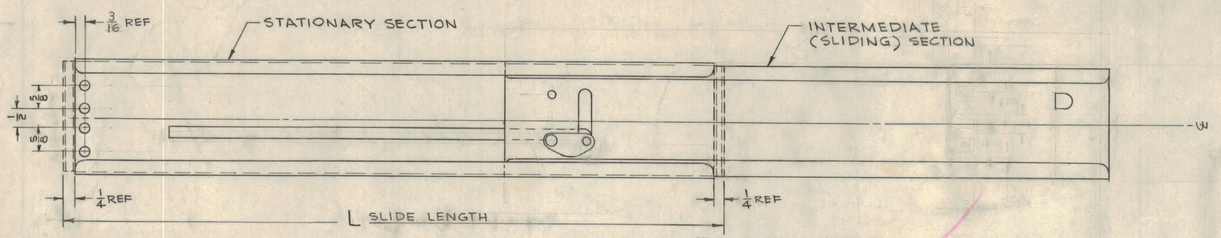
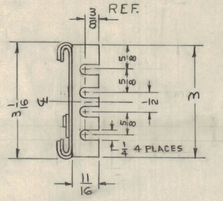
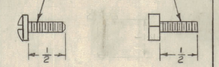
REVISIONS						
ZONE	SYM	DESCRIPTION	DATE	E.M.N. NO.	DRAFT	CHKD	APPD
H	X	EXPERIMENTAL RELEASE	4-7-64	X	A.M.		
H	X1	TK118HW WAS 26 REQ'D., 4 'A' HOLES DELE. 3/16 REF. WAS 7/32 REF., SPOT WELD ADD.	5/1/64	X1	A.M.		
H	X2	SPECIFICATIONS UPDATED	6-8-64	X2	A.M.	@	
H	0	ORIGINAL RELEASE FOR PRODUCTION	6/5/64	0	A.M.		



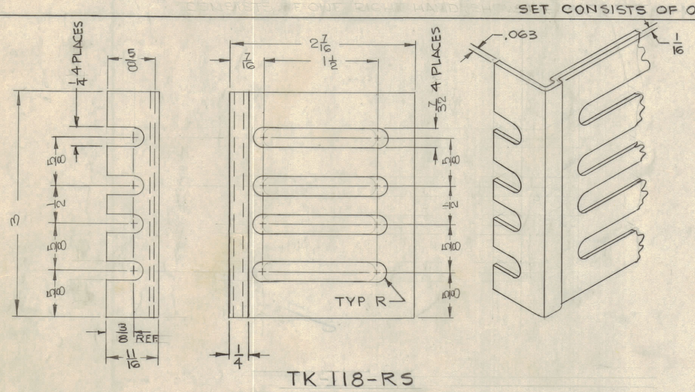
TK 118-XXRT (RIGHT H.)
TK 118-XXLT (LEFT H.)

STATIONARY & INTERMEDIATE (SLIDING) SECTION.
SET CONSISTS OF ONE RIGHT HAND (SHOWN) & ONE LEFT HAND (MIRROR IMAGE)

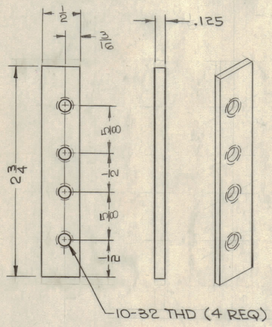




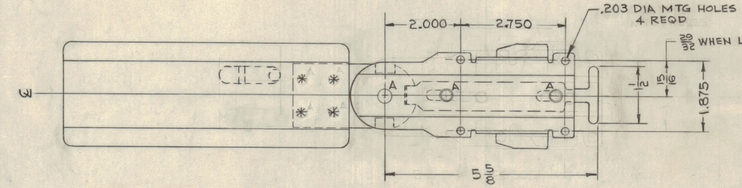
TK118-HW
MACHINE SCREWS

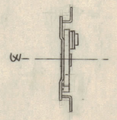


TK 118-RS
REAR SUPPORT



TK 118-NB
NUT BAR





TK 118-XXRC (RIGHT H.)
TK 118-XXLC (LEFT H.)
CHASSIS SECTION
SET CONSISTS OF ONE RIGHT HAND (SHOWN) & ONE LEFT HAND (MIRROR IMAGE)

SPECIFICATIONS

MATERIAL: TK 118-XXRT & LT, TK118-XXRC & LC, TK 118-RS & TK 118-NB ARE TEMPER COLD ROLLED STEEL PER SPEC. QQ-S-636. TK 118-HW ARE CARBON STEEL. SPRINGS, RIVETS, PINS, & STOPS ARE 18-8 STAINLESS STEEL.

FINISH: TK 118-XXRT & LT, TK 118-XXRC & LC, TK118-RS & TK118-NB ARE ZINC PLATED (PER MIL-QQ-Z 325) AND OLIVE DRAB IRIDITE COATED. STAINLESS STEEL PARTS ARE PASSIVATED

LUBRICATION: MOLYBDENUM DISULPHIDE WITH AN EPOXY BASE, PER MIL-L-22273, IS BAKED ON AT 375°F TO WITHSTAND TEMP. OF -100°+500°F, PRESSURE LOADINGS OF MORE THAN 50M AT 25 FPM.

