	1,200
MODULUS OF ELASTICITY (PSI)	-	11,000	52,000
THERMAL CONDUCTIVITY (BTU/HR./SQ. FT./°F./FT.)	.014	.020	-
COEFFICIENT OF THERMAL EXPANSION	-	40 x 10 ⁻⁶	-
WATER ABSORPTION (24 HRS. @ 25°C.)	1.3%	0.25%	0.1%

TMC PART NO. SHALL BE IN THE FOLLOWING FORM:
GL-123 - 14
 /
 BASIC PART NO. * BULK DENSITY (POUNDS/CUBIC FOOT)

SEE TMC 5G22

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
		POTTING COMPOUND	
		MATERIAL	
		STOCK SIZE	
		TYPE & TEMPER	
		HEAT TREAT. SPEC.	
		FINISH & SPEC. NO.	
		ELEC. DES. APP.	
		MECH. DES. APP.	
			GL-123 A

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.

REQ. PER UNIT

USED ON

DATE

GL-125

ASSY. NO.

8-31-62

Standard

EPOXI-PATCH KIT #1C, COLOR - WHITE, CONSISTING OF: A. ONE TUBE, EPOXI RESIN
 B. ONE TUBE, EPOXI HARDENER
 C. TWO WOOD SPATULAS

METHOD OF APPLICATION:

- Mix on any clean, dry, flat surface that is discardable.
- Squeeze one length of HYSOL RESIN on mix surface. Use uniform pressure for even bead.
- Parallel to bead of resin squeeze an EQUAL LENGTH BEAD OF HARDENER.
 NOTE: For even cut-off, tilt tube firmly against mixing surface.
- MIX THOROUGHLY -- so that the different colored hardener and resin result in a uniform color.
- Apply to surfaces which are clean, dry and free of oil, grease or wax.
- Mixed material must be used within 45 minutes.

CURE:

Room temperature (77°F.) will harden in 1-2 hours. Will cure in 24 hours.
 Cure may be accelerated with heat such as infra-red lamps, ovens or torches.
 Do not exceed heat of 300°F. for more than one hour.

WARNING:

- Keep tubes securely capped when not in use.
- Prevent contact with the skin. If skin contact occurs, wash with clean soap and water.

Ref: Hysol Corp., Olean, New York

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		EPOXY ADHESIVE	
		SEALANT	
		CHECKED	FINAL APPROVAL
		DRAWN	
		HEAT TREAT. SPEC.	
		FINISH & SPEC. NO.	GL-125
		ELEC. DES. APP. MECH. DES. APP.	

SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.

UNLESS OTHERWISE SPECIFIED:	
DIMENSIONS ARE IN INCHES	SCALE:
TOLERANCES ON	MAXIMUM ALLOWABLE TOLERANCES HAVE
FRAC. ± 1/64 DEC. ± .005 ANGLES ± 1/2°	BEEN DETERMINED AND ANY DEVIATIONS
	WILL BE CAUSE FOR REJECTION.
	REMOVE ALL BURRS AND SHARP EDGES

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REQ. PER UNIT	MODEL	ASSY. NO.	DATE		
	TR-147		9-18-62		

ADD 2% BY WEIGHT OF BENZOIL PEROXIDE TO 8001 POLYLITE. THEN ADD 15% BY WEIGHT OF 1/32 MFCF MILLED FIBERS. MIX WELL UNTIL ALL OF FILLER IS IN SUSPENSION.

NOTE: PLACE POTTED UNIT IN OVEN AND BAKE AT 200°F. FOR 1½ HOURS.

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		GELMAN THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
		STOCK SIZE	
		MATERIAL	
		BENZOIL PEROXIDE & 8001 POLYLITE	
		CHECKED	
		DRAWN	
		TYPE & TEMPER	
		HEAT TREAT. SPEC.	
		FINISH & SPEC. NO.	GL-126
		ELEC. DES. APP.	
		MECH. DES. APP.	

