

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

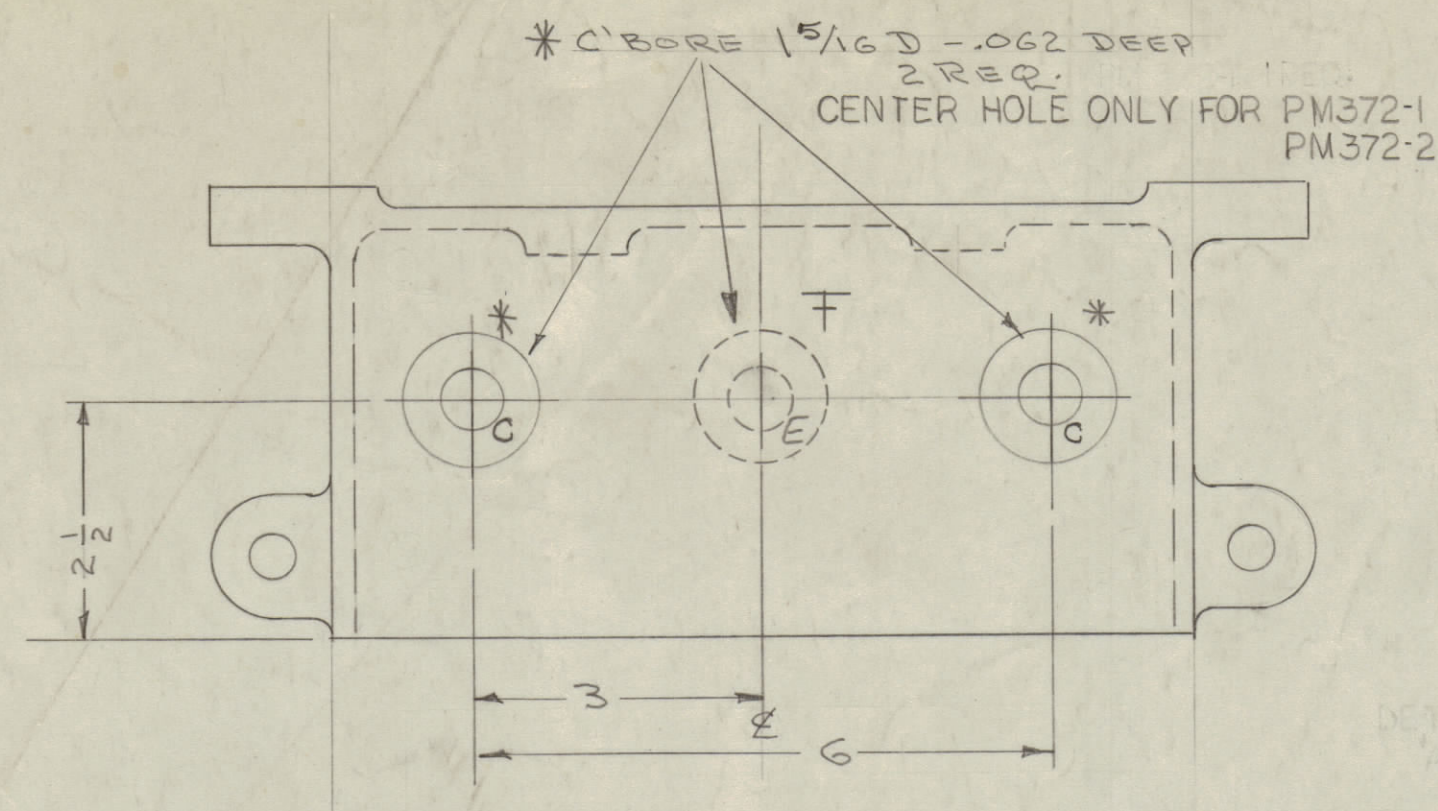
MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

