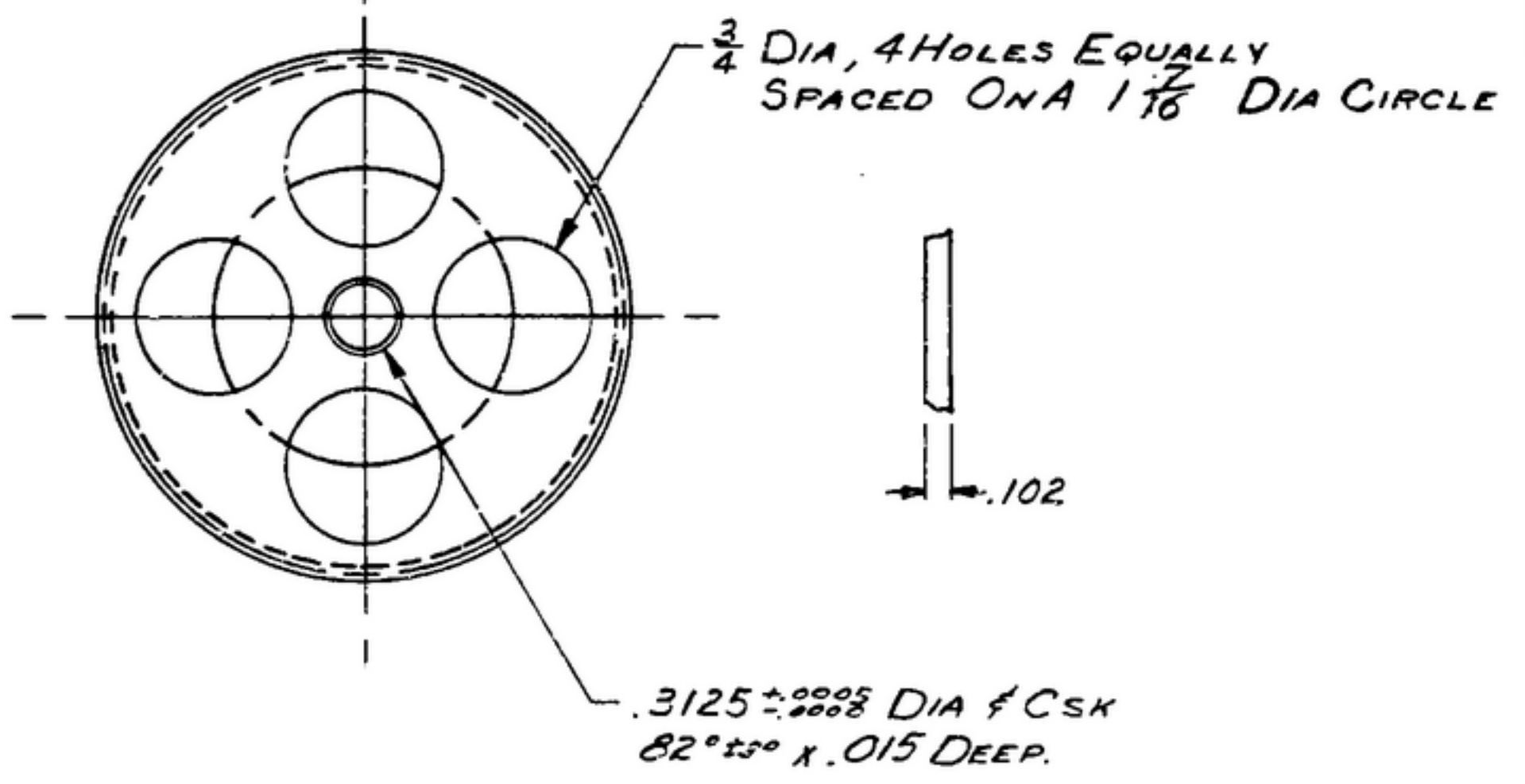


R-391 300-18-14-002

NOTICE: When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government hereby incurs no responsibility or any obligation whatsoever and the fact that its Government may have furnished, furnished, or in any way supplied the said drawings, specifications, or other data is not to be regarded by implication or otherwise as in any manner granting the holder or any other person or corporation, or conveying any rights or permission to manufacture, use or sell any patented invention that may in any way be related thereto.

NEXT ASSEMBLY		USED ON		REVISIONS		APPROVAL	
SM-B-178754		SC-DL-178467		A ₁ - WAS COMP C, QQ-B-611;		6 OCT 53	
SM-B-248940		SC-DL-248775		A ₂ - ADDED APPL SM-B-248940, SC-DL-248775.		42428-PC-59-A1-51	
A ₂						REV: PBF	



- A₁ BRASS COMP 1 1/2 HARD, PER SPEC QQ-B-613.
- 1-NORMAL DIAMETRAL PITCH 32
 - THEORETICAL PITCH DIAMETER 2.500
 - PRESSURE ANGLE 20°
 - NUMBER OF TEETH 80
 - BACKLASH ON NORMAL PITCH CIRCLE
 - WHEN MATED WITH MASTER .002-.003
 - AMERICAN STANDARD INVOLUTE TOOTH FORM
 - 2-ECCENTRICITY BETWEEN PITCH DIAMETER & BORE SHALL NOT EXCEED .002 TIR.
 - 3-SLIGHT BURRS PERMISSIBLE.

NOTE:
*FOR INFORMATION ONLY,
CONTRACTOR MAY AT HIS
OPTION DEVIATE FROM
THESE PROCESS DETAILS

REVISION	PART NO.	DESCRIPTION	DATE	SPEC	NOTE												
<table border="1" style="width: 100%;"> <tr> <td style="width: 30%;"> UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± — COMMERCIAL TOLERANCES APPLY TO STOCK SIZES ALL SURFACES ✓ </td> <td style="width: 20%;"> AUTHENTICATION DRAWN 21882-PA-56-93 TRACED PHOTO CHECKED <i>AK</i> VERIFIED <i>PO-GR</i> APPROVED <i>PO-GR</i> REVIEWED <i>PME</i> DATE 18-JUN-53 </td> <td style="width: 40%; text-align: center; vertical-align: middle;"> <h1>GEAR</h1> </td> <td style="width: 10%; text-align: center;"> SCALE 1/1 </td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> </tr> <tr> <td colspan="5" style="text-align: center;"> DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY </td> <td style="text-align: center; font-size: 1.2em;"> SM-B-178755 </td> </tr> </table>						UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± — COMMERCIAL TOLERANCES APPLY TO STOCK SIZES ALL SURFACES ✓	AUTHENTICATION DRAWN 21882-PA-56-93 TRACED PHOTO CHECKED <i>AK</i> VERIFIED <i>PO-GR</i> APPROVED <i>PO-GR</i> REVIEWED <i>PME</i> DATE 18-JUN-53	<h1>GEAR</h1>	SCALE 1/1			DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY					SM-B-178755
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WHEN REFERRING TO THIS DRAWING STATE DRAWING NO., APPLICABLE ISSUE SYMBOL AND DATE