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES ON
FRAC. ± 1/64 DEC. ± .005 ANGLES ± 1/2°

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

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			VLR-1		5-8-63

GL-128

B

- 1. PRELIMINARY PREPARATION**
 (The following preparation has a non-curing shelf life of one (1) year.)
 Mix 100 Grams of RUBBER GRADE STYRENE MONOMER with 450 Grams of 8001 POLYLITE.
 To color, add 25 Grams of POLYESTER COLOR. (Natural color is off-white.)
- 2. FINAL PREPARATION BEFORE POTTING**
 Separate preliminary preparation into two equal parts. Mix 11 Grams of BENZOIL PEROXIDE with one half of preliminary preparation, and mix 1.2 Gram of DIETHYL ANILINE with other half of preliminary preparation. Mix two halves of preparation together and immediately add 300 Grams of 611 CALCINED ALUMINA A-2 (-325 MESH). Mix thoroughly and pot immediately.
- 3. POTTED UNIT**
 May be handled after four (4) hours at room temperature.
 Is completely cured after 24 hours at room temperature.
- 4. SMALLER QUANTITIES**
 Formula may be broken down for smaller quantities.

INGREDIENT	MANUFACTURER
STYRENE MONOMER	COPPER CHEMICAL or DOW CHEMICAL
8001 POLYLITE	REICHHOLD CHEMICAL
CALCINED ALUMINA	WHITTAKER, CLARK & DANIELS, INC.
POLYESTER COLOR	FERRO CHEMICAL

TMC PART NO.	COLOR
GL-128-1	Brown
GL-128-2	Red
GL-128-3	Orange
GL-128-4	Yellow
GL-128-5	Green
GL-128-6	Blue
GL-128-7	Violet
GL-128-8	Gray
GL-128-9	White (Natural)
GL-128-0	Black

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		GELLMAN	
		THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
		COMPOUND, POTTING	
SYM	DESCRIPTION	CHECKER	ENG. APP.
B	ADDED GL-128-0	JRS	
A	POTTING SPECS CLARIFIED GL-128-1,3,7 & 8 ADDED	JRS	
	DATE	CH. NO.	DRAFTS
	12-13-66	17453	RME
	9-11-63	9896	JRS
	SCALE		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES			
DECIMALS	FRACTIONS	CODE	
.X ± .05	± 1/64		
.XX ± .01	ANGLES		
.XXX ± .005	± 0° 30'		
	TOLERANCES		
		DRAWN	CHECKED
		5-8-63	5/4/63
		JRS	JFH
		HEAT TREAT. SPEC.	FINAL APPROVAL
			5-8-63
		FINISH & SPEC. NO.	
		GL-128	B

SPECIFICATIONS

1. TENSILE STRENGTH: 6500-8000 PSI
2. MODULUS OF ELASTICITY: 4-5 X 10⁵ PSI
3. HARDNESS: 70-80 (ROCKWELL "M" SCALE)
4. FLEXURAL STRENGTH: 9,000-13,000 PSI
5. THERMAL EXPANSION: 6-8 X 10⁵ IN/IN/°C.
6. MAXIMUM TEMPERATURE: 150°C.
7. SPECIFIC GRAVITY: 1.04-1.06
8. MOISTURE ABSORPTION: .03-.04%
9. BURNING RATE (.05" THICK): 1-1.5 SECONDS
10. DISSIPATION FACTOR: .0001-.0005
11. DIELECTRIC CONSTANT: 2.52-2.65
12. DIELECTRIC STRENGTH: > 500 VOLTS/MIL
13. VOLUME RESISTIVITY: 10¹⁸-19ΩCM
14. ELONGATION OF FAILURE: 1.8-2.4%
15. DEFLECTION AT BREAK: 0.15-0.35 INCHES