NOTICE TO PERSONS RECEIVING THIS DRAWING

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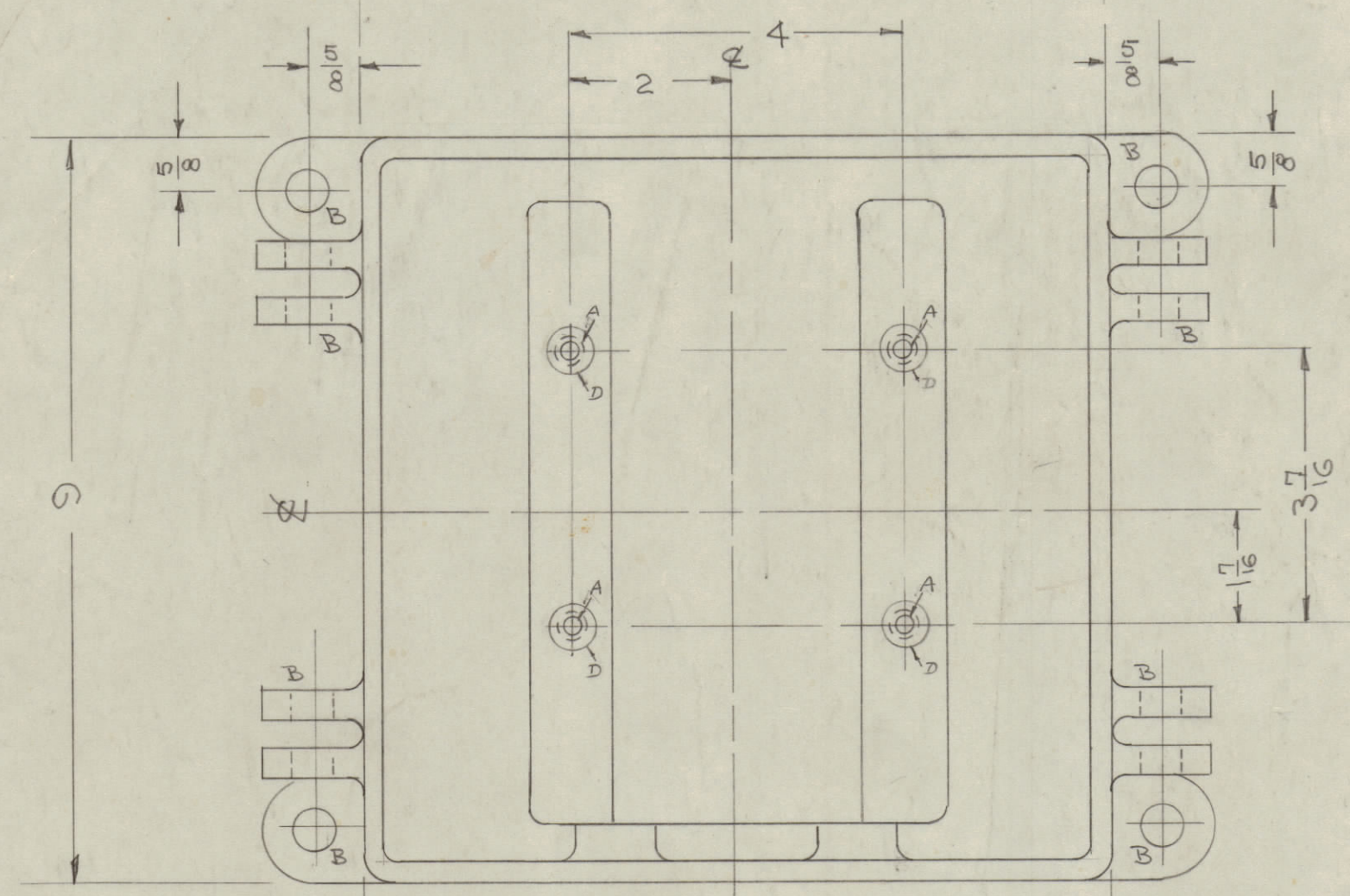
Property of:
THE TECHNICAL MATERIEL CORPORATION
MAMARONECK, NEW YORK

To Modify
for VRA-6
See Sheet 2



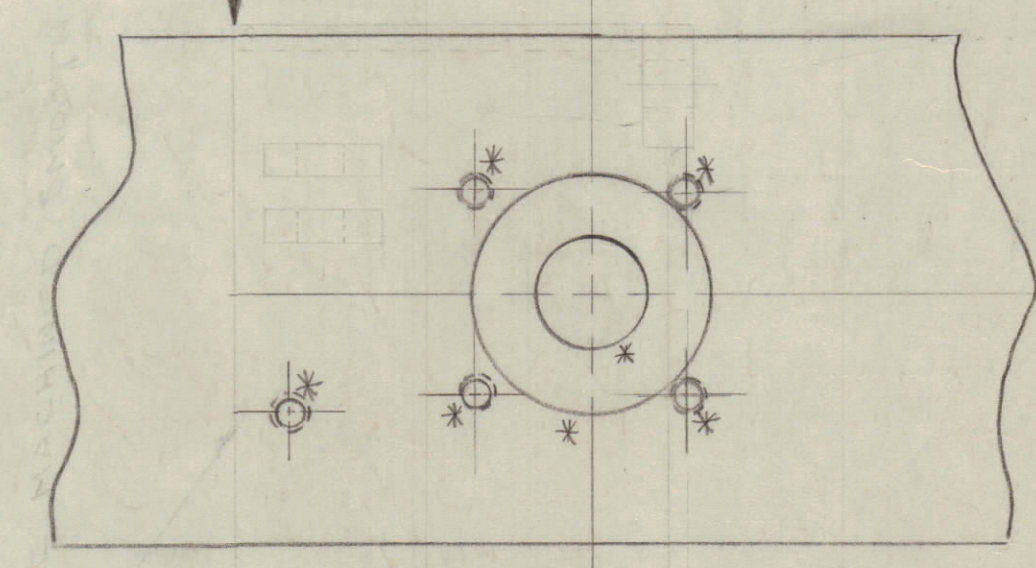
DELETE FOR PM372-1,2

LETTER	DESCRIPTION	REQ.	
A	8-32 BLIND TAP, 3/8 DEEP	4	
B	33/64 (.515) D	12	
C	5/8 (.625) D	2 *	PM 372
D	1/2 (.500) D. C'BORE SLIGHTLY TO REMOVE PAINT	5	
E	5/8 (.625) D RAC 46, RTB-20 ONLY	1 *	PM 372-1 PM 372-2



