KIT-231

995

TMC SPECIFICATION			NO. S - 995
REV: A B			
COMPILED: RJE	CHECKED: JEE	APPD: 7/23/62	SHEET 1 OF 4
TITLE:			

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

for

CONVERSION OF HFI-1 TO HFIB-1

(KIT-231)

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

TMC SPECIFICATION			NO. S - 995
REV: A B			
COMPILED: RJE	CHECKED:	APPD:	SHEET 2 OF 4

TITLE: INSTRUCTIONS OF HFI-1 TO HFIB-1 (KIT-231)

typed by vab 7/23/65

I. PURPOSE:

To provide modification instructions for conversion of an HFI-1 to an HFIB-1. This modififcation will be referred to as KIT-231.

II. MATERIALS SUPPLIED:

ITEM	QTY.	PART NO.	DESIGNATION
1	2	AX-544	Auto-Ass'y
2	2	MC-130	Cplg, Rigid
3	2	MC-131-1	Cplg, Rigid
4	1	NP362-58	Plate Indet.
5	2	PN59-062-8	Pin Spring
6	8	SCBP0832BN5	Scr. Mach.
7	8	LWE08MRN	Wash, LK, Ext.
8	8	NTH0832BN10	Nut, Plain Hex
9	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 accomodate for 8-32 hardware.

NOTE: CAUTION THE AX544 HAS BEEN PRE-ALIGNED AT THE FACTORY AND EXTREME CARE MUST BE EXERCISED TO AVIOD MOVING THE SHAFT.

15. 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.

16. Place an AX-544 over each IF Bandswitch "G" detail mounting holes as indicated on MS-2729. Fasten in place with 8-32 mounting hardware.

17. Place both IF Bandswitch selector switch knobs to 1 KC DS position.

18. Replace existing rigid coupling located midway between wafer decks on both "A" and "B" IF bandwidth 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 #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.

19. This completes the conversion of the HFI-1 to HFIB-1.(KIT-231)

TITLE: INSTRUCTIONS FOR THE HFI-1 TO HFIB-1 (KIT-231)

typed by vab 7/23/65

TOOLS REQUIRED: (FOR KIT-231)

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

One #52 high speed drill

One 1/8" high speed drill

One 13/64" high speed drill

One MS2729 Print

One TP136 Print

One TP136 Template

REVISION SHEET	THE TECHNICAL MATERIEL CORP. MAMARONECK NEW YORK	S995 LIST NO.

DATE	REV.	SHEET	EMN #	DESCRIPTION	APP.
2/7/66	A	all	15724	Revised per EMN	
8/4/72	B	2	20827	Revised per EMN	

TMC FORM MLR-1 2-65—AINS.