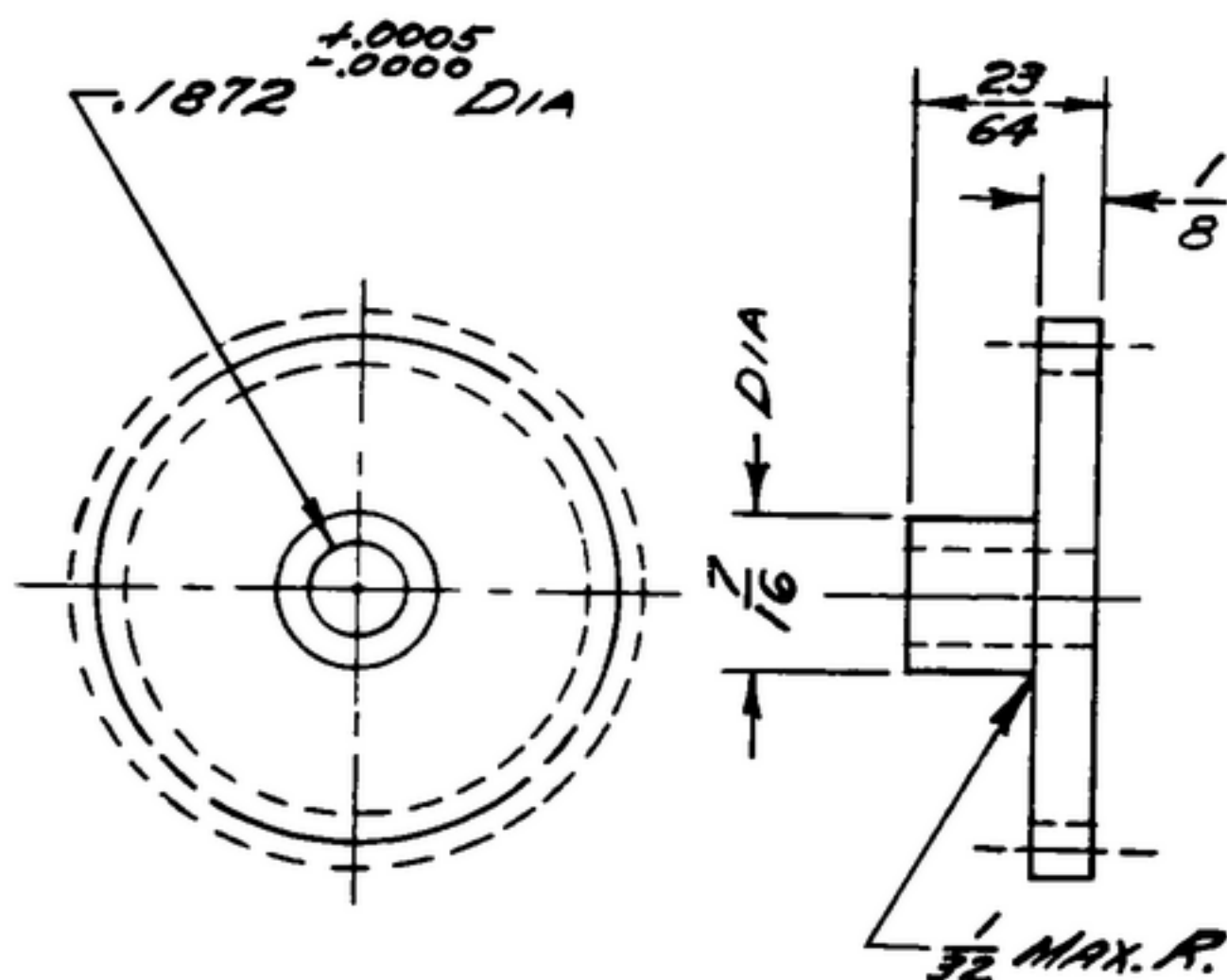


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* FOR INFORMATION ONLY. CONTRACTOR MAY AT HIS OPTION DEVIATE FROM THESE PROCESS DETAILS.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
SYM	PR10042-4		
A1	A, ADDED IRIDITE #7 TO FINISH NOTE	8 OCT 59	42428-PC-59 PME



NOTES:

- GEAR DATA
 NORMAL DIAMETRAL PITCH 48
 NORMAL PRESSURE ANGLE 20°
 NUMBER OF TEETH 50
 THEORETICAL PITCH DIAMETER 1.0417
 BACKLASH .002 TO .003 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 AMGA STANDARDS

BRASS, COMP 24, TEMPER 1/2H, PER SPEC QQ-B-613.

(A) FINISH: CHEMICAL POLISH PER IRIDITE #7 METCOTE PROCESS BY ALLIED RESEARCH PRODUCTS INC, BALTIMORE, MD, OR EQUAL. (* SAME AS 572167)
 * COLLINS 580 0034 00

COLLINS PART NO.	ITEM	REQD	PART NO.	DESCRIPTION	MATL.	MATL. SPEC.
LIST OF MATERIAL						
COLLINS PART NO. 558 0239 002						

558-0294002	SM-B-248890	SC-DL-248775
COLLINS NO.	QTY.	NEXT ASSY
USED ON		
APPLICATION		

DRAWN NUGEN
 CHECKED *Rm*
 APPROVED

UNLESS OTHERWISE SPECIFIED:
 DECIMAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±.005
 FRACTIONAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±1/64
 MACHINED ANGLES MAY VARY ±.1°
 SHEARED ANGLES MAY VARY ±.25°
 BROKEN ANGLES MAY VARY ±.1°
 ECCENTRICITY BETWEEN ANY DIAMETERS ON THE SAME CENTERLINE SHALL NOT EXCEED .010 TOTAL INDICATOR READING.
 ALL DIMENSIONS ARE FINISH DIMENSIONS INCLUDING APPLIED FINISH AND ARE GIVEN IN INCHES.

COLLINS RADIO CO.
 14214-PH-51-93
 SIGNAL CORPS
 REVIEWED PME
 APPROVED HLY PME
 DATE 14 DEC 55 SCALE 2/1

DEPARTMENT OF THE ARMY
 SIGNAL CORPS ENGINEERING
 LABORATORIES
 FORT MONMOUTH NEW JERSEY
 SM-B-248890