* NOTE FOR PM372-1,2. DELETE 2 "C" HOLES AND ADD 1 "E" HOLE

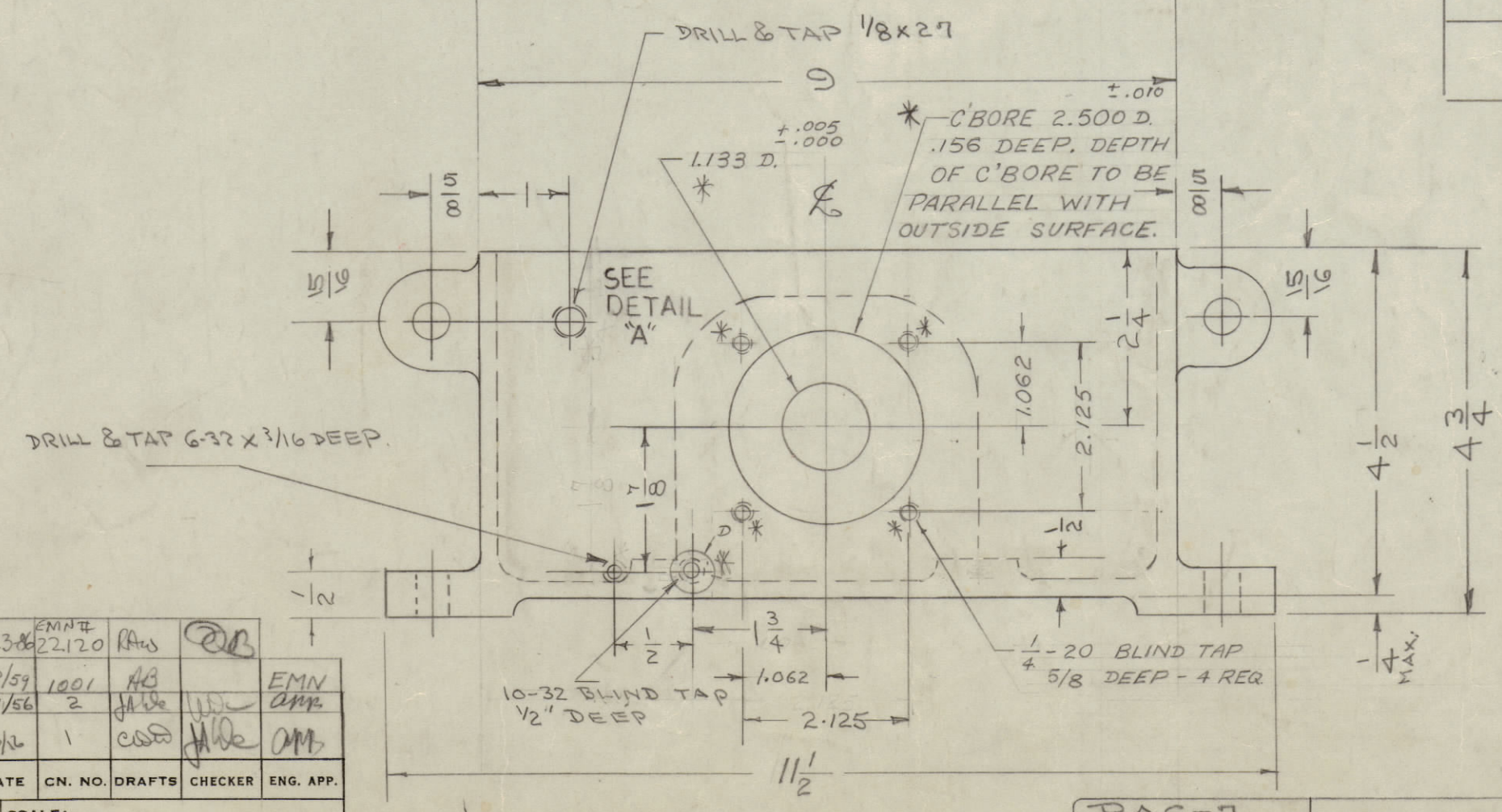
DO NOT DRILL HOLES SHOWN * IN DETAIL A. (PM372-2 ONLY)