REQ. PER UNIT	MODEL	USED ON ASSY. NO.	DATE
#	#	#	10-1-63

GL-130

STANDARD DRAWING

GELLMAN		DESCRIPTION		SYMBOL	
THE TECHNICAL MATERIEL CORP.		MAMARONECK.		NEW YORK	
CEMENT, Q-DOPE					
C. K. [Signature]		10/1/63		[Signature]	
DRAWN		CHECKED		FINAL APPROVAL	
TYPE & TEMPER		HEAT TREAT. SPEC.			
FINISH & SPEC. NO.		PART NO.		STOCK SIZE	
S401-219(57-04W)					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		DATE		CH. NO.	
TOLERANCES		SCALE		CHECKER	
FRACTIONS ± 1/64 ANGLES ± 0° 30'				ENG. APP.	
DECIMALS .XX ± .01 .XXX ± .005				DRAFTS	
				DATE	
				CH. NO.	
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				ENG. APP.	
				MATERIAL	
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				TYPE & TEMPER	
				HEAT TREAT. SPEC.	
				FINISH & SPEC. NO.	
				PART NO.	
				STOCK SIZE	

ELECTRICAL SPECIFICATIONS
 DISSIPATION FACTOR (60CPS TO 10 Kmc) : 0.03
 DIELECTRIC CONSTANT (60CPS TO 10 Kmc) : 4.4 TO 4.6
 VOLUME RESISTIVITY: @ 70°F (21°C.) 2 x 10¹⁵ OHM-CM
 300°F (149°C.) 1 x 10¹² OHM-CM
 DIELECTRIC STRENGTH: 400 VOLTS/MIL AT 68°F. (20°C.)

MECHANICAL SPECIFICATIONS
 SPECIFIC GRAVITY: 1.45 - 1.55
 VISCOSITY: 1,500 TO 2,500 CENTIPOISES AT 75°F. (24°C.)
 THERMAL EXPANSION COEFFICIENT: 20-30 x 10⁻⁶/°C
 THERMAL CONDUCTIVITY: 1.5-2.5 BTU/FT²/HR/°F/INCH
 IZOD IMPACT: 1.0 FT. LBS./INCH OF NOTCH
 WATER ABSORPTION (WEIGHT % GAIN, 24 HOURS): 0.1
 MACHINABILITY: EXCELLENT
 MAXIMUM CONTINUOUS TEMPERATURE: 350°F. (177°C.)
 MAXIMUM INTERMITTENT TEMPERATURE: 400°F. (204°C.)
 MINIMUM TEMPERATURE: -100°F. (-73°C.)
 TENSILE STRENGTH: 8,000 psi
 COMPRESSIVE STRENGTH: 11,900 psi
 FLEXURAL STRENGTH: 15,100 psi
 COLOR: REDDISH BROWN

NOTE:
 1. RESIN AND CATALYST ARE MOISTURE SENSITIVE. CONTAINERS SHOULD BE CLOSED WHEN NOT IN USE. A HUMID ATMOSPHERE AND TEMPERATURES BELOW 70°F. (22°C) SHOULD BE AVOIDED WHEN CURING AT ROOM TEMPERATURE TO INSURE A TACK-FREE SURFACE
 2. AVAILABLE IN 1, 5, OR 55 GALLON QUANTITIES OR MAY BE PURCHASED IN PROPORTIONAL RESIN-CATALYST PLASTIC BAG PACKAGES (50, 100, 200, 300, 400, OR 500 GRAMS).

REQ. PER UNIT
 MODEL HFA-1
 USED ON
 ASSY. NO.
 DATE
 GL-131

- MIXING INSTRUCTIONS**
 1. MIX ENTIRE CONTENTS OF THE SHIPPING CONTAINER TO A UNIFORM CONSISTENCY.
 2. WEIGH OUT THE DESIRED AMOUNT OF RESIN AND ADD 7 PARTS OF CATALYST, BY WEIGHT, TO EACH 100 PARTS OF RESIN. MIX THOROUGHLY.
 3. POUR COMPOUND INTO FORM.
 4. CURE AT THE FOLLOWING SCHEDULES:

