

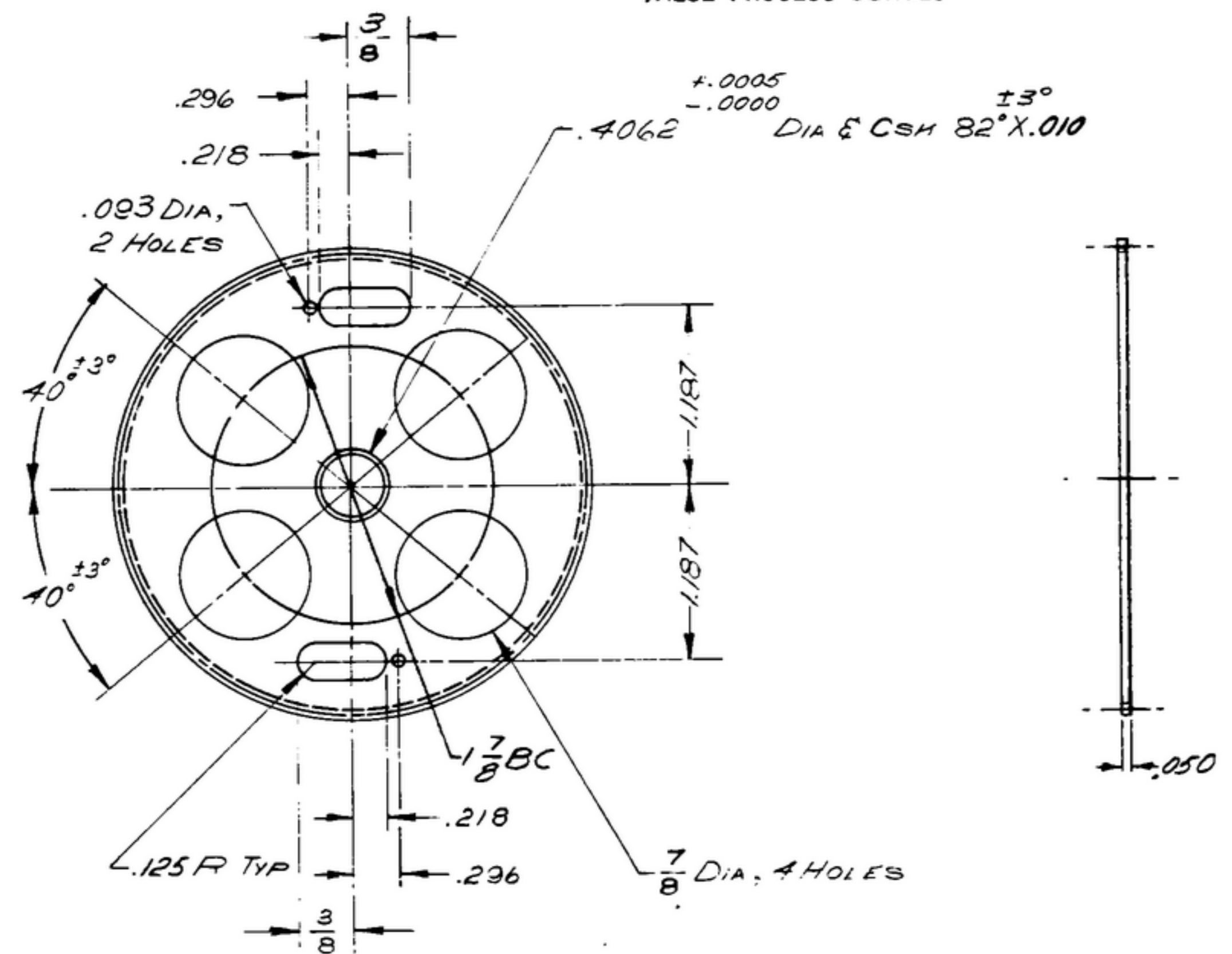
506-1017-002

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

NEXT ASSEMBLY		USED ON		REVISIONS			
(A2) SM-B-17906A	SC-DL-178467	SWE	APPROVAL	SYM	DESCRIPTION	DATE	APPROVAL
SM-B-248952	SC-DL-248775	SV	PR	A3	A1 ADDED FINISH NOTE #1 & RENUMBERED NOTES. A2 ADDED APPLICATION SM-B-248952 SC-DL-248775. A3 COMP. 302 WAS COMP. G.	8 OCT 59	42428-PC-59-A1-51 REUD. PME



- (A1) NOTES:
- FINISH: E300 PER SPEC. MIL-F-14072.
 - STEEL, COMPOSITION 302 COND. ANNEALED PER MIL-S-5059.
 - GEAR DATA:
 - NORMAL DIAMETRAL PITCH: 32
 - NORMAL PRESSURE ANGLE: 20°
 - NUMBER OF TEETH: 100
 - THEORETICAL PITCH DIAMETER: 3.125
 - BACKLASH .001 TO .002 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 STANDARDS.
 - REMOVE ALL BURRS AND SHARP EDGES.
 - PART MUST BE FLAT WITHIN .005 TYP.

UNLESS OTHERWISE SPECIFIED	AUTHENTICATION	DESCRIPTION	DATE	BY	HOW
DIMENSIONS ARE IN INCHES	DRAWN 21852-AV	GEAR			
TOLERANCES ON FRACTIONS ± 1/64	TRACED PHOTO				
DECIMALS ± .005	CHECKED <i>Wms</i>				
ANGLES ±	VERIFIED P.D.B.R.				
COMMERCIAL TOLERANCES APPLY TO STOCK SIZES	APPROVED P.D.B.R.				
ALL SURFACES ✓	REVIEWED PME	SCALE 1/1			
	DATE 18-JUNE-53				

DEPARTMENT OF THE ARMY
SIGNAL CORPS ENGINEERING LABORATORIES
FORT MONMOUTH NEW JERSEY
SM-C-85357

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