PM-372 D

	USED ON
PM 372	RAC-7 RAC-18
PM 372-1	RAC-46
PM 372-2	RTB-20

DETAIL A



FINISH

S-404 - YELLOW IRIDITE
S-114 - ZINC CHROMATE PRIMER
S-115 - SMOOTH GREY ENAMEL

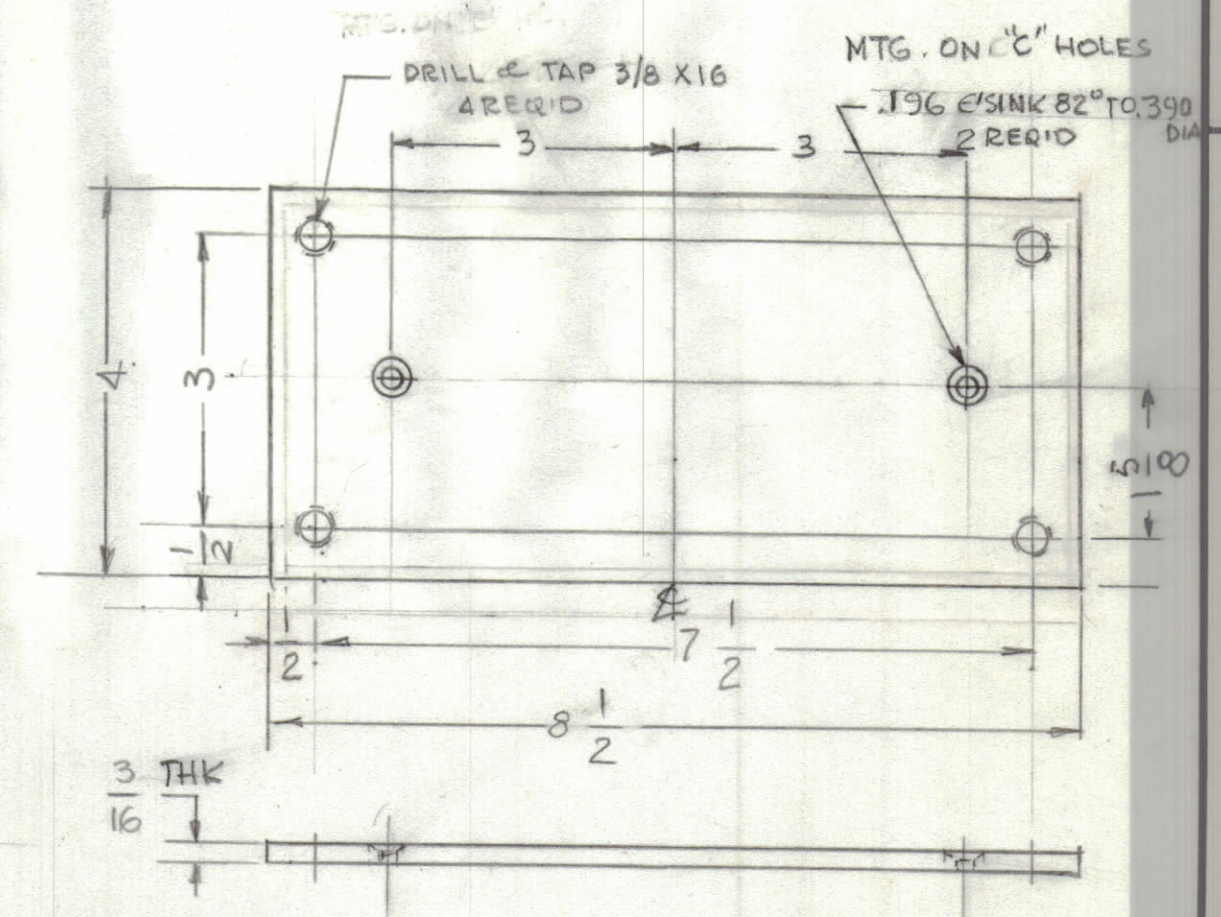
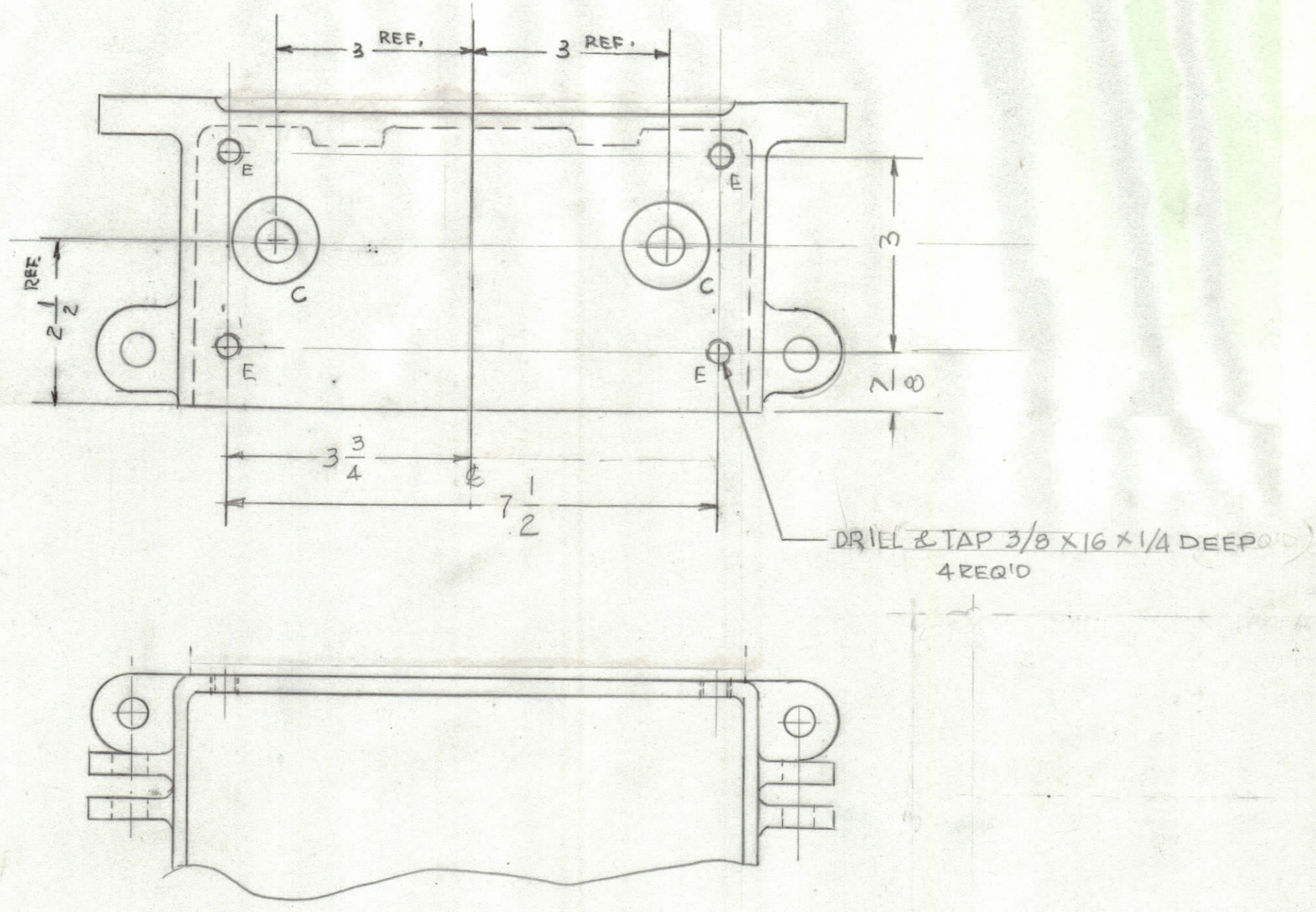
REF: CS-101

