

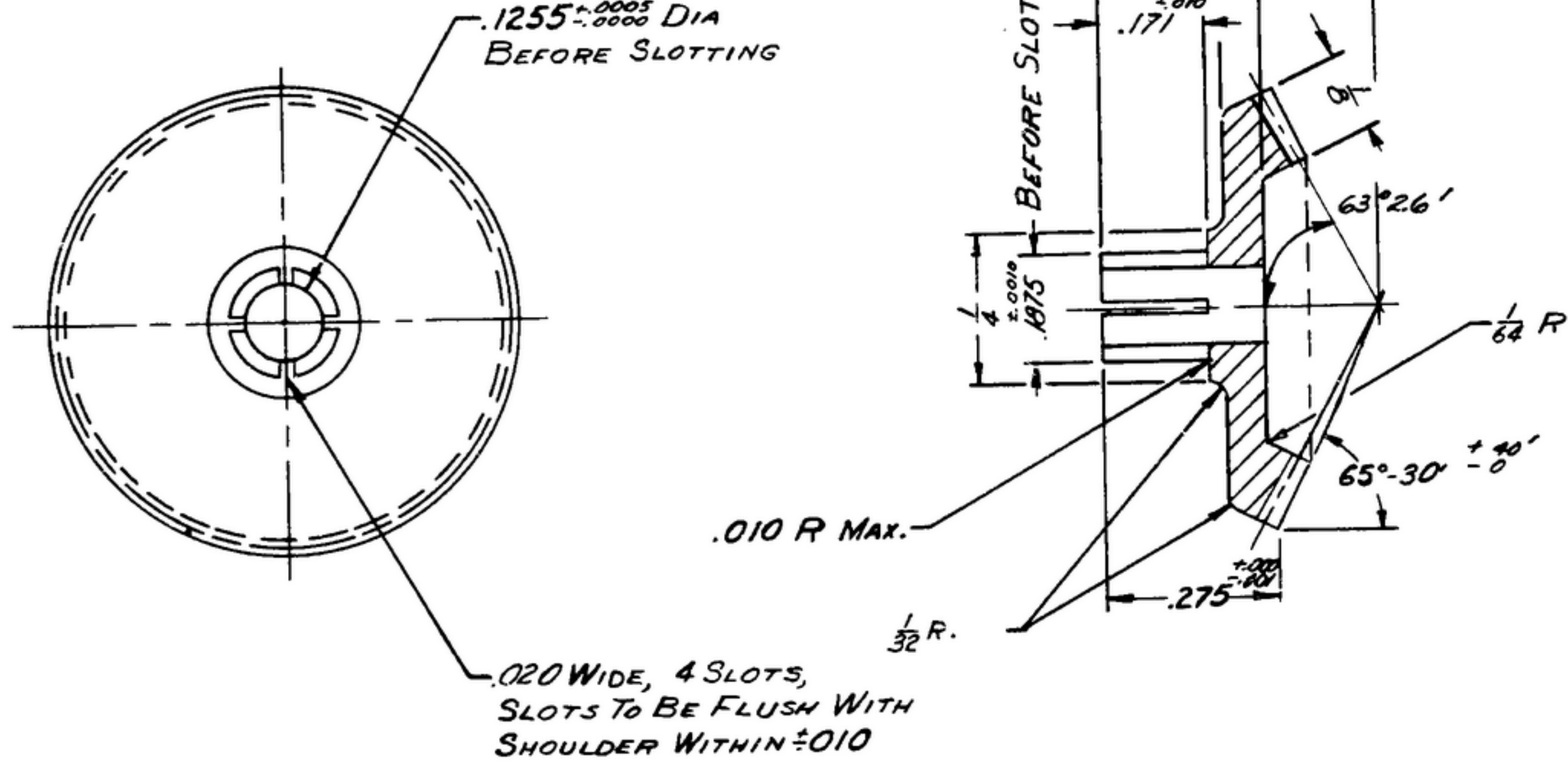
2.2

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 obligation whatsoever, and the fact that the Government may have furnished, or in any way caused the said drawings, specifications, or other data to be regarded by implication or otherwise as in any manner recognizing the liability of any other person or corporation, or conveying any rights or privileges to the holder or any other person in connection, or conveying any rights or privileges to the holder, use of all any patented invention that may in any way be related thereto.