SALT SPRAY: MEETS OR EXCEEDS 100 HOURS 20% SALT FOG AT 95° TEMP.

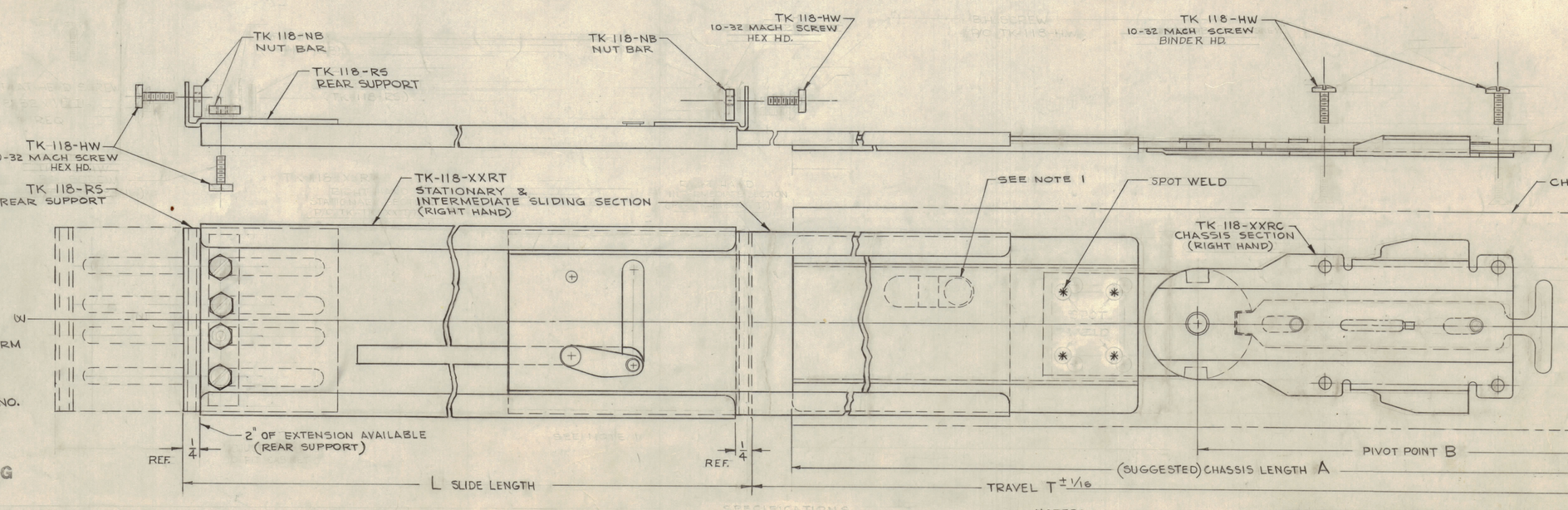
LOAD RATING: 175 LBS AT FULL EXTENSION, 100% SAFETY FACTOR.

TILT VARIATION: PIVOTS AND LOCKS IN PLUS OR MINUS 90° TILT POSITION.

FOR COMPLETE SET
TMC PART NO. TO BE IN FOLLOWING FORM

TK 118 - XX
TMC PART NO. — MODEL LENGTH NO. (SEE CHART)

STANDARD DRAWING



NOTES:
1. AUTOMATIC LOCK OUT, QUICK DISCONNECT, DEPRESS MANUAL RELEASE BUTTON TO REMOVE OR RETURN CHASSIS

TMC PURCH. & PART NO.	MFRS PART NO.	MODEL LENGTH NO.	DIMENSIONS A	B	L	T	REQUIRED TMC PART NO'S PER EACH TRACK & SLIDE SET: STATIONARY & INTERMEDIATE 1 REQD	1 REQD	CHASSIS SECTION 1 REQD	1 REQD	REAR SUPPORT 2 REQD	NUT BAR 6 REQD	HARDWARE 1 SET
TK-118-18	SS-300-D-18	18	17	8 1/2	17 7/8	20 1/2	TK-118-18RT	TK-118-18LT	TK-118-18RC	TK-118-18LC	TK-118-RS	TK-118-NB	TK-118-HW

REQ'D.	ITEM	PART NUMBER	DESCRIPTION	SYMBOL
I. JOHNSON			LIST OF MATERIAL	

MATERIAL: SEE SPECS
FINISH: SEE SPECS

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

TITLE: TRACK AND SLIDE SET, PLUS OR MINUS 90° TILT

1	RAK-31A	
Q'TY/UNIT	MODEL USED ON	ASS'Y. NO.

SCALE: NONE | CODE: C | S-401-209

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

DECIMALS: .X ± .05, .XX ± .01, .XXX ± .005 — TOLERANCES — FRACTIONS ± 1/64, ANGLES ± 0° 30'

	DRAWN	DATE	FINAL APPROVAL	DATE
		11-3-63		
	CHECKED	DATE		
		5/20/64		
	ELECT. DES.	DATE		
		5/20/64		
	MECH. DES.	DATE	SHEET	REV. LTR.
		6/5/64	TK 118	0

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TMC FORM 111

TK 118 0