~~EQUIP. TYPE R390A/URR~~ ~~EXP. NO.~~

~~COL. 540 7474 002~~

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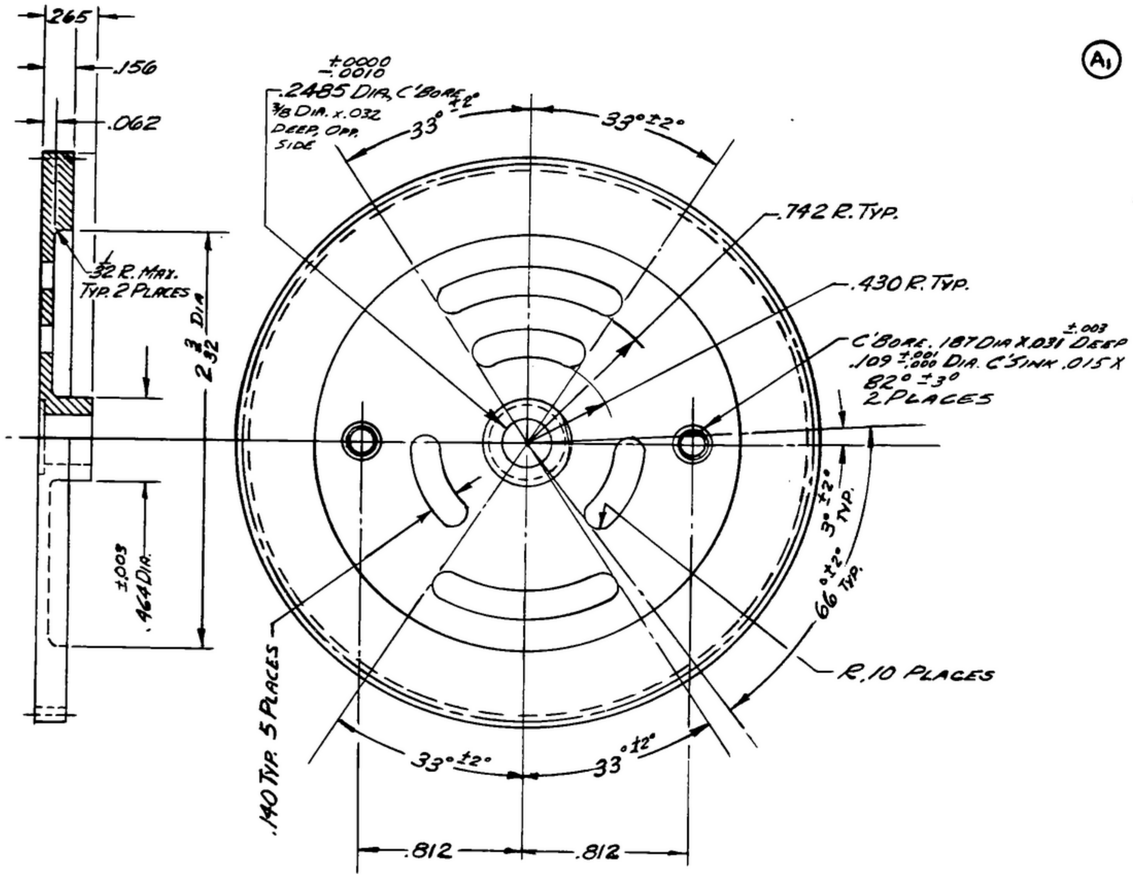
*FOR INFORMATION ONLY. CONTRACTOR MAY AT HIS OPTION DEVIATE FROM THESE PROCESS DETAILS.

*S.W.E. APPROVAL	
SYM	PR10042-5
B1	CA 84738

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A1	ADDED "IRIDITE #7" TO FIN. NOTE	9 OCT 59	42428-PC-59-A1-51 REV. D. PME
B1	B1 - WAS QQ-B-613	7 APRIL 60	42428-PC-59 REV. D. PME



BRASS, COMP 24, TEMPER 1/2H, PER SPEC QQ-B-626 (B1)

(A1) FINISH: CHEMICAL POLISH PER IRIDITE #7 METCOTE PROCESS BY ALLIED RESEARCH PRODUCTS INC, BALTIMORE MD, OR EQUAL.
~~* COLLINS 580 0034 00~~

NOTES:
1. REMOVE ALL BURRS.
2. GEAR DATA
   NORMAL DIAMETRAL PITCH 32
   NORMAL PRESSURE ANGLE 20°
   NUMBER OF TEETH 90
   THEORETICAL PITCH DIAMETER 2.8125

   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 AGMA STANDARD.

~~COLLINS PART NO.~~	~~ITEM~~	~~REQD~~	~~PART NO.~~	~~DESCRIPTION~~	~~MATL~~	~~MATL SPEC~~

LIST OF MATERIAL ~~COLLINS PART NO.~~ ~~558 0262 003~~

~~558 0299 002~~	~~1~~	~~SM-B-248950~~	~~SC-DL-248775~~
~~COLLINS NO.~~	~~QTY~~	NEXT ASSY	USED ON

APPLICATION

DRAWN ECS | CHECKED | APPROVED

UNLESS OTHERWISE SPECIFIED:
DECIMAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±.005
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 CO.~~ ~~CEDAR RAPIDS, IOWA~~
14214-PH-51-93

SIGNAL CORPS
REVIEWED PME
APPROVED HLY PME
DATE 14 DEC, 55

GEAR - CLUTCH

SCALE 2/1

DEPARTMENT OF THE ARMY
SIGNAL CORPS ENGINEERING LABORATORIES
FORT MONMOUTH NEW JERSEY

SM-C-248913

PD-794—074-3071-11—A4798—298007

WHEN REFERRING TO THIS DRAWING STATE DRAWING NO., APPLICABLE ISSUE SYMBOL, IF ANY, AND DATE