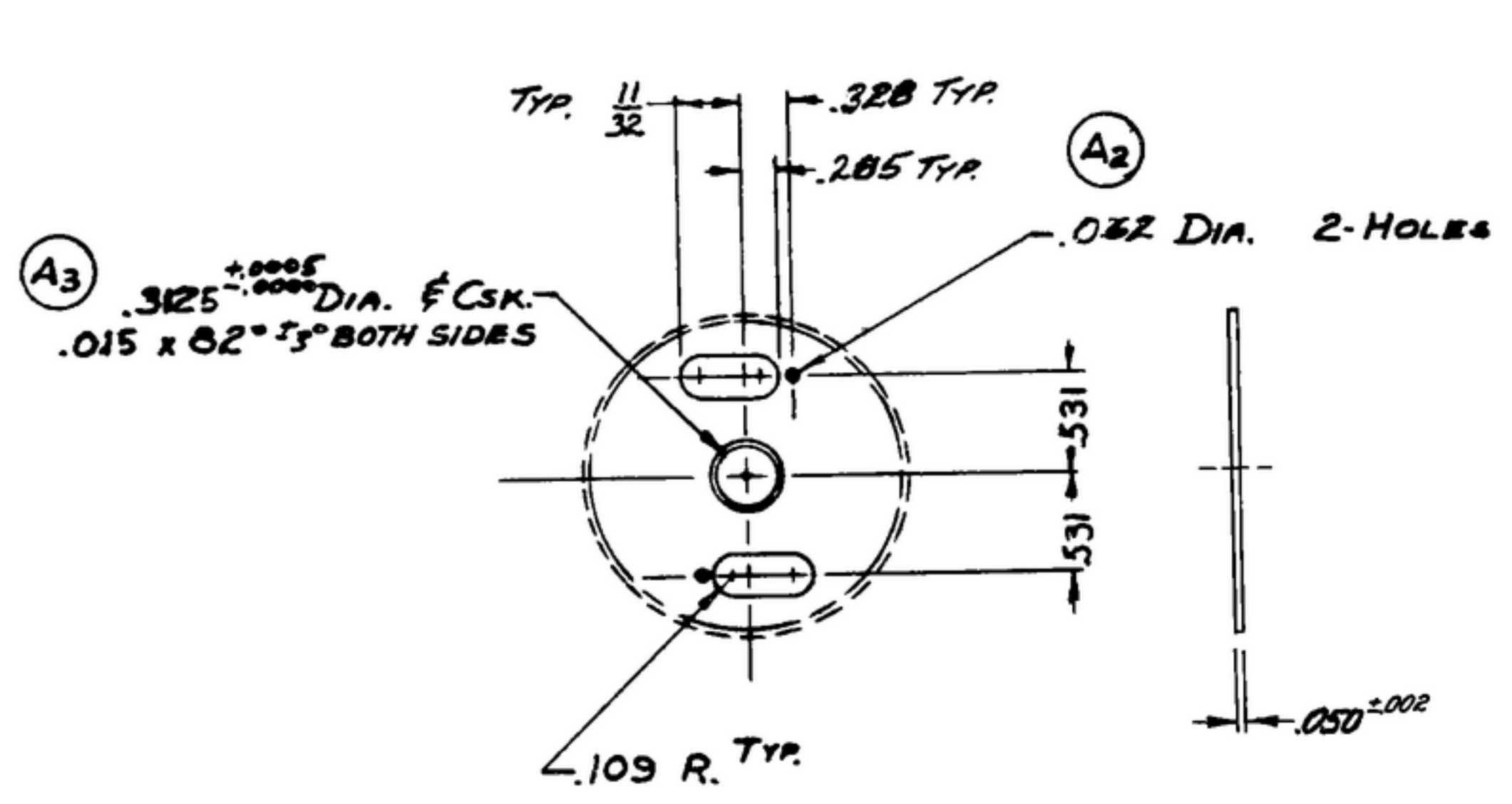


306-1869-002 R-

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

* SWE APPROVAL		REVISIONS		
SYM	DESCRIPTION	DATE	APPROVAL	
SYM PR10072 S				
A <sub>4</sub>	A <sub>1</sub> -STEEL SPEC. WAS COMP G; FINISH WAS MIL P-12011; A <sub>2</sub> - WAS .245; A <sub>3</sub> -REVISED C'SK; A <sub>4</sub> -ADDED APPL. SM-B-178919, SC-DL-248775.	9 OCT 59	42428-PC-59-A1-51	REV'D. PME



- NOTES:** (A<sub>1</sub>)
- 1.-STEEL COMP 301 COND 1/2H PER SPEC MIL-S-5059
  - 2.-GEAR DATA:  
 NORMAL DIAMETRAL PITCH 32  
 THEORETICAL PITCH DIAMETER 1.625  
 NUMBER OF TEETH 52  
 PRESSURE ANGLE 20°  
 BACKLASH .002 TO .003 WHEN REFERRED TO THE THEORETICAL PITCH CIRCLE  
 AMERICAN STANDARD INVOLUTE TOOTH FORM  
 ALL TERMS USED AS DEFINED BY A.G.M.A. STANDARDS
  - 3.-DIMENSIONS FOR SLOT & .062 DIAMETER HOLE ARE TYPICAL
  - 4.-ECCENTRICITY BETWEEN P.D. & BORE SHALL NOT EXCEED .002 T.I.R.
  - 5.-GEAR MUST BE FLAT WITHIN .003 T.I.R.
  - 6.-REMOVE ALL BURRS & SHARP EDGES
  - 7.-FINISH: E 300 PER SPEC MIL-F-14072.

QTY	PART NO.	DESCRIPTION	DATE	MATL SPEC
LIST OF MATERIAL				

		UNLESS OTHERWISE SPECIFIED		AUTHENTICATION		<b>GEAR</b>	SIGNAL CORPS ENGINEERING LABORATORIES  FORT MONMOUTH NEW JERSEY
		DIMENSIONS ARE IN INCHES		DRAWN 21822 - PN - 59-93			
		TOLERANCES ON FRACTIONS DECIMALS ANGLES		TRACED PHOTO			
		±1/64 ±.005		CHECKED <i>llm</i>			
				VERIFIED P.D.B.R.			
				APPROVED P.D.B.R.		<b>SM-B-178920</b>	
				REVIEWED PME			
				DATE 22-Nov-59			
NEXT ASSY		USED ON		SCALE 1/1			
APPLICATION				-See No. 12 6-			