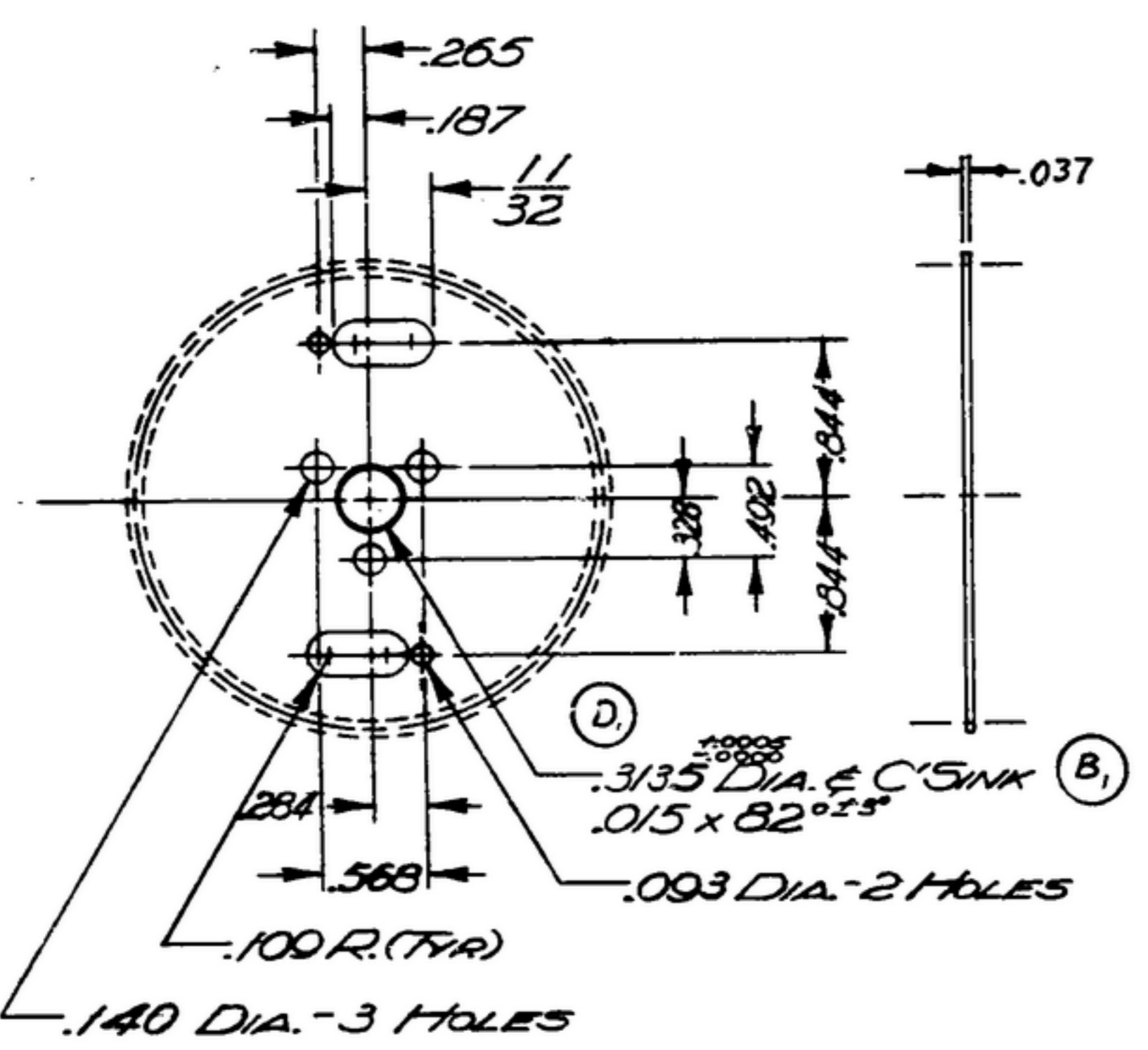


506 7328-002 R-391

X SWE APPROVAL		REVISIONS			
SYM	PR 10042-2	SYM	DESCRIPTION	DATE	APPROVAL
		A <sub>1</sub>	A <sub>1</sub> - RENUMBERED NOTES; A <sub>2</sub> - ADDED APPL 5D-248975, SM-D-343600, SC-DL-248775; A <sub>3</sub> COMP 302 WAS COMP G; A <sub>4</sub> FINISH WAS PER SPEC MIL-P-20H	1 OCT 53	42428-PC-53 -A1-51 REC
B	C.A.84590	B	B <sub>1</sub> - .313 <sup>+0.001</sup> / <sub>-.000</sub> WAS .3125 <sup>+0.0005</sup> / <sub>-.0000</sub>	10 DEC 54	42428-PC-53 -A1-51 REC
C	C.A.84693	C	C <sub>1</sub> - IN NOTE 1, 301 WAS 302	5 APRIL 60	42428-PC-53 -A1-51 REC
D	C.A.84934	D	(1) WAS .313 <sup>+0.001</sup> / <sub>-.000</sub>	30 NOV 60	42428-PC-53 -A1-51 REC

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 THEREBY INCURS NO LIABILITY FOR ANY INADEQUACY, UNRELIABILITY, OR THE FACT THAT THE GOVERNMENT HAS NOT REPRODUCED, FORWARDED, OR IN ANY WAY SUPPLIED THE SAID DRAWINGS, SPECIFICATIONS, OR OTHER DATA TO BE OBSERVED BY IMPLICATION OR OTHERWISE AS IN ANY BARRIER LICENSING THE HOLDER OR ANY OTHER PERSON OR ORGANIZATION, OR OBSERVING ANY RIGHTS OR FURNISHING TO MANUFACTURE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THEREBY.

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



- NOTES:
- STEEL, COMP 301, COND 1/2 H, PER SPEC MIL-S-5059.
  - NORMAL DIAMETRAL PITCH 48  
 NORMAL PRESSURE ANGLE 14 1/2°  
 NUMBER OF TEETH 108  
 THEORETICAL PITCH DIAMETER 2.250  
 BACKLASH .0015 TO .0025 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.
  - GEAR MUST BE FLAT WITHIN .004 TIR.
  - PASSIVATE: E300 PER SPEC MIL-F-14072

QTY	PART NO.	DESCRIPTION	MATL	MATL SPEC
LIST OF MATERIAL				

UNLESS OTHERWISE SPECIFIED		AUTHENTICATION		GEAR	SIGNAL CORPS ENGINEERING LABORATORIES PORT MONMOUTH NEW JERSEY  SM-C-178931
DIMENSIONS ARE IN INCHES		DRAWN 2783-PH-50-93			
TOLERANCES ON		TRACED PHOTO			
FRACTIONS	DECIMALS	ANGLES	CHECKED		
±1/64	±.005	✓	VERIFIED P.D.B.R.		
			APPROVED P.D.B.R.		
			REVIEWED P.M.E.		
NEXT ASSY	USED ON	DATE 27-Oct-1953	SCALE 1/1	SEE NOTE 1	
APPLICATION					
SM-D-248975	↑				
SM-D-343600	SC-DL-24				
SM-B-178977	↑				
SM-B-178929	SC-DL-170917				