

Materials needed:

Milling machine,

0.116" drill,

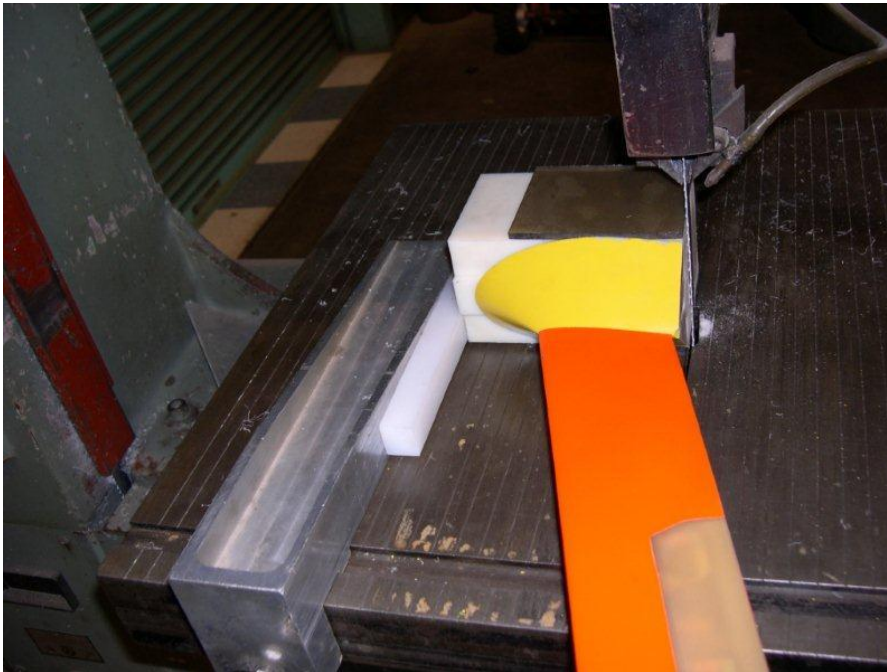
0.124" and 0.125" reamers,

2x 1.5" x 1/8" SS pins

Two jigs, with 3 pieces

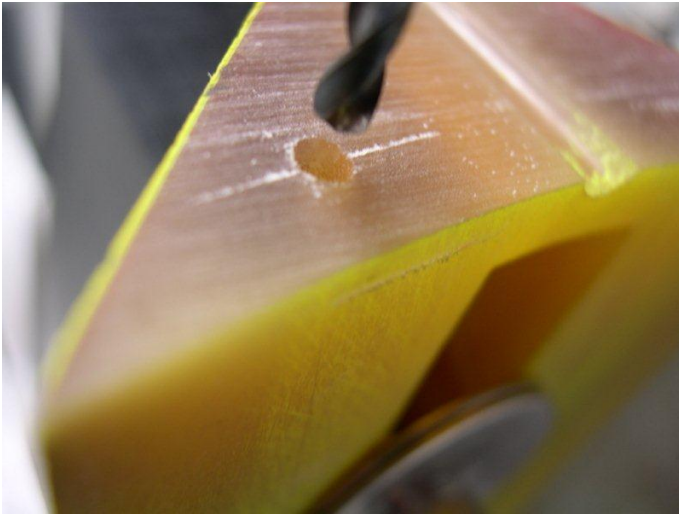
The larger one, which includes a removable sawing guide is used for parting the antenna.

1. Attach antenna with 2 ¼-20 x 3.5" socket head bolts.
2. Attach sawing guide.
3. Use fence on bandsaw to gently hold block against the blade.
4. Slowly run the antenna thru the saw ensuring the guide stays flush to the bandsaw fence.
5. See image of result

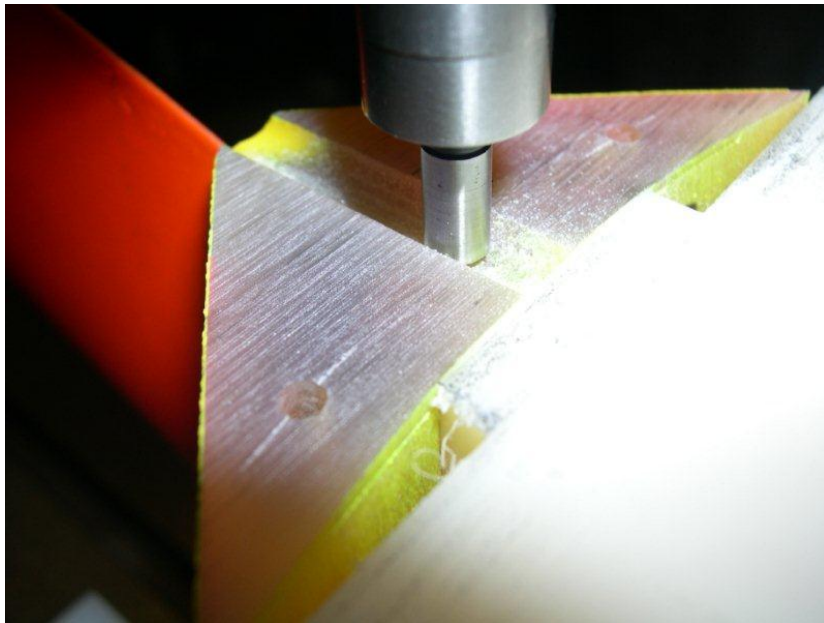


6. Attach tail section to other jig.

7. Remove saw guide from 1st jig.
8. Scribe a concentric line 0.250" from curved lower surface on both antenna pieces. Image.



9. Drilling 0.116" holes is similar with both jigs and parts.
10. Mounting either jig squarely in the vise, find center of part with the center finder resting in the part's center groove (cut hole)



11. Flip the center finder to locate point on the scribed line 0.750" from center.

12. In the front section, drill 0.55" Deep. ± 0.750 from Center line
13. In the aft section, drill 1.0" Deep.
14. Ream the aft section 1.0 deep holes 0.124" and the forward 0.55 deep holes 0.125"
15. Place pins and check fit.