- 70°F (22°C) - 8 HOURS
- 160°F (72°C) - 1 HOUR
- 200°F (93°C) - 30 MINUTES
- 250°F (121°C) - 15 MINUTES

TMC PART NUMBER SHALL BE IN THE FOLLOWING FORM:

GL-131 - 0
 BASIC NO. COLOR (SEE CHART)

CODE	COLOR
0	BLACK
1	BROWN
2	RED
3	ORANGE
4	YELLOW
5	GREEN
6	BLUE
9	WHITE

MFG. REF.: RESIN - STYCAST 3050, CATALYST - #9

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		CAMARDA DEWEY	
		THE TECHNICAL MATERIEL CORP. MAMARONECK. NEW YORK	
		STOCK SIZE	
		MATERIAL	
		COMPOUND, POTTING	
		G.D.L	
		DRAWN	
		CHECKED	
		HEAT TREAT. SPEC.	
		FINISH & SPEC. NO.	
		S401-229	
		DATE	
		CH. NO.	
		DRAFTS CHECKER	
		ENG. APP.	
		SCALE	
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	
		FRACTIONS	
		TOLERANCES	
		± 1/64	
		ANGLES	
		± 0° 30'	
		DECIMALS	
		X ± .05	
		XX ± .01	
		XXX ± .005	
		MECH. DES. APP.	
		MECH. DES. APP.	
		FINAL APPROVAL	
		GL-131	

APPLICATION			REVISIONS							
QTY	MODEL USED ON	ASS'Y NO.	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD	
			Ø	ORIGINAL RELEASE FOR PRODUCTION	2/27/67	Ø	C.V.			

SPECIFICATIONS

SPECIFIC GRAVITY (ASTM D 1810): 2.30 MIN

THERMAL CONDUCTIVITY (ASTM D 1674): 0.0005 CAL/SEC/CM²/°C/CM MIN

WATER ABSORPTION (ASTM D 570): 0.1% MAX

BLEED (MIL-S-8660 @ 24 HOURS @ 200°C): 1.5% MAX

DIELECTRIC STRENGTH (ASTM D 150): 10 MIL THICKNESS 500 V/MIL MIN
50 MIL THICKNESS 225 V/MIL MIN

DIELECTRIC CONSTANT (ASTM D 150 @ 1Kc): 4.5 MAX

DISSIPATION FACTOR (ASTM D 150): 400 CPS 0.0005 MAX
1.0 Kc 0.005 MAX
100 Kc 0.005 MAX

VOLUME RESISTIVITY (ASTM D 257): 10¹² OHM-CM MIN

ARC RESISTANCE (ASTM D 495): 30 SECONDS MIN

COLOR: WHITE, OPAQUE

APPEARANCE: SHALL BE HOMOGENEOUS & FREE FROM LUMPS & COARSE PARTICLES. THERE SHALL BE NO SEPARATION OF FILLER WHICH CANNOT BE READILY DISPERSED.

HEAT RESISTANCE: WILL NOT DRY OUT, HARDEN, OR MELT AT 200°C.

SHELF LIFE: INDEFINITE AT 80°F

COEFFICIENT OF THERMAL EXPANSION: 0.00096 IN/IN/°C

CONSISTANCY, WORKED (ASTM D 217): 250-340

THERMAL RESISTANCE STABILITY: +20% MAX AFTER 100 DAYS, THEREAFTER NO CHANGE



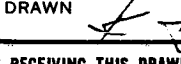
REFERENCE: BUWEPS #64A5A75

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.	
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005	FRACTIONS 1/64 ANGLES 0°-30'	LIST OF MATERIAL					
S401-446 (120)		FINAL APP. <i>[Signature]</i>	DATE 2/27/67	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK COMPOUND, SILICONE, HEAT SINK			
S401-40 (641)		MECH. DES. <i>[Signature]</i>	DATE				
S401-408 (XL500)		ELECT. DES. <i>[Signature]</i>	DATE 2/14/67				
		CHECKED <i>[Signature]</i>	DATE 2-1-67				
		DRAWN <i>[Signature]</i>	DATE	SIZE A	CODE IDENT. NO. 82679	DWG NO. GL 138	ISSUE Ø
<p align="center">NOTICE TO PERSONS RECEIVING THIS DRAWING THE TECHNICAL MATERIEL CORPORATION claims proprietary right in the material disclosed hereon. This drawing is issued in confidence for engineering information only and may not be reproduced or used to manufacture anything shown hereon without permission from THE TECHNICAL MATERIEL CORPORATION to the user. This drawing is loaned for mutual assistance and is subject to recall at any time.</p>				SCALE	SHEET	OF	

