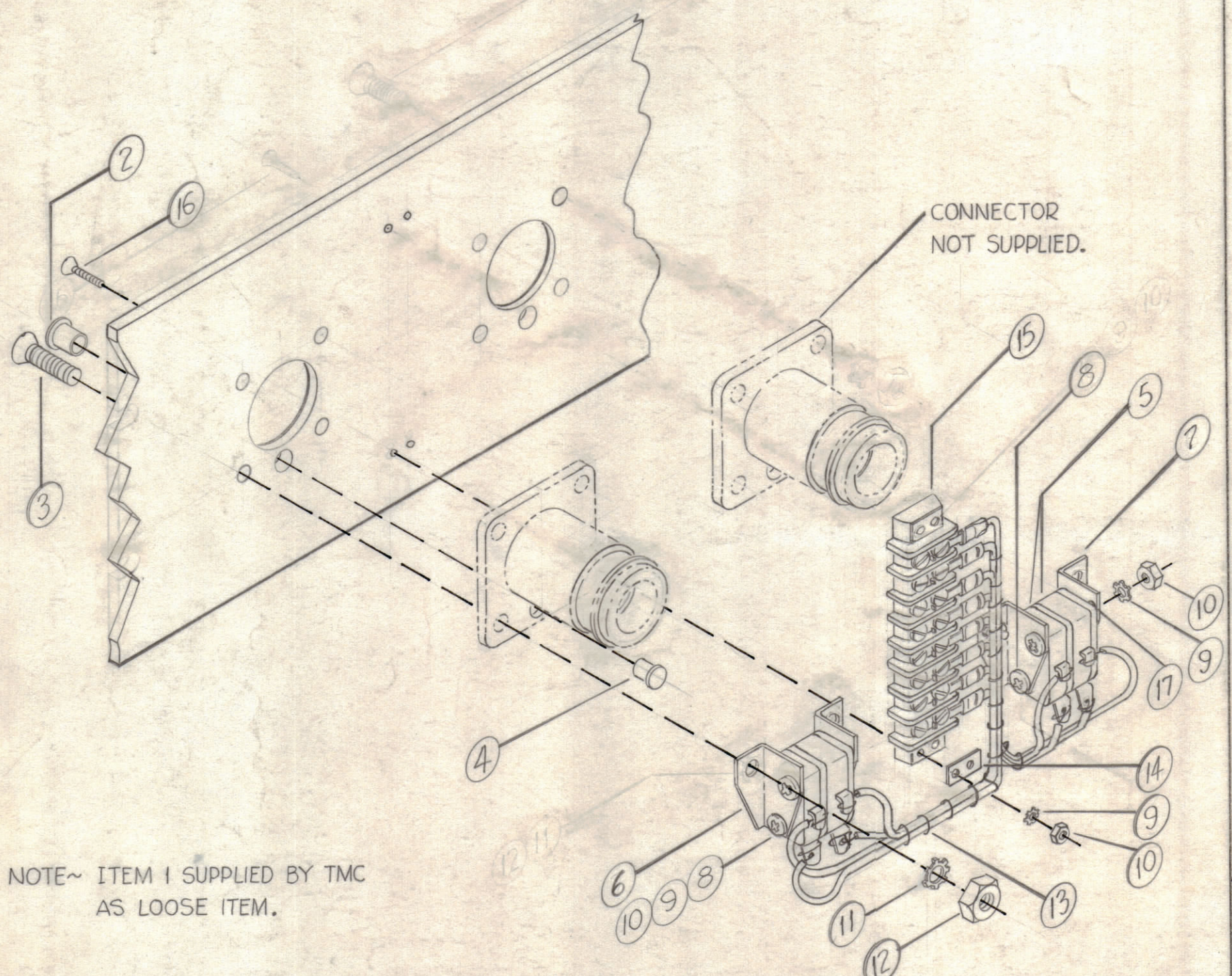


REVISIONS						
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD
B2	A	ITEM(2) WAS BB-111, ITEM(3) WAS SCFPI032BN0	6-8-62	6782	V.R.K.	
A1	B	PART NO. WAS ID-278; QDL ADDED TO TITLE	10-24-62	7499	ESG	
	C	ON FIG 1 CALLOUTS REVERSED 6 & 7	8-16-72	20826	GE	

FIGURE - 1 (Rear of Panel)



NOTE~ ITEM 1 SUPPLIED BY TMC AS LOOSE ITEM.

