

NOTICE: WHEN GOVERNMENT DRAWINGS, SPECIFICATIONS, OR OTHER DATA ARE USED FOR ANY PURPOSE OTHER THAN IN CONNECTION WITH A SPECIFICALLY RELATED GOVERNMENT PROCUREMENT OPERATION, THE UNITED STATES GOVERNMENT THEREBY INCURS NO RESPONSIBILITY FOR ANY MISUSE OR NEGLIGENCE, AND THE FACT THAT THE GOVERNMENT MAY HAVE FORMULATED, PROVIDED, OR IN ANY WAY SUPPLIED THE SAID DRAWINGS, SPECIFICATIONS, OR OTHER DATA IS NOT TO BE REGARDED BY REPLICATORS OR OTHERWISE AS IN ANY MANNER LICENSES THE HOLDER OR ANY OTHER PERSON OR CORPORATION, OR CONFERRING ANY RIGHTS OR PERMISSION TO MANUFACTURE, USE, OR SELL ANY PATENTED INVENTION THAT MAY IN ANY WAY BE RELATED THERETO.

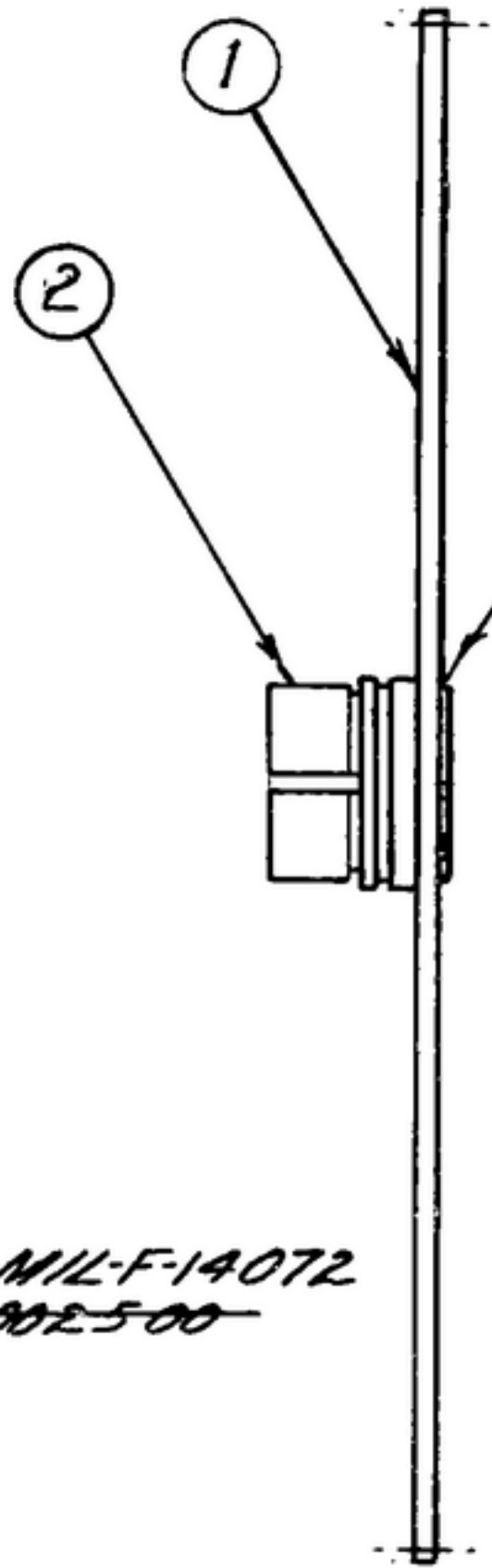
THIS DOCUMENT HAS BEEN PURCHASED BY THE GOVERNMENT AND MAY BE REPRODUCED AND USED IN CONNECTION WITH ANY GOVERNMENT PROCUREMENT OR MANUFACTURE OPERATION.

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

REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
A₃	A₁-NOTE 1 WAS SOLDER CLASS 4 OR 6, USING FLUX PER U.S. NAVY SPEC 51 F 4. A₂-ADDED APPL. SM-D-343600; A₃-ADDED ITEMS 3 AND 4;	9 OCT. 59	42428-PC-59-A1-51 REV'D. PME
B ₁	B ₁ -10S111330-4 WAS 10S130020	17 MAY 60	42428-PC-59 REV'D. PME

*SWE APPROVAL	
SYM	PR10043-5
B ₁	CA 84781



FLOW UNIFORM FILLET OF SOLDER ALL AROUND THIS SIDE ONLY

- NOTES:
1. SILVER SOLDER SHALL BE PER SPEC QQ-S-561, CLASS 4 USING FLUX PER U.S. NAVY SPEC.
 2. PRESS C'SINK SIDE OF GEAR (1) FLUSH AGAINST SHOULDER OF HUB(2) AS SHOWN & SILVER SOLDER.
 3. GEAR MUST BE FLAT WITHIN .008 T.I.R.
 4. SIDE RUNOUT OF .015 PERMISSIBLE.

FINISH: E300 PER SPEC MIL-F-14072
*COLLINS 580-002500

QTY	AS REQ'D	PART NO.	DESCRIPTION	MATL	MATL SPEC
4	AS REQ'D	FLUX			1
3	AS REQ'D	SOLDER, SILVER			1
2	1	SM-B-248951	HUB-TUNING SHAFT		
1	1	SM-C-85357	GEAR		

*SWE. PART NO.	ITEM	REQD	PART NO.	DESCRIPTION	MATL	MATL SPEC
US30298						
10S111330-4						

LIST OF MATERIAL - COLLINS PART NO. 580-0301-002

COLLINS NO.	QTY	NEXT ASSY	USED ON
558-0324-004	1	SM-D-248975	SM-D-248775

DRAWN HENRY
CHECKED *[Signature]*
APPROVED

UNLESS OTHERWISE SPECIFIED:
DECIMAL DIMENSIONS INCLUDING HOLE SIZES MAY VARY ±.008
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.
GEAR-RAPID-187A
14219-PH
51-93

SIGNAL CORPS
REVIEWED PME
APPROVED HLY
PME

DATE 6 DEC 55 SCALE 2/1

GEAR A554-MC

DEPARTMENT OF THE ARMY
SIGNAL CORPS ENGINEERING
LABORATORIES
FORT MONMOUTH NEW JERSEY

SM-B-248952