APPLICATION			REVISIONS						
QTY	MODEL USED ON	ASS'Y NO.	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	DDRR-10K		X	EXP. RELEASE	10/7/69			LH	MD
			Ø	ORIGINAL RELEASE	10/17/69			W	

TMC MFG CODE #: S 401 - 506
MFG P/N : QUELSPRAY (CLEAR)

DESCRIPTION: VINYL SPRAY, AIR DRY, CLEAR
1 LB PRESSURIZED SPRAY CAN.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.	
<small>DECIMALS</small> .X ± .05 .XX ± .01 .XXX ± .005 <small>FRACTIONS</small> 1/64 ANGLES 0° - 30'		LIST OF MATERIAL					
MATERIAL		<small>FINAL APPROVAL</small> 		<small>DATE</small> 10/17/69		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK VINYL SPRAY, CLEAR (AIR DRY)	
FINISH		<small>MECH. DES.</small>		<small>DATE</small>			
		<small>ELECT. DES.</small>		<small>DATE</small>			
		<small>CHECKED</small> 		<small>DATE</small> 10/9/69			
		<small>DRAWN</small> 		<small>DATE</small> 10/7/69			
<small>NOTICE TO PERSONS RECEIVING THIS DRAWING</small> THE TECHNICAL MATERIEL CORPORATION claims proprietary right in the material disclosed hereon. This drawing is issued in confidence for engineering information only and may not be reproduced or used to manufacture anything shown hereon without permission from THE TECHNICAL MATERIEL CORPORATION to the user. This drawing is loaned for mutual assistance and is subject to recall at any time.				<small>SIZE</small> A	<small>CODE IDENT. NO.</small> 82679	<small>DWG NO.</small> GL 140	<small>ISSUE</small> Ø
				<small>SCALE</small>	<small>SHEET</small>		<small>OF</small>

APPLICATION			REVISIONS						
QTY	MODEL USED ON	ASS'Y NO.	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	DDRR-10K	RAK127	X	EXPERIMENTAL RELEASE	10/17/69	—	CV		
	DDR-10K	RAK127	Ø	ORIGINAL RELEASE	10/17/69		CV		

MFR (TMC CODE NO.): S401-502

MFR PART NUMBER: #4900 CONDUCTIVE COATING RESIN
CONSISTS OF ONE (1) 6 OZ CAN

<small>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES</small> <small>DECIMALS FRACTIONS</small> <small>.X ± .05 TOLS. 1/64</small> <small>.XX ± .01 ANGLES</small> <small>.XXX ± .005 0° -30'</small>	REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.	
	LIST OF MATERIAL					
	MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK				
	FINISH	RESIN, CONDUCTIVE COATING				
	<small>NOTICE TO PERSONS RECEIVING THIS DRAWING</small> <small>THE TECHNICAL MATERIEL CORPORATION claims proprietary right in the material disclosed hereon. This drawing is issued in confidence for engineering information only and may not be reproduced or used to manufacture anything shown hereon without permission from THE TECHNICAL MATERIEL CORPORATION to the user. This drawing is loaned for mutual assistance and is subject to recall at any time.</small>			SIZE A	CODE IDENT. NO. 82679	DWG NO. GL 141
			SCALE	SHEET		OF

APPLICATION			REVISIONS						
QTY	MODEL USED ON	ASS'Y NO.	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD	APPD
	DDRR-10K	RAK127	X	EXPERIMENTAL RELEASE	10/19/69		CV		
	DDR-10K	RAK127	Ø	ORIGINAL RELEASE	10/17/69		Ø		

