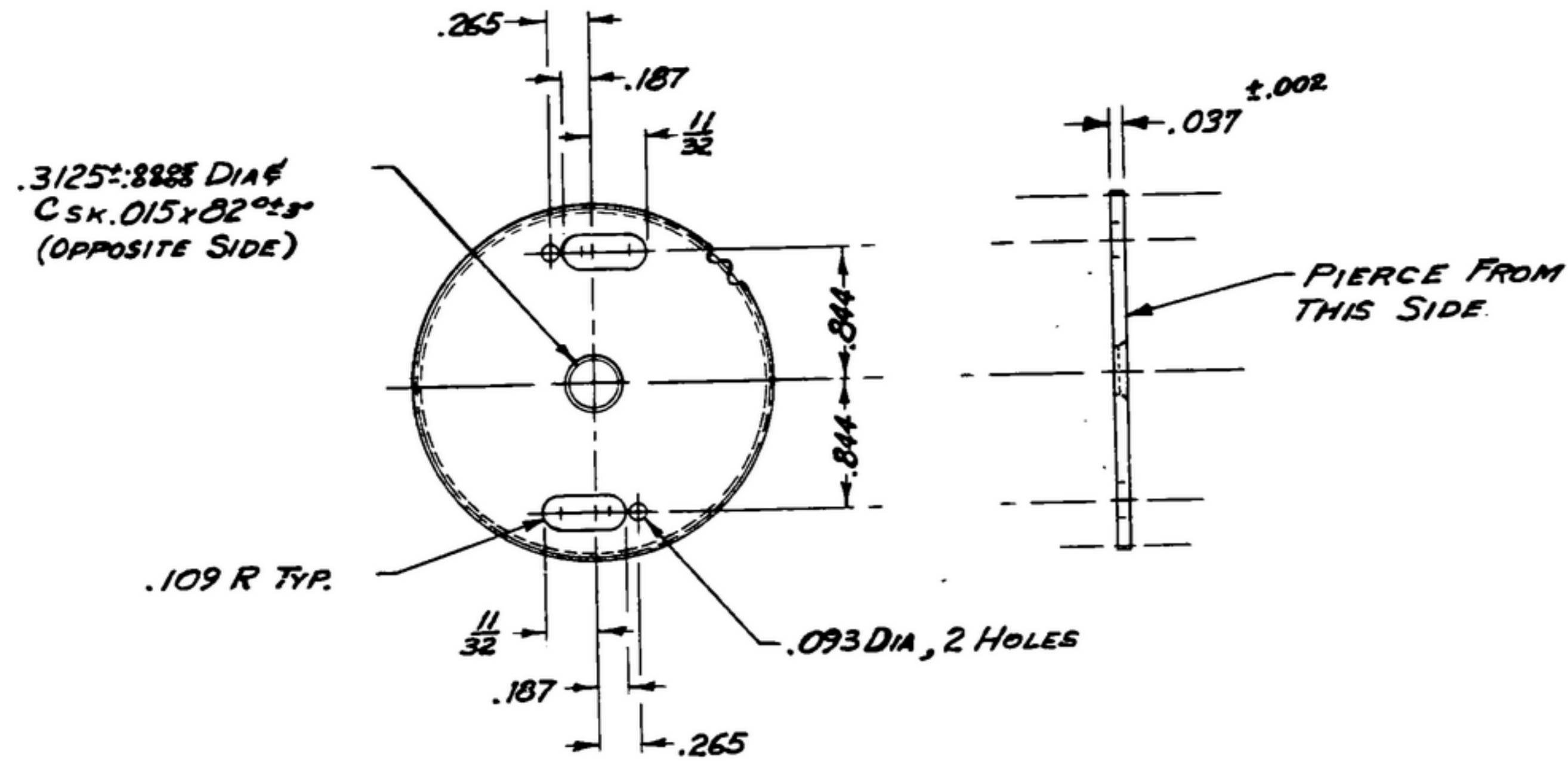


NOTICE: When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government hereby incurs no responsibility or obligation whatsoever, and the fact that the Government may have furnished, or in any way supplied the said drawings, specifications, or other data, shall not be regarded by implication or otherwise as in any way constituting an endorsement or approval by the Government of the quality, value, or use of any material, process, or method of manufacture, use or sale of 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	SWE. * APPROVAL	SYMBOL	REVISIONS DESCRIPTION	DATE	APPROVAL
SM-C-178957	SC-DL-178467	(A2)	A1	A1 - RENUMBERED NOTES, TYPE 302, 1/4 H WAS COMP G, ANNEALED; A2 - ADDED APPL. SM-C-178957, SC-DL-248775. A3 - ADDED FINISH NOTE.	1 OCT. 59	42428-PC-59-AI-51 REV'D. PME
SM-C-178957	SC-DL-248775	(A2)	B1	B1 - TYPE 301 1/2 HARD WAS TYPE 302 1/4 HARD.	7 APRIL 60	42428-PC-59 REV'D. PME



NOTES: (A1) (B1)

- (A1) 1. STEEL, TYPE 301 COND 1/2 HARD PER SPEC MIL-S-5059
- 2. GEAR DATA:
 NORMAL DIAMETRAL PITCH 48
 THEORETICAL PITCH DIAMETER 2.250
 PRESSURE ANGLE 14 1/2°
 NUMBER OF TEETH 108
 BACKLASH ON NORMAL PITCH CIRCLE WHEN MATED WITH MASTER: .0015-.0025
 AMERICAN STANDARD INVOLUTE TOOTH FORM.
- 3. GEAR MUST BE FLAT WITHIN .004 TIR.
- 4. REMOVE ALL BURRS AND SHARP EDGES.
- 5. ECCENTRICITY BETWEEN PITCH DIAMETER AND BORE MUST NOT EXCEED .002 TIR.
- (A3) 6. PASSIVATE: E 300 PER SPEC MIL-F-14072.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS ± 1/64 DECIMALS ± .005 ANGLES ± COMMERCIAL TOLERANCES APPLY TO STOCK SIZES ALL SURFACES ✓	AUTHENTICATION	GEAR	DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY
	DRAWN 2188-PH-20-93		
	TRACED PHOTO		
	CHECKED <i>Law</i>		
	VERIFIED P.D.B.R.		
	APPROVED P.D.B.R.		
REVIEWED PME	DATE 28 MAY 53	SCALE 1/1	SEE NOTE 5
			SM-C-178958