

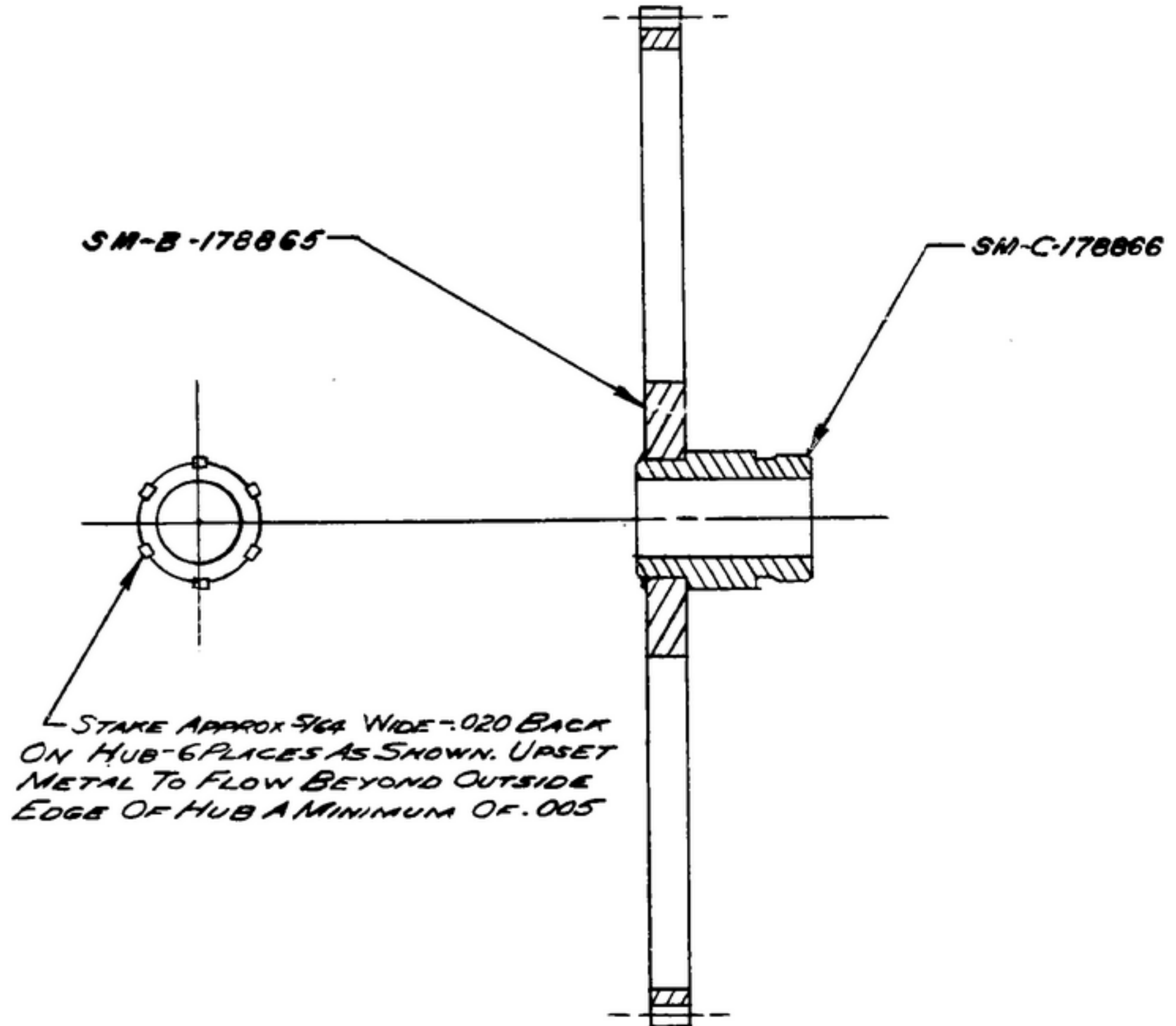
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506-1824 002 ~~506-1824-002~~ R-391

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

*SWE APPROVAL		REVISIONS		
SYM	DESCRIPTION	DATE	APPROVAL	
SYM PR10042-2				
A <sub>2</sub>	A <sub>1</sub> - ADDED APPL. SM-B-178861, SC-DL-248775; A <sub>2</sub> - SM-C-178866 WAS SM-178866.	10 OCT. 59	42428-PC-59-A1-51 REV'D PME	



- (A<sub>2</sub>)
- 1- PRESS SM-B-178865 ONTO SM-C-178866, SNUG AGAINST SHOULDER WITH C'SUNK SIDE OF GEAR TOWARD SHOULDER AND STAKE AS SHOWN.
  - 2- AXIAL RUNOUT SHALL NOT EXCEED .015 TIR AT 1 1/2 INCH RADIUS.
  - 3- GEAR MUST WITHSTAND 75 INCH LBS. OF TORQUE WITH HUB HELD STATIONARY. GEAR MUST NOT ROTATE ON HUB OR LOOSEN IN ANY WAY AS A RESULT OF THIS TEST.
  - 4- ECCENTRICITY OF PITCH LINE OF GEAR TO BORE OF HUB SHALL NOT EXCEED .004 TIR AFTER STAKING.
  - 5- ANY PROJECTION CAUSED BY STAKING WHICH EXTENDS BEYOND FACE OF HUB MUST BE REMOVED.

QTY	PART NO.	DESCRIPTION	MATL	MATL SPEC
1	SM-C-178866	HUB		
1	SM-B-178865	GEAR		

LIST OF MATERIAL

(A <sub>1</sub> )	SM-B-178861	SC-DL-248775	APPLICATION	UP, LESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES	AUTHENTICATION DRAWN 21832-PA-50-93 TRACED PHOTO CHECKED [Signature] VERIFIED P.D.BR. APPROVED P.D.BR. REVIEWED PME DATE 3-AUG-53	GEAR ASSY	SIGNAL CORPS ENGINEERING LABORATORIES PORT MONMOUTH NEW JERSEY
	SM-B-178861	SC-DL-178467					
	NEXT ASSY	USED ON					SM-B-178864