

DATE 6/28/56
SH. 1 OF 3
COMPILED BY
WDC

TMC SPECIFICATION NO. S-300

TITLE: PROCEDURE TO CONVERT MODEL PMO'S NOW IN THE

JOB

APPROVED WDC FIELD TO INCLUDE ALL ENGINEERING IMPROVEMENTS

PART I

Changes which will not require recalibrating the oscillator.

A. Dismantle all parts on A-855 Main Gear Assembly, except the vernier drive and front panel spacers.

B. Main Gear and Counter Assembly Modifications.

1. Modify the main gear plate according to drawing A-858 which involves enlarging one hole and adding six holes.
2. Remove oillite bearings on gear housing and modify according to drawing A-827
3. Add two PM-413 gear plate supports.
4. Delete existing A-826 Gear Plate Sub-Assembly and remake according to the latest A-826 revision.
5. Replace steel miter gears GR-116 with nylon gear assembly A-939.

C. Calibrate Gear Assembly Modifications.

1. Modify calibrate assembly spacers according to drawing PM-299.
2. Modify rear float according to front float drawing A-829.

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3. Remove GR-115 step up gear from shaft PM-314 and replace with split gear GR-127.
 4. Modify collar PM-316 according to the latest revision.
 5. Delete existing calibrate shaft A-830 which includes gear GR-109 and replace the new shaft containing GR-118 according to the latest revision on A-830.
 6. Modify the front panel for the calibrate locking feature according to drawings MS-550 for PMO-1, MS-554 for PMO-2, and LD-192 for PMO-1,-2, which involves enlarging one 3/8 diameter hole to 1 1/16 diameter, adding two #6 countersunk holes and engraving the word LOCK.
 7. Install shaft lock PM-181 with spacers PM-420 and mounting hardware on the front panel.
 8. Assemble PM-421 and PX-340 which makes the calibrate lock knob and mount when unit has been completed of revisions and fully assembled again.
- D. Reassemble main gear, calibrate, and counter assembly used on all the modified parts listed above.

PART II

Changes which will require recalibrating the oscillator

- A. Ceramic coil A-243 and tuning slug CI-111
 1. Remove ceramic coil and tuning slug.

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2. Drill out existing roll over insert and add two holes according to the latest revision on MS-332.
 3. Reassemble coil and slug as shown on oscillator sub-assembly drawing A-805.
- B. Change in temperature compensating capacitors.
1. Change C304 to CC20RG100G.
 2. Change C305, C306 to CC45LG271J.
 3. Change C319 to CC-102-5.
- C. Re-calibrate the oscillator.