MFR(TMC CODE NO.): S401-503

MFR PART NUMBER: #CE-2700 CONDUCTIVE EPOXY
 CONSISTS OF: 1 OZ. TUBE PART A
 1 OZ. TUBE PART B

PHYSICAL AND ELECTRICAL PROPERTIES

VOLUME RESISTIVITY: .001 OHM cm (APPROX)
 TENSILE SHEAR STRENGTH @25°C (STEEL TO STEEL): 2200 psi

SPECIFIC GRAVITY: 2.2
 COLOR: SILVER
 POT LIFE (AFTER MIXING PARTS A & B): 4 TO 6 HOURS FOR 20-GRAM BATCH

STORAGE LIFE (PARTS A & B NOT MIXED): 6 MONTHS
 CURE TIME: AT 25°C 24-36 HOURS
 AT 65°C 4 HOURS
 AT 100°C 15 MINUTES

DIRECTIONS:

1. SQUEEZE APPROXIMATELY EQUAL PARTS A & B. (EITHER BY VOLUME OR WEIGHT; THE DENSITIES OF BOTH ENDS ARE SIMILAR, AND PROPORTIONS ARE NOT CRITICAL).
2. MIX THE TWO PARTS THOROUGHLY
3. TO BOND GASKET, APPLY IN THIN LINE OR 1/8" DIAMETER SPOTS.
4. SET GASKET ON TOP OF APPLIED EPOXY AND CLAMP DOWN OR WEIGHT DOWN.
5. ALLOW TO CURE (HEAT WILL ACCELERATE).

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		REQ'D	ITEM	PART NUMBER	DESCRIPTION	SYM.
LIST OF MATERIAL						
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005 TOLS.		FRACTIONS 1/64 ANGLES 0° 30'		THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK		
MATERIAL		MECH. DES.		DATE	EPOXY, CONDUCTIVE	
FINISH		ELECT. DES.		DATE		
		CHECKED <i>MJB</i>		DATE 10/19/69		
		DRAWN <i>CU</i>		DATE 10/17/69		
NOTICE TO PERSONS RECEIVING THIS DRAWING THE TECHNICAL MATERIEL CORPORATION claims proprietary right in the material disclosed hereon. This drawing is issued in confidence for engineering information only and may not be reproduced or used to manufacture anything shown hereon without permission from THE TECHNICAL MATERIEL CORPORATION to the user. This drawing is loaned for mutual assistance and is subject to recall at any time.				SIZE A	CODE IDENT. NO. 82679	DWG NO. GL 142
				SCALE	SHEET	ISSUE Ø
					OF	

IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

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

STANDARD DRAWING

OL-10002

USED ON

PROJECT NO. ASS'Y. NO. DATE

28/6/61

MATERIAL	NAME	SUPPLIERS
Resin	Laminac # 4116	Cyanamid of Canada.
Accelerator	Cobalt Napthenate 6%	1. } Nuodex Co., Toronto. 2. } W.C. Hardesty. 3. } O.P.W. Paints Limited
Fillter	ASP-400	Alkali Co., Cleveland 14, Ohio.
Catalyst	1.) Laminac Catalyst # 347 2.) Lupersol: (60% Methyl Ethyl Ketone in Dimethyl Pthalate)	1.) Lucidol Division, Novadel-Agene Corp., 1740 Military Road, Buffalo 5, NY. 2.) J.H. Connor & Son Ltd., 207 Montcalm, Hull, P.Q.
Solvent	1.) Styrene thinners 2.) Laminac clean-up solvent # 3776	

REVISED

OCT 8 1963

NOTE: FOR PREPARATION SEE SPEC. S-10072

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
		TMC (Canada) LIMITED	ONTARIO
		LAMINAC COLD POTTING	
STOCK SIZE			
MATERIAL	WEIGHT PER PC.		
TYPE & TEMPER			
HEAT TREAT. SPEC.			
FINISH & SPEC. NO.			GL-10002