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

| NEXT ASSEMBLY | USED ON |
|---------------|--------------|
| SM-D-178679 | SC-DL-178967 |
| SM-D-343600 | SC-DL-248775 |
| SM-D-248975 | SC-DL-248775 |

| SWE * APPROVAL | | REVISIONS | | DATE | APPROVAL |
|----------------|--|------------|----------|-------------------|------------|
| SYN. | DESCRIPTION | DATE | APPROVAL | DATE | APPROVAL |
| A ₃ | A ₁ - RENUMBERED NOTES; A ₂ - ADDED APPL. SM-D-248975, SM-D-343600, SC-DL-248775. A ₃ - BRASS WAS COMP. B, 1/2 HARD PER SPEC. QQ-B-611. | 8 OCT. 59 | | 42428-PC-59-AI-51 | REV'D. PME |
| B ₁ | B ₁ - RELOCATED 17/64 DIM. LINE. | 17 MAY 60 | | 42428-PC-59 | REV'D. PME |
| C ₁ | (1) - ADDED NOTE # 5. | 15 OCT. 60 | | 42428-PC-59 | REV'D. PME |



- NOTES: (A₁)
1. - BRASS, COMP 22 1/2 HARD, PER SPEC QQ-B-626. (A₃)
 2. - NORMAL DIAMETRAL PITCH 64
 NORMAL PRESSURE ANGLE 20°
 NUMBER OF TEETH 48
 THEORETICAL PITCH DIAMETER .750
 BACKLASH .000 TO .001 WHEN REFERRED TO
 THEORETICAL PITCH CIRCLE
 CROWN TO BACK DIMENSION .280
 FACE ANGLE 65°-30'
 PITCH ANGLE 63°-26'
 MOUNTING DISTANCE .453
 AMERICAN STANDARD INVOLUTE TOOTH FORM
 ALL TERMS USED AS DEFINED BY A.G.M.A. STANDARDS
 3. - SLIGHT BURRS PERMISSIBLE IN .020 SLOTS. REMOVE ALL OTHER BURRS AND SHARP EDGES.
 4. - ECCENTRICITY BETWEEN PITCH DIAMETER & BORE SHALL NOT EXCEED .002 TIR.
 5. - FINISH: CHEMICAL POLISH PER IRIDITE #7 METCOTE PROCESS BU ALLIED RESEARCH PRODUCTS INC., BALTIMORE, MD., OR EQUAL.
- (C₁)

| UNLESS OTHERWISE SPECIFIED | AUTHENTICATION | DESCRIPTION | DATE | SCALE | NOTE |
|--|-------------------|-------------|------|-----------|------|
| DIMENSIONS ARE IN INCHES | DRAWN 27852-PH | GEAR | | SCALE 4/1 | |
| TOLERANCES ON FRACTIONS ± 1/64. | DRAWN -50-93 | | | | |
| DECIMALS ± .005 | TRACED PHOTO | | | | |
| ANGLES ± | CHECKED R. | | | | |
| COMMERCIAL TOLERANCES APPLY TO STOCK SIZES | VERIFIED P.D.B.R. | | | | |
| ALL SURFACES ✓ | APPROVED P.O.B.R. | | | | |
| | REVIEWED PME | | | | |
| | DATE 23-JUN-53 | | | | |

DEPARTMENT OF THE ARMY
SIGNAL CORPS ENGINEERING LABORATORIES
FORT MONMOUTH NEW JERSEY
SM-C-178700