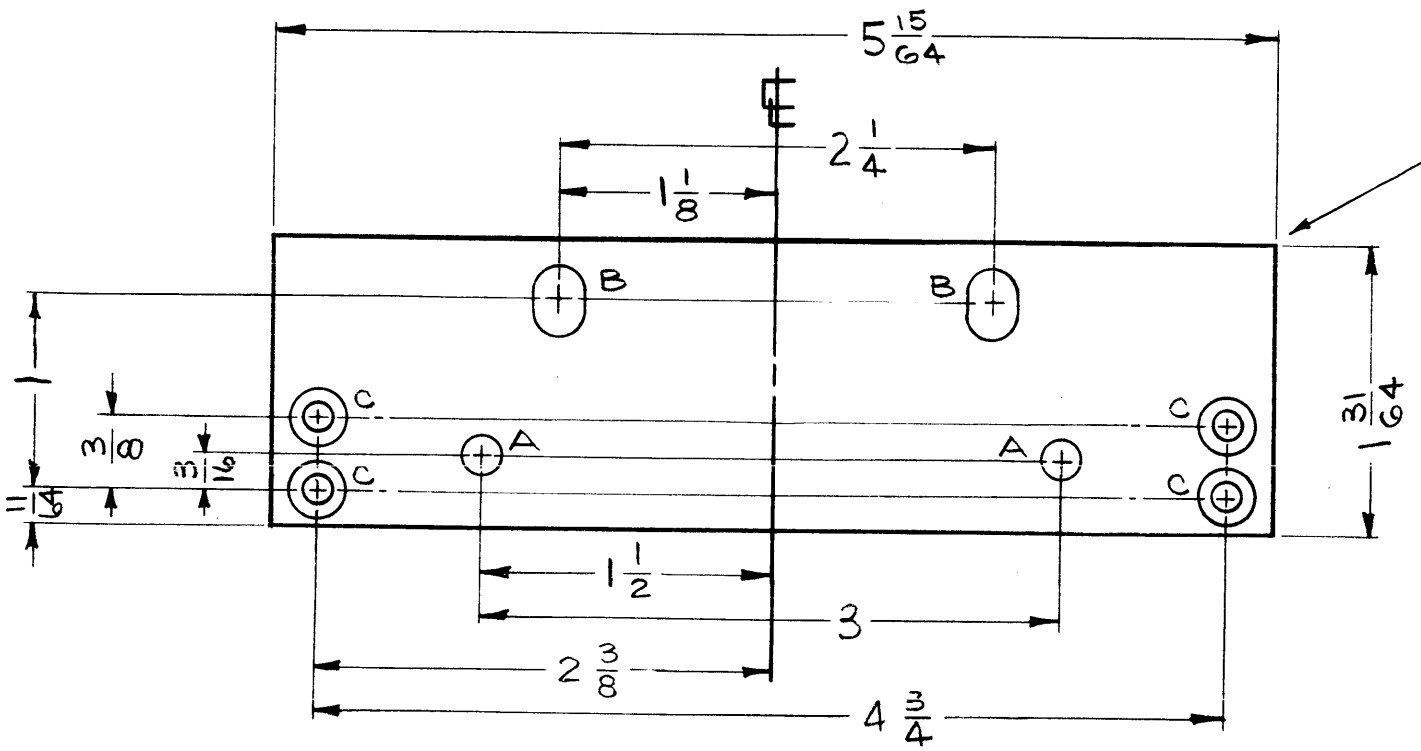


MS-3451

REVISIONS						
SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD



METAL STAMP TMC PART NO.  
1/8 HIGH GOTHIC, ON REAR (MS-3451)

LEGEND		
HOLE	DESCRIPTION	REQ
A	3/16 DIA.	2
B	1/4 x 3/8 SLOTS	2
C	.144 DIA. HOLE, C'SINK 82° TO .284 DIA.	4

FRONT OF PANEL SHOWN

**MACHINING:**

1. MILL ALL EDGES.
2. HOLES MUST BE DRILLED, UNLESS OTHERWISE SPECIFIED.
3. LATERAL BOW OF PANEL MUST BE KEPT TO .031 TOLERANCE.
4. PANEL MUST BE FREE OF ALL MACHINING MARKS, GOUGES AND SCRATCHES. IF NECESSARY, SAND FRONT OF PANEL WITH NO. 120 GRIT SANDPAPER.

