KIT-235
S996

TMC SPECIFICATION

NO. S - 996

REV: A B

COMPILED:

CHECKED: JEC

APPD: [illegible] 7/23/63

SHEET 1 OF 5

TITLE:

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

for

CONVERSION OF HFI-1 TO HFIA-1

(KIT-235)

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

TITLE: CONVERSION INSTRUCTIONS FOR THE HFI-1 TO HFIA-1 (KIT-235)

typed by vab 7/23/65

I. PURPOSE:

To provide modification instructions for conversion of an HFI-1 to an HFIA-1. This modification will be referred to as KIT-235.

II. MATERIALS SUPPLIED:

ITEM	QTY.	PART NO.	DESIGNATION
1	1	AX-544	Auto-Ass'y (Chan B)
2	1	AX-588	Auto-Ass'y (Chan A)
3	2	MC-130	Cplg, Rigid
4	2	MC-131-1	Cplg, Rigid
5	1	NP362-59	Plate Ident.
6	1	CA-480-14-9	Cable Coaxial W/ Connector
7	2	PN59-062-8	Pin Spring
8	8	SCBP0832BN5	Scr. Mach.
9	8	LWE08MRN	Wash, LK, Ext.
10	8	NTH0832BN10	Nut, Plain Hex
11	1	CA-1093-14.00	Cable, Interconnector
12	4	~~SLHC0832SN3~~	Set screw (for MC130)

III. PROCEDURE:

1. Place Template (TP-136) against rear panel with pilot plugs in extreme "B" holes. Use MS2729 print to locate these holes on rear plate.
2. Using tool TP-133, center punch through all 1/8" Dia. holes on template, except "H" detail holes.

NOTE: DO NOT DRILL THROUGH TEMPLATE.

3. With 1/8" Dia. Bit pilot all "G" holes only.
4. All "G" holes shown on MS2729 are then opened up to 13/64" to accommodate for 8-32 hardware.

5. Referring to LD-1040, new "D" detail hole J6220, procede as follows: 1" over on the same center line, center punch and drill 1/8" pilot hole. Then enlarge hole to 5/16", to accommodate for style "D" punch screw. Insert "D" punch in hole as per instructions accompaning TP113. Mount coaxial cable thru grommet hole directly below it and solder center conductor to TP6201 and solder shield to adjacent ground lug.

NOTE: CAUTION THE AX-544 AND AX-588 HAVE BEEN PRE-ALIGNED AT THE FACTORY AND EXTREME CARE MUST BE EXERCISED TO AVOID MOVING THE SHAFT.

6. On AX-544 mount a MC131 multi-jaw coupling onto the Ledex shafts to an approximate depth of 3/8", and fasten set screw to flat surface.
7. Place an AX-544 over Chan B IF Bandswitch "G" detail mounting holes as indicated an MS-2729. Fasten in place with 8-32 mounting hardware.
8. With AX-588 Repeat steps 6 and 7 for Chan A.
9. Place both IF Bandswitch selector switch knobs to 1 KC DSB position.
10. Replace existing rigid coupling located midway between wafer decks on both Chan "A" and "B" IF Bandswitch Selector switches with new MC130 rigid coupling. This may be accomplished by removing set screws and withdrawing shaft from knob end sufficient to replace with new coupling then reinsert shaft into broached end of the new coupling. Set screws should then be

tightened down. Then drill thru pilot hole of coupling and shaft with a #52 drill (supplied), and inserting pin (supplied) PN59-062-8. Place MC131 multi-jaw coupling over switch shaft and allow to remain free. Next, mate switch shaft multi-jaw coupling by sliding free shaft coupling forward to mate snugly with Ledex Drive Unit coupling.

11. To facilitate slaving Chan "B" to chan "A", connect CA1093-14 between J6219-1 to J6219-4.

12. This concludes the conversion of HFI-1 to HFIA-1.

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TITLE: CONVERSION INSTRUCTIONS OF THE HFI-1 TO HFIA-1 (KIT235)

typed by vab 7/23/65

TOOLS REQUIRED:

One take-off tool (or transfer punch) TP-133

One #52 high speed drill

One 1/8" high speed drill

One 5/16" high speed drill

One 13/64" high speed drill

One MS2729 Print

One TP136 Print

One TP136 Template

One 1/2" style "D" Punch TP113D0-1/2

One CK-522 Schematic

REVISION SHEET

THE TECHNICAL MATERIEL CORP.
MAMARONECK NEW YORK

S996
LIST NO.

DATE	REV.	SHEET	EMN #	DESCRIPTION	APP.
2/7/66	A	all	15724	Revised per EMN	
8/14/72	B	11/12	20827	Revised per EMN	

TMC FORM MLR-1 2-65—AINS.