ISSUE	ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
D	1	ADD "E" HOLE / NOTE F	7-23-56	22120	AMW	AMB	
C	1	S-404 YEL. IRIDITE WAS S-101 CAUSTIC DIP	12/10/59	1001	AG	AMB	EMN
B	1	3/8 X 2.7 TAP WAS 3/8 X 1.6 TAP	11/1/56	2	JL	AMB	
A	2	3/8 X 1.6 TAP. ADDED	6/1/56	1	CSW	AMB	
A	1	6-32 X 3/16 DEEP.					

MODEL	PROJECT NO.	ASS'Y. NO.	DATE
RAC-7 RAC-18		A-1354	10-29-56
			11/4/55

REQ. ITEM	PART NO.	DESCRIPTION	SYMBOL
THE TECHNICAL MATERIEL CORP.			
MAMARONECK, NEW YORK			
CASE MACHINING			
MODEL RAC-18			
STOCK SIZE		DRAWN	
MATERIAL		ELEC. DES. APP.	
WEIGHT PER PC.		MECH. DES. APP.	
TYPE & TEMPER		CHECKED	
HEAT TREAT. SPEC.		FINAL APPROVAL	
SEE NOTE		SHEET 1 OF 2	
FINISH & SPEC. NO.		PM 372-1 E	

REVISIONS						
ZONE	LTR	DESCRIPTION	DATE	E.M.N.NO	DRAFT	CHKD APPD
F		SHEET 2 ADDED				



MATERIAL:
 3/16TH ALUM 356-T6
 FINISH:
 S404 YEL IRIDIOTE
 S114 ZINC CHROMATE PRIMER
 S115 SMOOTH GREY ENAMEL

RAC-7		A 1354
RAC-18		
QTY / UNIT	MODEL USED ON	ASS'Y NO.
APPLICATION		
CODE		

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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND INCLUDE CHEMICALLY APPLIED OR PLATED FINISHES

TOLERANCES ON

DECIMALS	FRACTIONS
.X ± .05	± 1/64
.XX ± .01	ANGLES
.XXX ± .005	± 0° -30'

MATERIAL	
FINISH	

QTY. REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
LIST OF MATERIAL				
FINAL APPROVAL		DATE	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK CASE MACHINING MODEL RAC-18 MODIFIED FOR VRA 5	
MECH. DES.		DATE		
ELECT. DES.		DATE		
CHECKED		DATE		
DRAWN		DATE		
		GDL	6-25-92	
SIZE	CODE	IDENT. NO.	DWG NO.	ISSUE
C		82679	PM 372	F
SCALE		1/2		SHEET 2 OF 2

