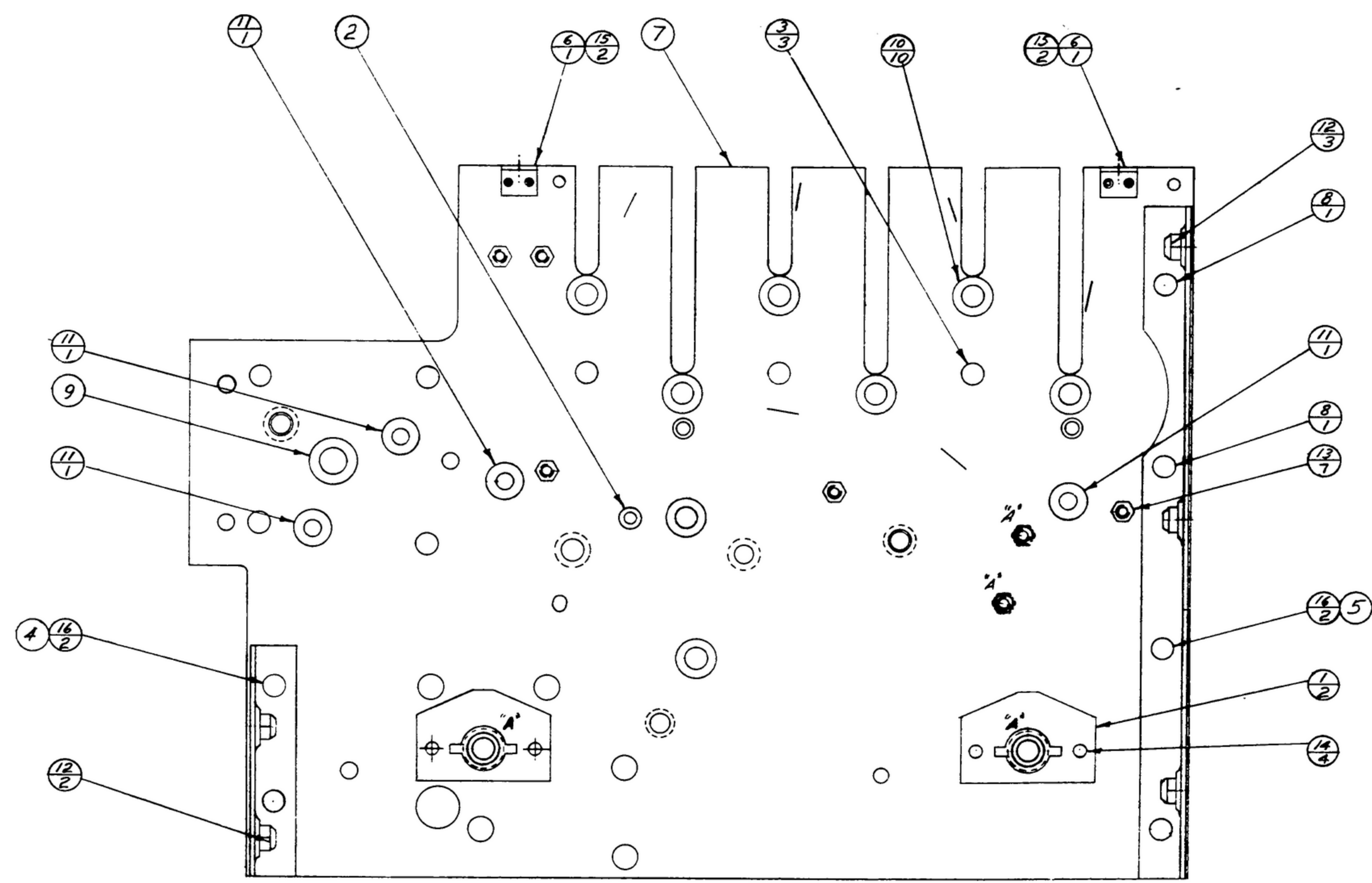


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| REVISIONS |             |      |          |
|-----------|-------------|------|----------|
| BY        | DESCRIPTION | DATE | APPROVAL |



