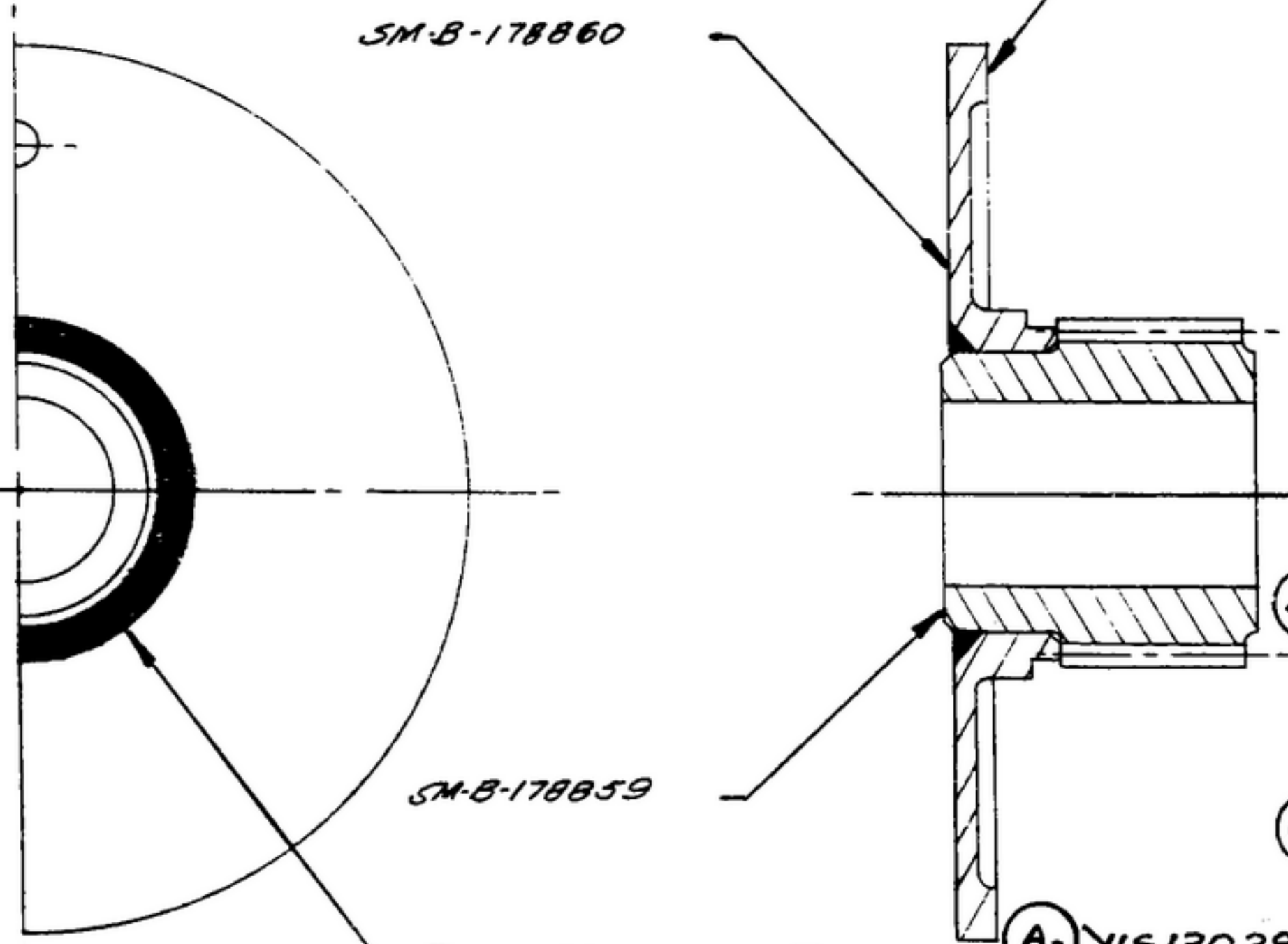


NOTICE: WHEN GOVERNMENT DRAWINGS, SPECIFICATIONS, OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A DEFINITELY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY FOR ANY OBLIGATION WHATSOEVER; AND THE FACT THAT THE GOVERNMENT MAY 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 THERE TO.