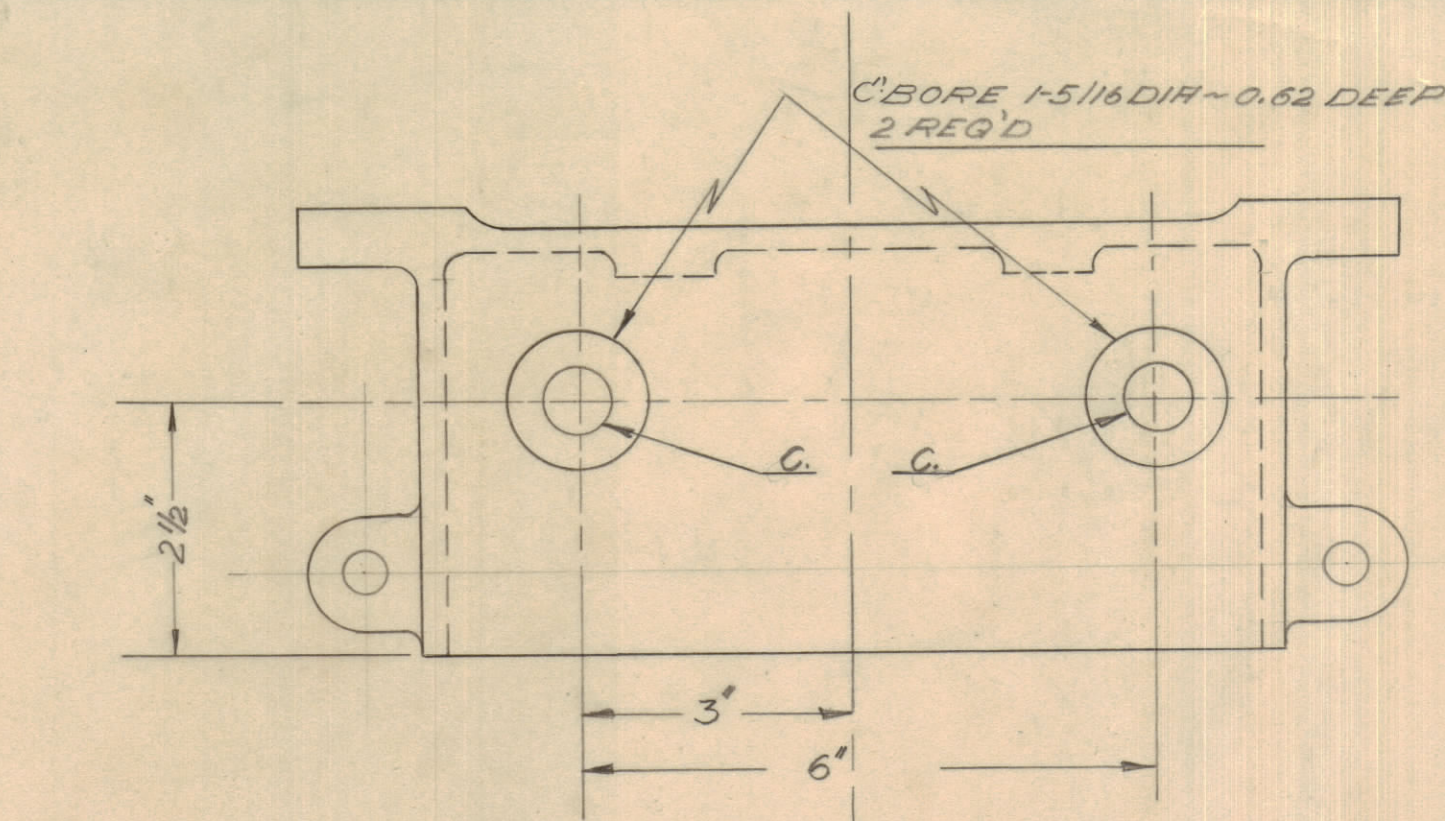
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MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