- NOTES:
- PRESS BEARINGS (9,10) & NUTS (13), INTO PLATE (7).
  - BEARINGS & NUTS MARKED "A" TO BE PRESSED IN FROM OPPOSITE SIDE SHOWN.
  - RIVET BRACKET (5) TO PLATE (7) USING RIVETS (8 & 16).
  - RIVET BRACKET (4) TO PLATE (7) USING RIVETS (16).
  - RIVET HEADS TO BE ON OPPOSITE SIDE SHOWN.
  - BURNISH BEARING (9) TO .3125<sup>+0.0005</sup> DIA., BEARINGS (10) TO .2500<sup>+0.0005</sup> DIA. & BEARINGS (11) TO .1875<sup>+0.0005</sup> DIA.
  - PRESS STUD (2) INTO PLATE (7) FROM SIDE SHOWN, AND STAKE OR ROLL OPPOSITE SIDE.
  - PRESS PINS (3) INTO PLATE (7) FROM OPPOSITE SIDE. PINS TO BE FLUSH TO 1/4 BELOW SURFACE SHOWN.
  - RIVET PLATE (1) TO PLATE (7) USING RIVETS (14).
  - SECURE BRACKET (6) TO PLATE (7) WITH RIVETS (15). RIVET HEADS TO BE ON OPPOSITE SIDE FROM BRACKET.
  - PLATE TO BE FLAT WITHIN .025 TIR.
  - SLOTS TO BE .265<sup>+0.002</sup> AFTER ASSY.
  - IN ALL SPLIT BALLOONS TOP FIGURE IS MATERIAL LIST ITEM INDICATOR & BOTTOM FIGURE IS QUANTITY.

|              |    |    |                                  |
|--------------|----|----|----------------------------------|
| 305 1171 00  | 16 | 4  | AN470AD4-6 RIVET                 |
| 305 0106 00  | 15 | 4  | AN456AD3-6 RIVET                 |
| 305 1375 00  | 14 | 4  | AN426AD4-6 RIVET                 |
| 553 0257 003 | 13 | 7  | SM-C-283166-4 NUT-INSERT CAPTIVE |
| 553 0251 002 | 12 | 5  | SM-B-283164-1 NUT-STOP           |
| 553 0242 002 | 11 | 4  | SM-B-283158 BEARING              |
| 553 0241 002 | 10 | 10 | SM-B-283157 BEARING              |
| 553 0240 003 | 9  | 1  | SM-C-283156-3 BEARING            |
| 553 0236 002 | 8  | 2  | SM-B-249262 RIVET                |
| 553 0330 004 | 7  | 1  | SM-D-248981 PLATE-FRONT GEAR     |
| 553 0323 002 | 6  | 2  | SM-B-248976 BRACKET-DUST COVER   |
| 553 0277 003 | 5  | 1  | SM-C-248928 BRACKET-LONG         |
| 553 0276 003 | 4  | 1  | SM-C-248927 BRACKET-SHORT        |
| 553 0268 002 | 3  | 3  | SM-B-248919 PIN-GUIDE            |
| 553 0248 002 | 2  | 1  | SM-B-248899 STUD-GEAR            |
| 553 0219 003 | 1  | 2  | SM-B-248871 PLATE-LOCKING        |

| COLLINS-PART NO. | ITEM | REQD | PART NO. | DESCRIPTION | MATL | MATL SPEC |
|------------------|------|------|----------|-------------|------|-----------|
|------------------|------|------|----------|-------------|------|-----------|

|                        |  |                        |                   |                                     |  |
|------------------------|--|------------------------|-------------------|-------------------------------------|--|
| DRAWN<br><i>Hamer</i>  |  | CHECKED<br><i>Ham</i>  | APPROVED          | COLLINS-PART NO.<br>14 214-PH-51-93 | DEPARTMENT OF THE ARMY<br>SIGNAL CORPS ENGINEERING<br>LABORATORIES<br>FORT MONMOUTH NEW JERSEY |
| REVIEWED<br><i>PME</i> |  | APPROVED<br><i>PLY</i> | DATE<br>29 DEC 55 | SCALE<br>1/1                        |  |
| APPLICATION            |  |                        | SM-D-248981       | PLATE ASSY-FRONT GEAR               |  |