RWT/hh DRAWN
 ELEC. DES. APP. MECH. DES. APP.
 FINAL APPROVAL

ISSUE ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
TOLERANCES						
SCALE						
DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED						
DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURER TOLERANCES ARE NOT INCLUDED.						
ALL OTHERS	DEC. DIM. ±	FRAC. DIM. ±	ANGULAR DIM. ±			

GL 10004

ISSUE	ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.	REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL																				
											<p>1.0 <u>Description</u></p> <p>Hysol 4362/3404 is a room temperature cure, low viscosity, liquid epoxy system for encapsulating or potting electrical and electronic components. It is slightly resilient to provide shock resistance, and to reduce stress on the encapsulated components.</p> <p>2.0 <u>Characteristics</u></p> <table style="width:100%; border:none;"> <tr> <td style="width:60%;">Density, #/cu.in.</td> <td style="width:40%; text-align:right;">.051</td> </tr> <tr> <td>Tensile Strength, p.s.i.</td> <td style="text-align:right;">4,000</td> </tr> <tr> <td>Compressive Strength, p.s.i.</td> <td style="text-align:right;">12,000</td> </tr> <tr> <td>Operating Class (AIEE)</td> <td style="text-align:right;">A</td> </tr> <tr> <td>Colour</td> <td style="text-align:right;">Ivory</td> </tr> <tr> <td>Linear Shrinkage %</td> <td style="text-align:right;">0.9</td> </tr> <tr> <td>Elongation, %</td> <td style="text-align:right;">3</td> </tr> </table> <p>3.0 <u>Handling</u></p> <table style="width:100%; border:none;"> <tr> <td style="width:45%;">Mixing Ratio, by weight</td> <td style="width:55%; text-align:right;">100 : 7 (4362:3404)</td> </tr> <tr> <td>Pot Life, Minutes, at 25°C</td> <td style="text-align:right;">30</td> </tr> <tr> <td>Viscosity, cps.</td> <td style="text-align:right;">6,000</td> </tr> </table> <p>Weigh, mix, deair if necessary and cast at room temperature.</p> <p><u>Caution:</u> Avoid contact with skin and eyes and use with good ventilation to draw fumes away from operator.</p> <p>4.0 <u>Cure</u></p> <p style="text-align:center;">24 hours @ R/T or 2 hours @ 60°C.</p>	Density, #/cu.in.	.051	Tensile Strength, p.s.i.	4,000	Compressive Strength, p.s.i.	12,000	Operating Class (AIEE)	A	Colour	Ivory	Linear Shrinkage %	0.9	Elongation, %	3	Mixing Ratio, by weight	100 : 7 (4362:3404)	Pot Life, Minutes, at 25°C	30	Viscosity, cps.	6,000	
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TMC(Canada)LIMITED OTTAWA ONTARIO																																
EPOXY ENCAPSULATING SYSTEM																																
SHOCK RESISTANT																																
DRAWN <i>P M</i> ELEC. DES. APP. <i>W</i> MECH. DES. APP. <i>W</i>																																
CHECKED <i>R De</i> FINAL APPROVAL																																
FINISH & SPEC. NO. GL10004																																
STANDARD DRAWING																																

GL10006

ISSUE	ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.	REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
Ø		REL. TO PROD.	29/6/67		A.P.							

1201 RTV primer is an air-drying silicone primer that improves the adhesion of RTV silicone rubber to various substrates. The primer is supplied as a dilute solution in acetone.

STORAGE OF THE PRIMER
 After priming operation is completed, any remaining Silastic 1201 RTV primer should be returned to a sealable container as soon as possible for storage. The container should be kept tightly sealed when not in use. The primer evaporates rapidly when exposed to air.

TYPICAL PHYSICAL CHARACTERISTICS

- Colour Straw
- Viscosity at 77 F, centipoises Less than 1
- Specific Gravity 0.82
- Flash Point 5 F
- Solvent Acetone
- Pounds per gallon 6

WARNING

The solvent used in 1201 RTV primer is extremely flammable. It should be applied only in a well ventilated area, and kept away from heat, sparks and open flame.