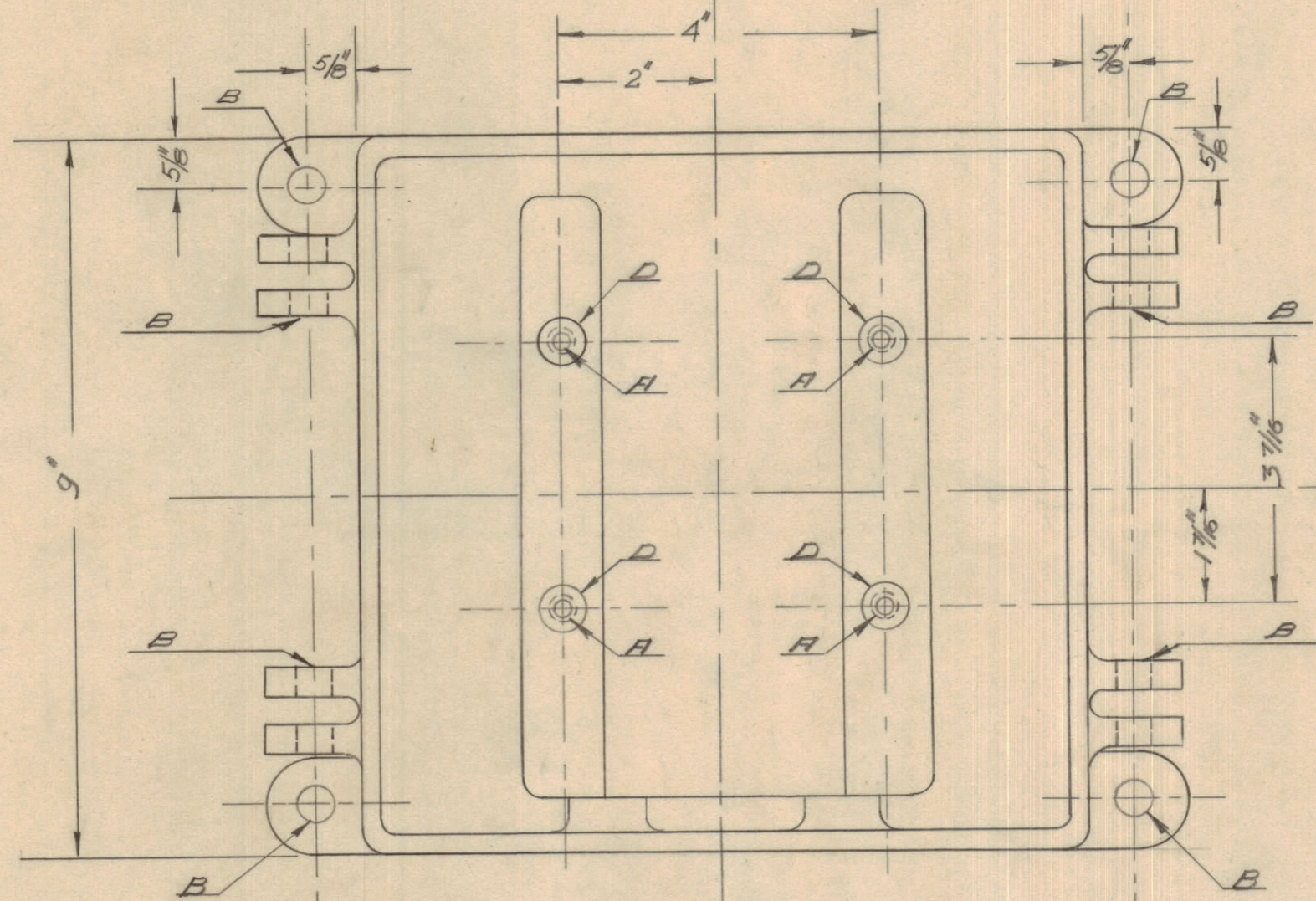
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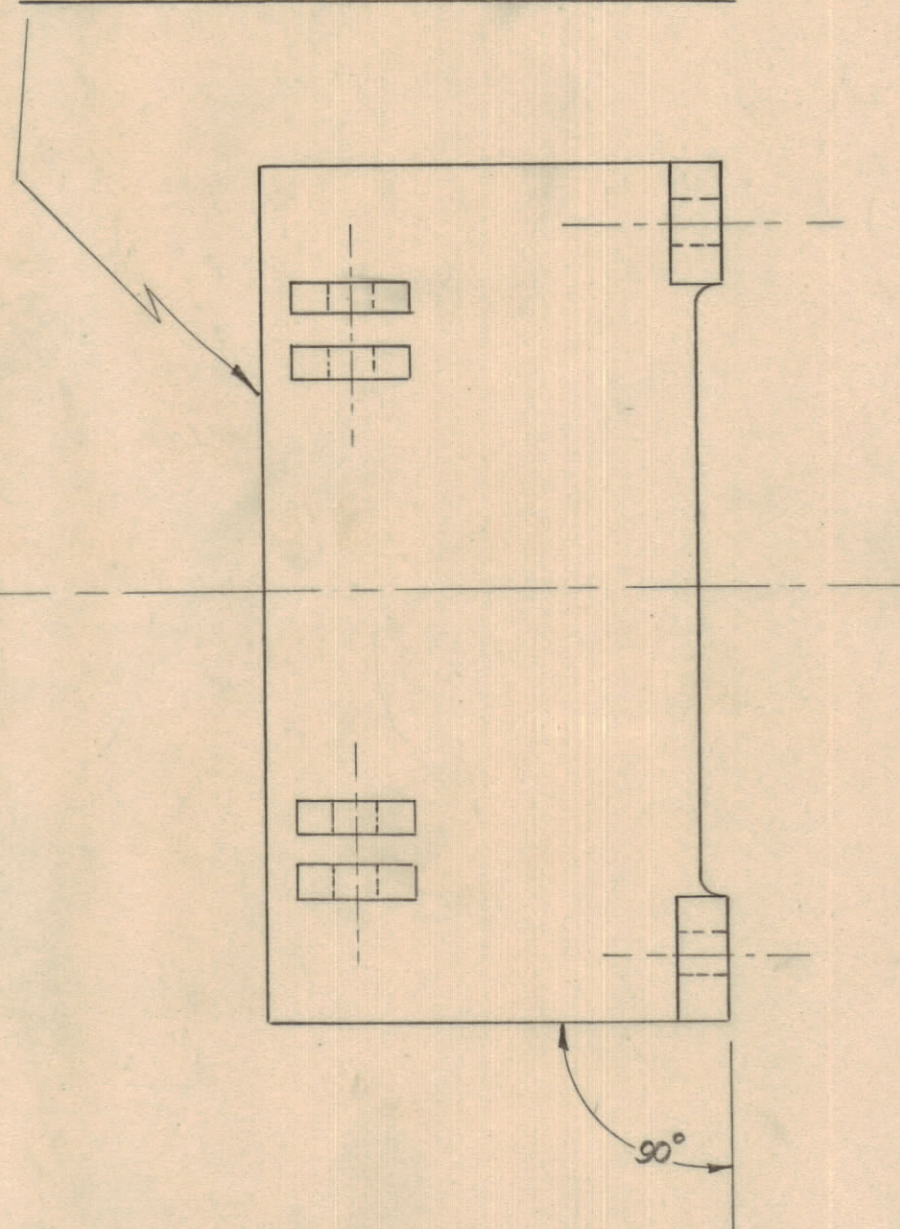
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MAMARONECK, NEW YORK



