TMC SPECIFICATION

NO. S 992

REV: 0 A

COMPILED: RJE | CHECKED: FEE | APPD: MMKeu 7/22/65 | SHEET COVER OF 3

TITLE:

typed by vab 7/16/65

I N S T R U C T I O N S

for

CONVERSION OF HFA-1 TO HFAR-1

(KIT-222)

CAUTION: 1. DO NOT ROTATE ANY LEDEX SHAFTS UNTIL ENTIRE INSTRUCTIONS HEREIN CONTAINED ARE REVIEWED.

TMC SPECIFICATION

NO. S 992

REV: 0 A

COMPILED: RJE | CHECKED: | APPD: | SHEET 1 OF 3

TITLE: CONVERSION OF THE HFA-1 TO HFAR-1 (KIT-222)

typed by vab 7/16/65

I. PURPOSE:

To provide modification instructions for conversion of an HFA-1 to an HFAR-1. This modification will be referred to as KIT-222.

II. MATERIALS SUPPLIED:

ITEM	QTY.	PART NO.	DESIGNATION
1	2	AX-541	Auto-Ass'y
2	2	MC130-1	Cplg. Rigid
3	2	MC-131	Cplg. Rigid
4	1	NP362-30	Plate Ident.
5	2	PM691RF8.500S	Shaft Ext.
6	2	PN59-062-8	Pin Spring
7	8	SCBP0832BN5	Scr, Mach.
8	8	LWE08MRN	Wash., LK, Ext.
9	8	NTH0832BN10	Nut, Plain, Hex
10	4	SLHC0832SN3	Setscrew (for MC130)

III. PROCEDURE:

1. Place template TP-138 against rear flange (MS-2820) so pilot plugs engage with "P" detail holes. Use MS2820 print to locate these holes on rear of HFA-1.
2. Using tool TP-133, center punch through all 1/8" Dia. holes on template.

NOTE: DO NOT DRILL THROUGH TEMPLATE.

3. With a 1/8" Dia. drill bit, pilot all center punch marks.
4. All "W" holes shown on MS2820 are then opened up to 13/64" to accomodate for 8-32 hardware.

5. Next, 3/8" holes on rear of chassis wrap-around are to be opened to 5/8" to accept shaft coupling MC-131. This is accomplished by centering 5/8" round style "R" punch in 3/8 hole, as per instructions accompaning TP113. Cutout to be orientated as per MS2820.
6. All holes necessary in rear panel have been accomplished so as to mount Ledex brackets AX-541.
7. On each AX-541, mount a MC131 multi-jaw coupling onto the Ledex shafts to an approximate depth of 3/8", and fasten set screw to flat surface.
8. CAUTION: AX-541 HAS BEEN PREALIGNED AT THE FACTORY, AND EXTREME CARE MUST BE EXCERCISED TO AVOID MOVING THE SHAFT.
9. Place an AX-541, orientated with connector plugs facing upward over each detection "W" detail mounting holes, as indicated on MS2820. Fasten in place with 8-32 mounting hardware.
10. Place both detection switches in the "AM" position.
11. With each PM691RF8.500$ extension shaft insert into MC-130 rigid coupling to a depth of 7/16", tighten set screw, then drill through pilot hole with #52 drill. Then insert pin PN59-062-8.
12. Place MC-131 multi-jaw coupling over round shaft (PM691RF8.500S) and allow to remain free. Then fasten broached end of MC-130 to each detection selection switch shaft. Next, mate multi-jaw coupling (MC-131) by sliding free shaft coupling forward to mate snugly with coupling on Ledex Drive Unit Assembly. Tighten setscrews.
13. This completes the conversion of an HFA-1 to an HFAR-1.

IV. TOOLS REQUIRED

One Take off tool (or transfer punch) TP133

One #52 High speed drill

One 1/8" High speed drill

One 13/64" High speed drill

One 5/8" Round style "R" punch (TP1130R-5/8)

One MS2820 Chassis, Elect. Print

One TP138 Template Print

One TP138 Template

REVISION SHEET	THE TECHNICAL MATERIEL CORP. MAMARONECK NEW YORK	S-992 LIST NO.

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7/22/65		1 of 3		O=ORIGINAL RELEASE FOR PRODUCTION.	
8/21/72	A	1,2&3		Revised per EMN 20839	EJ