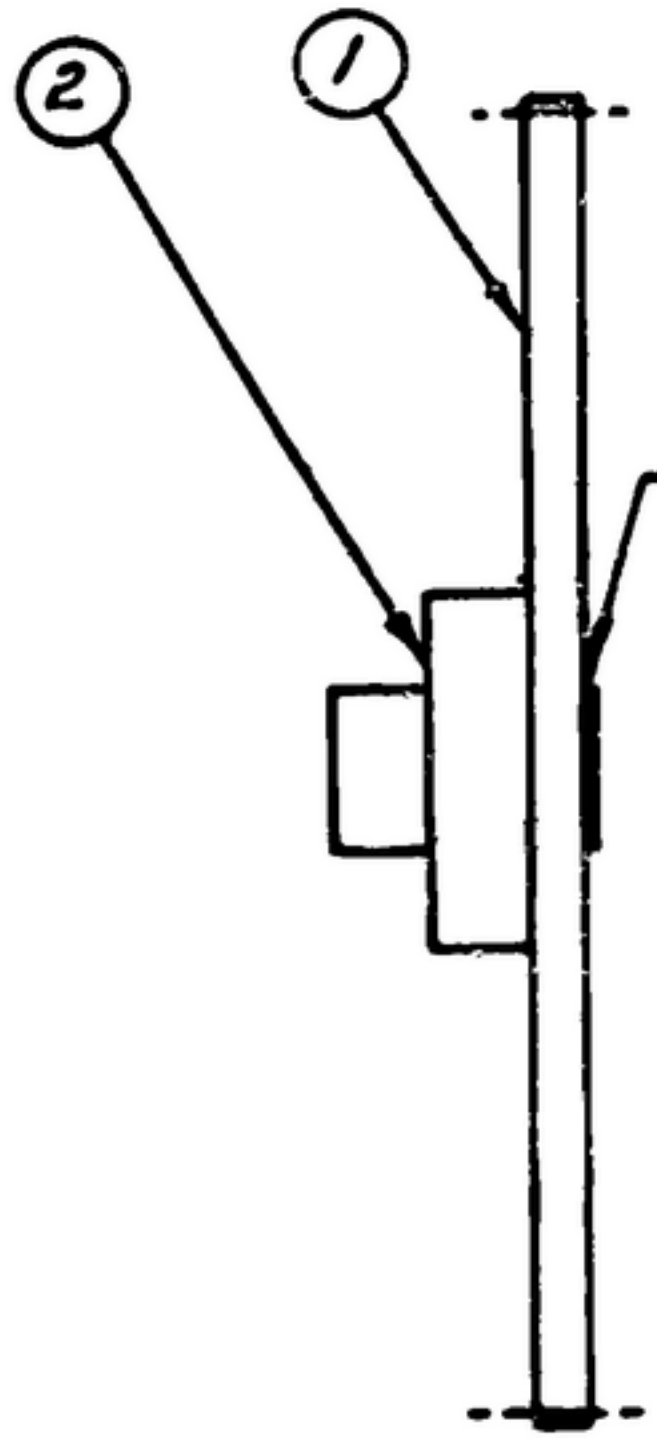


REVISIONS
 1. SPEC O-F-499 WAS 51F4
 2. ADDED IRIDITE[®] TO FINISH
 3. ADDED ITEM 3 AND 4

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

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REVISIONS			
SYMBOL	DESCRIPTION	DATE	APPROVAL
A₁	SWEE APPROVAL SYM PR10042-5	9 OCT 59	42428-PC 59-A1-51 REV'D PME
B ₁	CA 84781	17 MAY 60	42428-PC 59 REV'D PME



SILVER SOLDER ALL AROUND (A)

- NOTES
- SILVER SOLDER SHALL BE PER SPEC QQ-S-561 CLASS 4 USING FLUX PER SPEC. O-F-499
 - SIDE RUNOUT OF .015 TIR PERMISSIBLE.
 - PRESS GEAR (1) ON GEAR (2) AND SILVER SOLDER AS SHOWN, WITH C'SUNK SIDE NEXT TO GEAR (2).

(A)
 FINISH: CHEMICAL POLISH PER IRIDITE[®] NETCOTE
 PROCESS BY ALLIED RESEARCH PRODUCTS
 INC, BALTIMORE, MD, OR EQUAL.
 * SPECIFIC 500-8034-00

QTY	UNIT	REQ	PART NO.	DESCRIPTION	DATE	DATE SPEC	QTY
1	FLUX						1
1	SOLDER, SILVER						1
2	1		SM-B-24839	GEAR - SPUR			
1	1		SM-B-178755	GEAR			

LIST OF MATERIAL - JOURNAL PART NO. 558-0889-002

DRAWN: HEMER CHECKED: [Signature] APPROVED: [Signature]	SELLING OFFICE: [Address] 1214-PH-5193 SIGNAL CORPS REVIEWED: PME APPROVED: HLY DATE: 6 DEC 55	DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY SM-B-248340
UNLESS OTHERWISE SPECIFIED: DIMENSIONS INCLUDING HOLE SIZE MAY VARY 1/32" FRACTIONAL DIMENSIONS INCLUDING HOLE SIZE MAY VARY .0075" CHAMFER ANGLES MAY VARY 5.1° CHAMFER ANGLES MAY VARY 2.50° BEVEL ANGLES MAY VARY 5.1° CLEARANCE BETWEEN ANY DIMENSIONS OF THE SAME CHARACTER SHALL NOT EXCEED .005 TYPICAL UNLESS OTHERWISE SPECIFIED. ALL DIMENSIONS ARE GIVEN UNLESS OTHERWISE SPECIFIED.		
558-0880-002 - 1 SM-B-24839 SC-D-248775 APPLICATION	DATE: 6 DEC 55	SCALE: 3/1