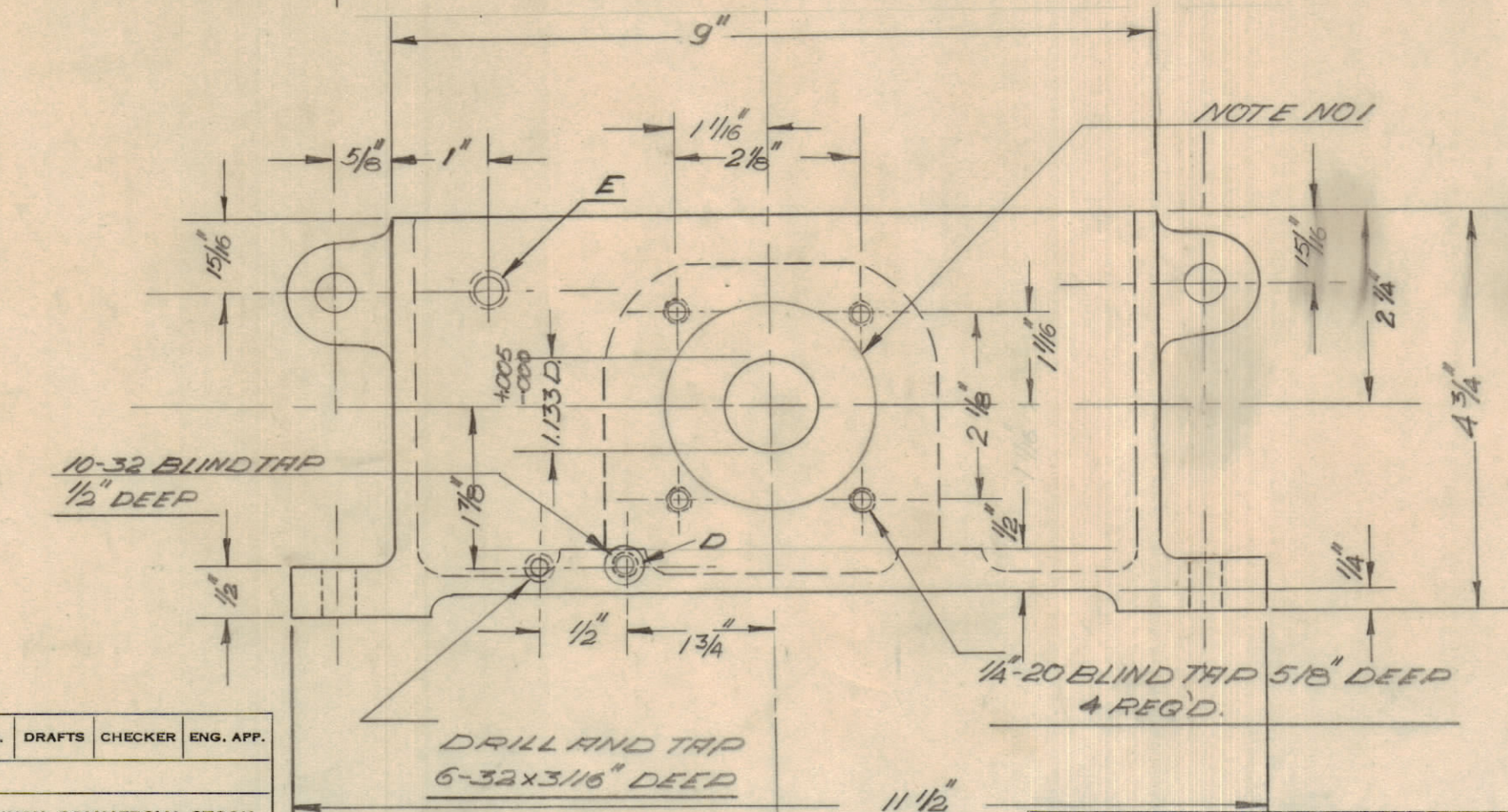
LETTER	DESCRIPTION	REQ'D
A	5/32 BLIND TAP 3/8" DEEP	4
B	33/64 (.515) D	12
C	5/8" (.625)	2
D	1/2 (.500) D C' BORE SLIGHTLY TO REMOVE PAINT.	5
E	DRILL AND TAP 1/8" x 27	



TOP SURFACE MACHINED SMOOTH



FINISH
S-101-COUSTIC DIP
S-114-ZINK CHROMATE PRIMER
S-115-SMOOTH GREY ENAMEL



NOTE NO 1

Note NO 1
C BORE 2.500 D .156 DEEP
DEPTH OF C BORE TO BE PARALLEL WITH OUTSIDE SURFACE

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

MODEL	PROJECT No.	ASS'Y. No.	DATE
RFC-18	USED ON		

REQ.	ITEM	PART No.	DESCRIPTION	SYMBOL
			TMC (Canada) LIMITED	
			OTTAWA ONTARIO	
			CHASE MACHINING	
			MODEL RFC-18	
DRAWN		ELEC. DES. APP.		MECH. DES. APP.
CHECKED		FINAL APPROVAL		
		PH-372		B

B PH372