ASSEMBLY INSTRUCTIONS

1. Remove connectors from original panel.
2. Layout, drill and counter sink additional holes in original panel (see figure 2).
3. Press fit panel bearings (2, figure 1) carefully. Make certain that switch contacts (4) move freely, without binding.
4. Position connectors and jack switch assembly on panel as shown in figure 1. Install machine screws (3 and 16), straddle plate (14), lockwashers (9), and nuts (10).
5. Loosen screws (8). Move micro-switches (5) toward switch contacts (4) until switch buttons touch switch contacts but do not activate the micro-switches.
6. Tighten screws (8).
7. Make certain that cable (13) is assembled and soldered as shown in figure 3.

C'SINK FOR 10-32 FLAT HEAD SCREW

DRILL .246 AND PRESS FIT OF BRONZE BEARINGS FROM FRONT OF PANEL.

DRILL & C'SINK FOR 4-40 FLAT HEAD SCREW

FIGURE 2 (Front of Panel)

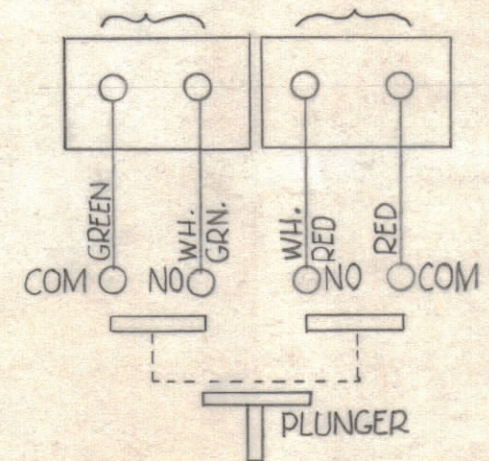
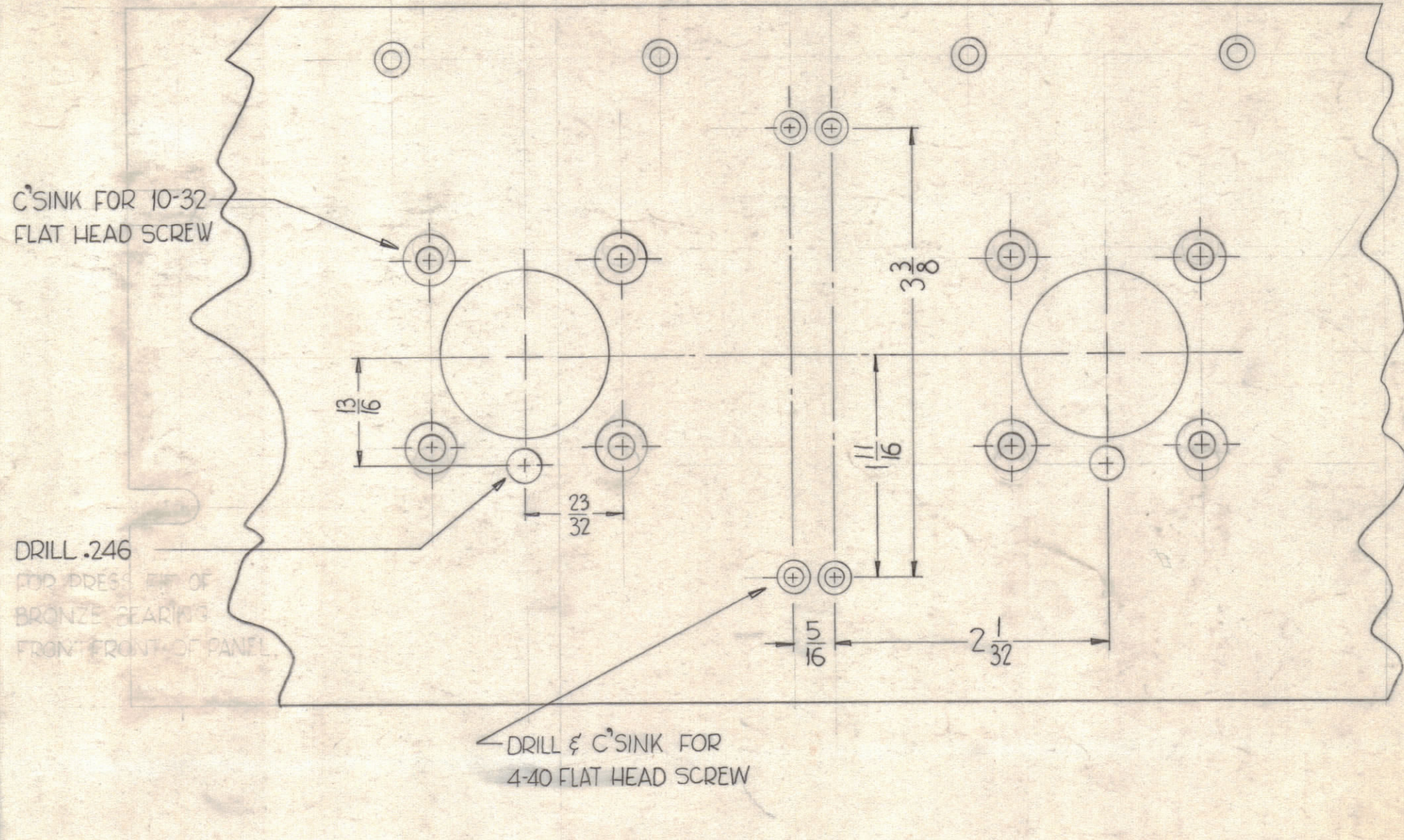