THIS SURFACE MUST BE FLAT WITHIN .006 TIR AFTER SOLDERING



FLOW UNIFORM FILLET OF SOLDER THIS SIDE ONLY

| * SWE APPROVAL | | REVISIONS | | | |
|----------------|------------|----------------|---|------------|------------------------------|
| SYM | PR 10042-3 | SYM | DESCRIPTION | DATE | APPROVAL |
| | | A ₃ | A ₁ -WAS 51F4; A ₂ -ADDED APPL. SC-DL-248775; A ₃ -ADDED TO LIST OF MAT'L FLUX, & SILVER SOLDER. | 6 OCT. 59 | 42428-PC-59-A1-51 REV'D. |
| | | B ₁ | B ₁ -10S111330-3 WAS 10S130020 | 17 MAY 60 | 42428-PC-59 REV'D |
| | | C ₁ | (1)-NOTE *7 ADDED. | 15 SEP. 60 | 42428-PC-59 REV'D. P.M.E. |

- 1- GEAR DATA**
 NORMAL DIAMETRAL PITCH: 48
 NORMAL PRESSURE ANGLE: 14 1/2°
 NUMBER OF TEETH: 56
 THEORETICAL PITCH DIAMETER: 1.166
 BACKLASH ON NORMAL PITCH CIRCLE WHEN MATED WITH MASTER: .0015-.0025
 AMERICAN STANDARD INVOLUTE TOOTH FORM
- 2- SILVER SOLDER SHALL BE PER SPEC QQ-S-561, CLASS 4 OR 6, USING FLUX PER US NAVY SPEC. O-F-499.**
3- AFTER SOLDERING, HUB, SM-B-178860 AS INDICATED.
4- ECCENTRICITY BETWEEN BORE AND PITCH DIAMETERS SHALL NOT EXCEED .003 TIR.
5- AXIAL RUNOUT SHALL NOT EXCEED .006 TIR AT .500 RADIUS.
6- PART MUST BE FREE OF BURRS & SHARP EDGES.
7- FINISH: CHEMICAL POLISH PER IRIDITE *7 METCOTE PROCESS BU ALLIED RESEARCH PRODUCTS INC., BALTIMORE MD., OR EQUAL.

| * SWE PART NO. | REQD | PART NO. | DESCRIPTION | MATL | MATL SPEC | |
|----------------------------|------|----------|---------------------|------|-----------|---|
| A ₃ 10S130298 | A/R | | FLUX. | | | 2 |
| B ₁ 10S111330-3 | A/R | | SOLDER, SILVER | | | 2 |
| | | | 1 SM-B-178860 BLANK | | | |
| | | | 1 SM-B-178859 GEAR | | | |

LIST OF MATERIAL

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

| UNLESS OTHERWISE SPECIFIED | | AUTHENTICATION | | <p align="center">GEAR ASSY</p> <p align="center">SIGNAL CORPS ENGINEERING LABORATORIES</p> <p align="center">PORT MONMOUTH NEW JERSEY</p> <p align="center">SM-B-178858</p> |
|---|--------------|----------------------------|------------|--|
| DIMENSIONS ARE IN INCHES | | DRAWN 21852-PH-58-93 | | |
| TOLERANCES ON FRACTIONS DECIMALS ANGLES | | TRACED PHOTO | | |
| | | CHECKED <i>[Signature]</i> | | |
| A ₂ SM-C-178855 | SC-DL-248775 | VERIFIED | P.D.B.R. | |
| SM-C-178855 | SC-DL-178967 | APPROVED | P.D.B.R. | |
| NEXT ASSY | USED ON | REVIEWED | P.M.E. | |
| APPLICATION | | DATE | 4-AUG-1953 | |
| | | SCALE | 4/1 | —80-585— |