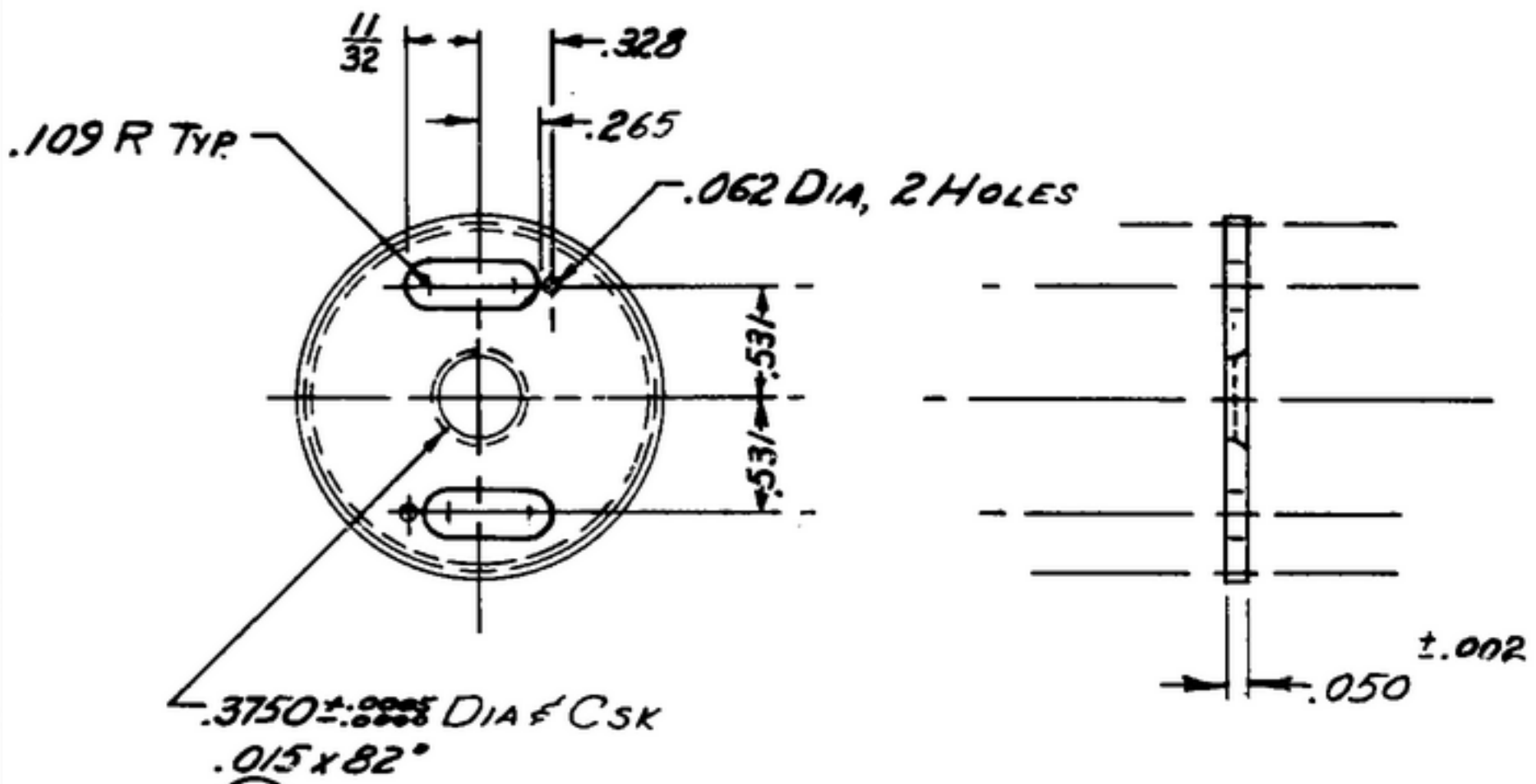


506-1870-002

506-1870-002 R-99

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 incurs no responsibility or obligation whatsoever; and the fact that the Government may have formulated, furnished, or in any way supplied the said drawings, specifications, or other data is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation, or conveying any rights or permission to manufacture, use or sell any patented invention that may in any way be related thereto.

NEXT ASSEMBLY	USED ON	SW E X APPROVAL	SYN	REVISIONS	DESCRIPTION	DATE	APPROVAL
(A ₂) SM-B-178921	SC-DL-178467	SWE X APPROVAL	A ₂	A ₁ - STEEL SPEC WAS "TYPE 302"		10 OCT. 59	42428-PC-59-A1-51
SM-B-178921	SC-DL-248775	SWE X APPROVAL		A ₂ - ADDED APPL SM-B-178921, SC-DL-248775			REV'D PME



- NOTES: (A₁)
1. STEEL, TYPE 301 COND 1/2 H PER SPEC MIL-S-5059
 2. -NORMAL DIAMETRAL PITCH 32
THEORETICAL PITCH DIAMETER 1.625
PRESSURE ANGLE 20°
NUMBER OF TEETH 52
BACKLASH ON NORMAL PITCH CIRCLE
WHEN MATED WITH MASTER .002-.003
AMERICAN STANDARD INVOLUTE TOOTH FORM
 3. -REMOVE ALL BURRS
 4. -GEAR MUST BE FLAT WITHIN .003 TIR
 5. -ECCENTRICITY BETWEEN PITCH DIAMETER & BORE SHALL NOT EXCEED .002 TIR.
 6. -DIMENSIONS FOR SLOT & .062 DIA HOLE ARE TYPICAL.

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

ISS.	PART NO.	DESCRIPTION	DATE	QTY	NOTE
		GEAR			

UNLESS OTHERWISE SPECIFIED	AUTHENTICATION	<p>DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY</p> <p>SM-B-178922</p>
DIMENSIONS ARE IN INCHES	DRAWN 21832-PH-50-99	
TOOLERANCES ON	TRACED PHOTO	
FRACTIONS ± 1/64	CHECKED R _h	
DECIMALS ± .005	VERIFIED P.D.B.R.	
ANGLES ±	APPROVED P.D.B.R.	
COMMERCIAL TOLERANCES APPLY TO STOCK SIZES	REVIEWED PME	SCALE 1/1
ALL SURFACES ✓	DATE 30 JUN-53	

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