

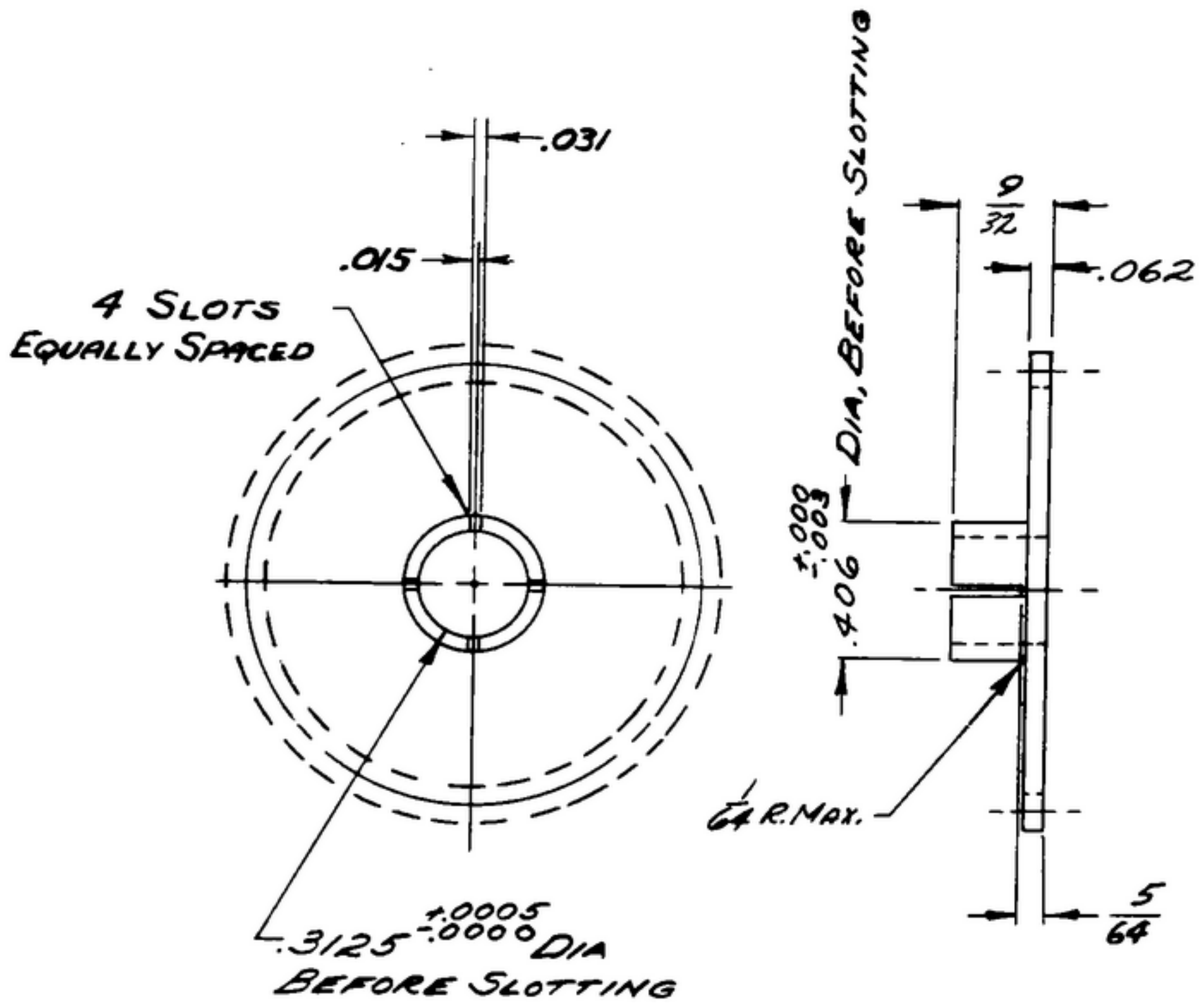
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\* FOR INFORMATION ONLY. CONTRACTOR MAY AT HIS OPTION DEVIATE FROM THESE PROCESS DETAILS.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A <sub>1</sub>	ADDED "IRIDITE #7 TO FINISH NOTE	9 OCT 59	42428-PC
A <sub>2</sub>	ADDED APPL. SM-D-343600		59-A1-S1 REV'D PME

~~\* SWE APPROVAL~~  
SYM PR 100-42-5



(A) BRASS, COMP. 24, TEMPER 1/2H, PER SPEC QQ-B-613  
 FINISH: CHEMICAL POLISH PER IRIDITE #7 METCOTE PROCESS BY ALLIED RESEARCH PRODUCTS INC, BALTIMORE, MD, OR EQUAL.  
~~\* COLLINS 580 0034 00 (\* SAME AS 572167)~~

NOTES:  
 1. GEAR DATA:  
 NORMAL DIAMETRAL PITCH 48  
 NORMAL PRESSURE ANGLE 20°  
 NUMBER OF TEETH 64  
 THEORETICAL PITCH DIAMETER 1.3333  
 BACKLASH .002 TO .003 WHEN REFERRED TO THE THEORETICAL PITCH CIRCLE.  
 TOTAL COMPOSITE ERROR NOT TO EXCEED .003 WHEN MEASURED WITH MASTER GEAR.  
 AMERICAN STANDARD INVOLUTE TOOTH FORM  
 ALL TERMS USED AS DEFINED BY A.G.M.A. STANDARDS.

(A<sub>2</sub>)

COLLINS PART NO.	ITEM	REQD	PART NO.	DESCRIPTION	MATL	MATL SPEC
LIST OF MATERIAL						
COLLINS PART NO. 558 0245 002						

558 0324 004	+	SM-D-248975	SC-DL-248775
COLLINS NO.	QTY	NEXT ASSY	USED ON
APPLICATION			

DRAWN Hamer  
 CHECKED *Aln*  
 APPROVED

UNLESS OTHERWISE SPECIFIED:  
 DECIMAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±.003  
 FRACTIONAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±1/64  
 MACHINED ANGLES MAY VARY ±.1°  
 SHEARED ANGLES MAY VARY ±.25°  
 BROKEN ANGLES MAY VARY ±.1°  
 ECCENTRICITY BETWEEN ANY DIAMETERS ON THE SAME CENTERLINE SHALL NOT EXCEED .010 TOTAL INDICATOR READING.  
 ALL DIMENSIONS ARE FINISH DIMENSIONS INCLUDING APPLIED FINISH AND ARE GIVEN IN INCHES.

COLLINS-RADIO-60-  
 -GEAR-RAPID-18WA-  
 14214-PH-  
 51-93

SIGNAL CORPS  
 REVIEWED PME  
 APPROVED HLY  
 PME

DATE 6 DEC 55

GEAR-SPUR

SCALE 2/1

DEPARTMENT OF THE ARMY  
 SIGNAL CORPS ENGINEERING  
 LABORATORIES

FORT MONMOUTH NEW JERSEY

SM-B-248896