

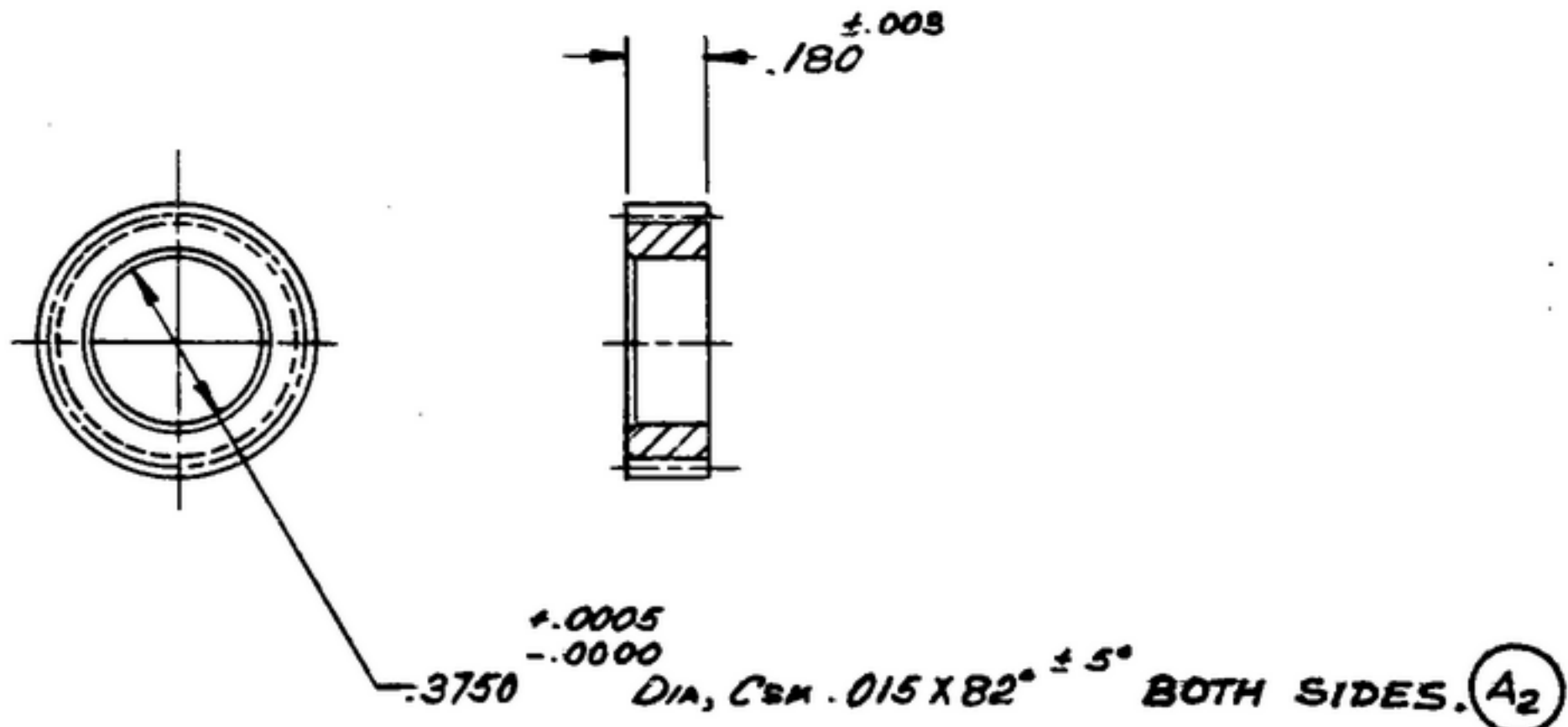
RBB. 7

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

NEXT ASSEMBLY	USED ON	SWE * APPROVAL	REVISIONS			
			SYM	DESCRIPTION	DATE	APPROVAL
SM-B-178861	SC-DL-178467	SWE * APPROVAL SY 10042- M -3	A4	A1 - WAS COMP. FM, AN-S-771, A2 - ADDED "BOTH SIDES" A3 - REVISED FIN. NOTE; A4 - ADDED APPL. SM-B-178861, SC-DL-248775	6 OCT. 59	42428-PC-59-A1-51 REV'D. PME
SM-B-178861	SC-DL-248775					
	SC-DL-144500					
			B1	B1, ADDED: "SURFACE COND c"	25 SEP 64	15283-PP-63 REVD EC-2



(A1) STEEL, COMPOSITION 303S CONDITION B, SURFACE COND c PER SPEC MIL-5-7120 (B1)

- 1-NORMAL DIAMETRAL PITCH : 48
- THEORETICAL PITCH DIAMETER : .583
- PRESSURE ANGLE : 14 1/2°
- NUMBER OF TEETH : 28
- BACKLASH ON NORMAL PITCH CIRCLE WHEN MATED WITH MASTER .0015-.0025.
- AMERICAN STANDARD INVOLUTE TOOTH FORM.
- 2- ECCENTRICITY BETWEEN BORE DIAMETER AND PITCH DIAMETER SHALL NOT EXCEED .002 TIR.

(A3) 3- FINISH: E 300 PER SPEC. MIL-F-14072.

UNLESS OTHERWISE SPECIFIED	AUTHENTICATION	SCALE	DEPARTMENT OF THE ARMY
DIMENSIONS ARE IN INCHES	DRAWN 21852-PA-50 53	2/1	SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY
TOLEANCES ON FRACTIONS ± $\frac{1}{16}$	TRACED PHOTO		
DECIMALS ± .005	CHECKED <i>[Signature]</i>	GEAR	SM-B-178863
ANGLES ±	VERIFIED P.D.BR.		
COMMERCIAL TOLERANCES APPLY TO STOCK SIZES	APPROVED P.D.BR.	DATE 29-JUNE-53	
ALL SURFACES ✓	REVIEWED PME	SCALE 2/1	
	DATE 29-JUNE-53	SEE NOTE 3	