**FINISH NOTES:**

1. S404 - IRIDIPT 14-2 AL-COAT.
2. S114 - ZINC CHROMATE PRIMER ) FRONT AND
3. S115 - SMOOTH GRAY ENAMEL ) EDGES ONLY

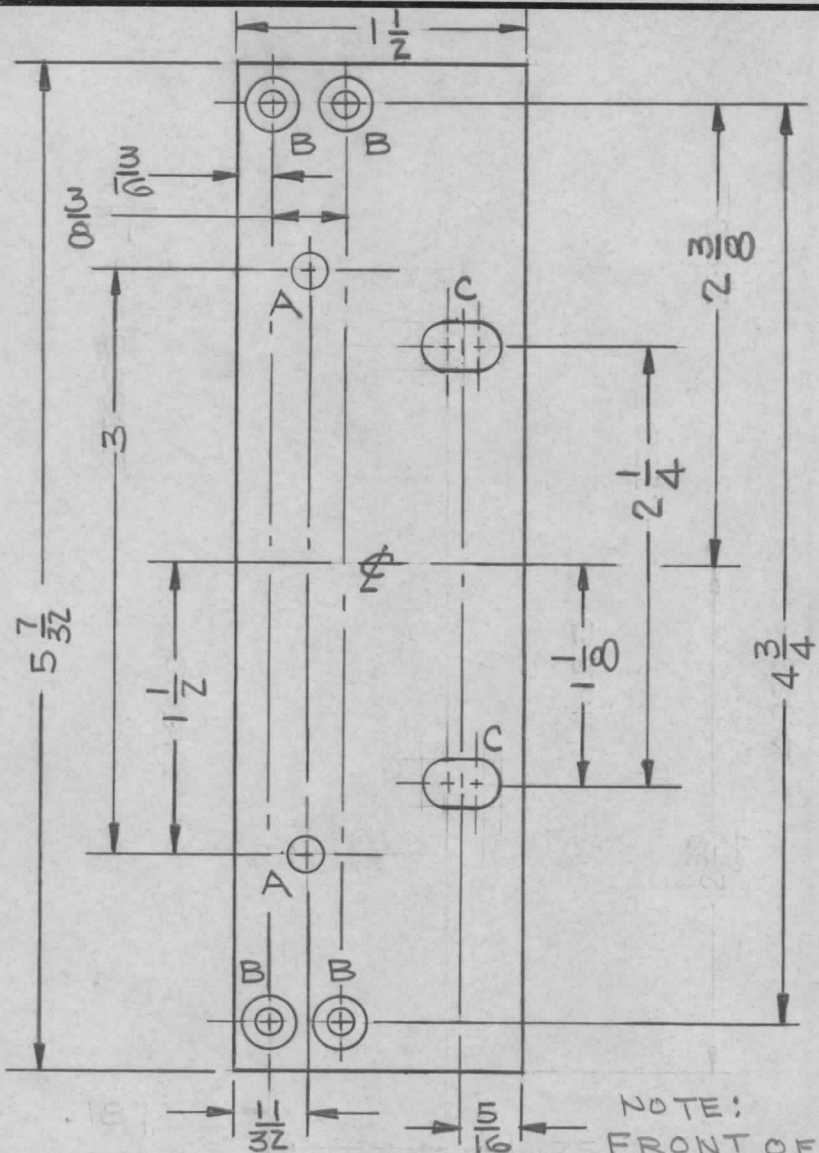
**NOTES**

2		
QTY./UNIT	MODEL USED ON	ASSY. NO.
SCALE 1:1	CODE	

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.

REF: TELE-SIGNAL MODEL 139

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
<b>I. JOHNSON LIST OF MATERIAL</b>				
MATERIAL 3/16, ALUMINUM 2024-T3			THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
FINISH SEE FINISH NOTES			TITLE PANEL, FRONT, SHELF	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES			DRAWN <i>G. Senem</i> DATE 7-25-63	FINAL APPROVAL <i>[Signature]</i> DATE
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005			CHECKED <i>[Signature]</i> DATE 7-26-63	DATE 7-27-63
FRACTIONS ± 1/64 ANGLES ± 0° 30'			ELECT. <i>[Signature]</i> DATE 7-27-63	MS-3451
TOLERANCES			MECH. <i>[Signature]</i> DATE 7-27-63	SHEET
				REV. LTR.



REQ. PER UNIT	USED ON			MS-3451	A
	MODEL	ASS'Y. NO.	DATE		
2	TMX-1,Z				

HOLE LEGEND		
LTR	DESCRIPTION	QTY
A	3/16 DIA DRILL	2
B	.144 DIA THRU & CSK 82° TO .284 DIA.	4
C	3/8 x 1/4 SLOT	2

**MACHINING:**

1. MILL ALL EDGES.
2. HOLES MUST BE DRILLED, UNLESS OTHERWISE SPECIFIED.
3. LATERAL BOW OF PANEL MUST BE KEPT TO .031 TOLERANCE.
4. PANEL MUST BE FREE OF ALL MACHINING MARKS, GOUGES AND SCRATCHES. IF NECESSARY, SAND FRONT OF PANEL WITH NO. 120 GRIT SANDPAPER.

**FINISH NOTES:**

1. S404 - IRIDITE 14-2 AL-COAT.
2. S114 - ZINC CHROMATE PRIMER) FRONT AND
3. S115 - SMOOTH GRAY ENAMEL ) EDGES ONLY

NOTE: FRONT OF PANEL SHOWN

							REQ. ITEM	PART NO.	JOHNSON	DESCRIPTION	SYMBOL	
								3/16 THICK	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK			
								ALUMINUM	PANEL, FRONT SHELF			
A	REDRAWN WITH NO CHANGES	9-5-63	9910	AK								
SYM	DESCRIPTION	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.	MATERIAL					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES		SCALE	1/1				2024-T4	RINALDI	9/5/63	FINAL APPROVAL		
DECIMALS .X ± .05 .XX ± .01 .XXX ± .005	TOLERANCES	FRACTIONS ± 1/64 ANGLES ± 0° 30'	CODE	SEE NOTE				DRAWN	CHECKED	MS-3451 A		
							FINISH & SPEC. NO.	ELEC. DES. APP.	MECH. DES. APP.			