DIAGRAM OF REPRESENTATIVE SWITCH ASS'Y.

CONTACT RATING : 1/2 AMP 125 V.DC
10 AMPS 125 V.AC

FIGURE ~ 3

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
8	17	WA-109-17	WASHER, FIBRE	
4	16	SCFP0440BN10	SCREW, MACHINE	
1	15	TM-102-8	TERMINAL STRIP, BARRIER TYPE	
2	14	MS-154-1	PLATE, STRADDLE	
1	13	CA-345	CABLE	
8	12	NTH1032BN12	NUT, HEX.	
8	11	LWE10MRN	LOCKWASHER, EXT.	
8	10	NTH0440BN6	NUT, HEX.	
8	9	LWE04MRN	LOCKWASHER, EXT.	
4	8	SCBPO440BN18	SCREW, MACHINE	
2	7	MS-986	BRACKET, SWITCH, LEFT	
2	6	MS-987	" " " " , RIGHT	
4	5	SW-189	SWITCH, MICRO	
2	4	PM-427-1	CONTACT, SWITCH	
8	3	SCFPI032BN10	SCREW, MACHINE	
2	2	BB-115	BEARING, PANEL	
1	1	TM-105-8AR	FANNING STRIP (Not Illustrated)	

PRITCHARD

LIST OF MATERIAL

MATERIAL	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
FINISH	TITLE INSTALLATION DETAILS QDL JACK SWITCH ASSEMBLY			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES	DRAWN D.H.	DATE 4/11/62	FINAL APPROVAL BP	DATE
DECIMALS X ± .05 .XX ± .01 .XXX ± .005	CHECKED H.D.	DATE 4/11/62	DATE	KIT-137
FRACTIONS ± 1/64 ANGLES ± 0° 30'	ELECT. DES.	DATE	SHEET	C
TOLERANCES	MECH. DES.	DATE	REV. LTR.	

NOTES

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KIT-137