The formulation may also be severely irritating to the eyes. In case of eye contact, flush with water for at least 15 minutes; obtain prompt medical attention.

STANDARD DRAWING

MODEL		PROJECT NO.	DATE	29 June 67		TMC (Canada) LIMITED OTTAWA ONTARIO	
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES		USED ON		1201 RTV PRIMER		DRAWN P A M	
IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.		SCALE		ELEC. DES. APP.		MECH. DES. APP.	
TOLERANCES		DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED		FINISH APPROVAL		Ø	
DEC. DIM. ±		DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.		DRAWN		GILLOO06	
FRAC. DIM. ±				CHECKED			
ANGULAR DIM. ±				P A M			

5610007

STANDARD DRAWING

Rocol Core Locking Compound # 8, Extra "G"
 Manufacturer S 10045 - 64

NOTE: If difficulty is experienced in applying a small amount of compound to finely threaded cores, heat the compound to about 100°C.
 At this temperature it will melt, and have thinned out sufficiently to permit the proper amount to be applied and for the insides of the threads to be properly covered.

ISSUE	ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. AN.	REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL		
Ø		REL. TO PROD	NOV 28/67		RPL	JW	JW							
USED ON														
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES			IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.			PROJECT NO.			NOV 28/67			DATE		
TOLERANCES			SCALE			ASS'Y. NO.			STOCK SIZE			TMC(Canada)LIMITED OTTAWA ONTARIO		
DEC. DIM. ±			DIMENSIONS IN INCHES			MATERIAL			MATERIAL			COMPOUND, CORE LOCKING		
FRAC. DIM. ±			UNLESS OTHERWISE SPECIFIED			TYPE & TEMPER			TYPE & TEMPER			DRAWN		
ANGULAR DIM. ±			DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.			HEAT TREAT. SPEC.			HEAT TREAT. SPEC.			CHECKED		
ALL OTHERS						FINISH & SPEC. NO.			FINISH & SPEC. NO.			ELEC. DES. APP.		
												MESH. DES. APP.		
												FINAL APPROVAL		
												GL 10007		

ISSUE	ITEM	CHANGED FROM	DATE	CM. NO.	DRAFTS	CHECKER	ENG. APP.	REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X		ENG RELEASE	23 Jan 72		C.C.		HCS					
<p>MIXING RATIO PARTS BY WEIGHT</p> <p>PART A (SILVER BASE) 15.0</p> <p>PART B (HARDENER) 1.6</p> <p>STIR PART A (SILVER BASE) IN CONTAINER THOROUGHLY BEFORE USING</p> <p>CURING SCHEDULE - (USE ANYONE OF THE FOLLOWING)</p> <p>150°C 1/2 HOUR</p> <p>100°C 1 HOUR</p> <p>80°C 2 HOURS</p> <p>60°C 4 HOURS</p> <p>ROOM TEMPERATURE 2 TO 3 DAYS</p> <p>POT LIFE - AT LEAST 8 HOURS</p> <p>VOLUME RESISTIVITY (COMPARATIVE METHOD) 11.0 BTU IN/FT. 2 HR. °F</p> <p>THERMAL CONDUCTIVITY (COMPARATIVE METHOD) 0.0001 TO 0.0005 OHM-CM</p>												
<p>FOR FURTHER INFORMATION REFER TO "EPOXY TECHNOLOGY, BULLETIN "EPO-TEK 410"</p>												
<p>TMC (Canada) LIMITED OTTAWA ONTARIO</p>												
<p>ELECTRICALLY CONDUCTIVE EPOXY</p>												
<p>C. CHARLES</p>												
<p>DRAWN ELEC. DES. APP. MECH. DES. APP.</p>												
<p>CHECKED FINAL APPROVAL</p>												
<p>GL 10009 X</p>												