

506 6535 002 R391

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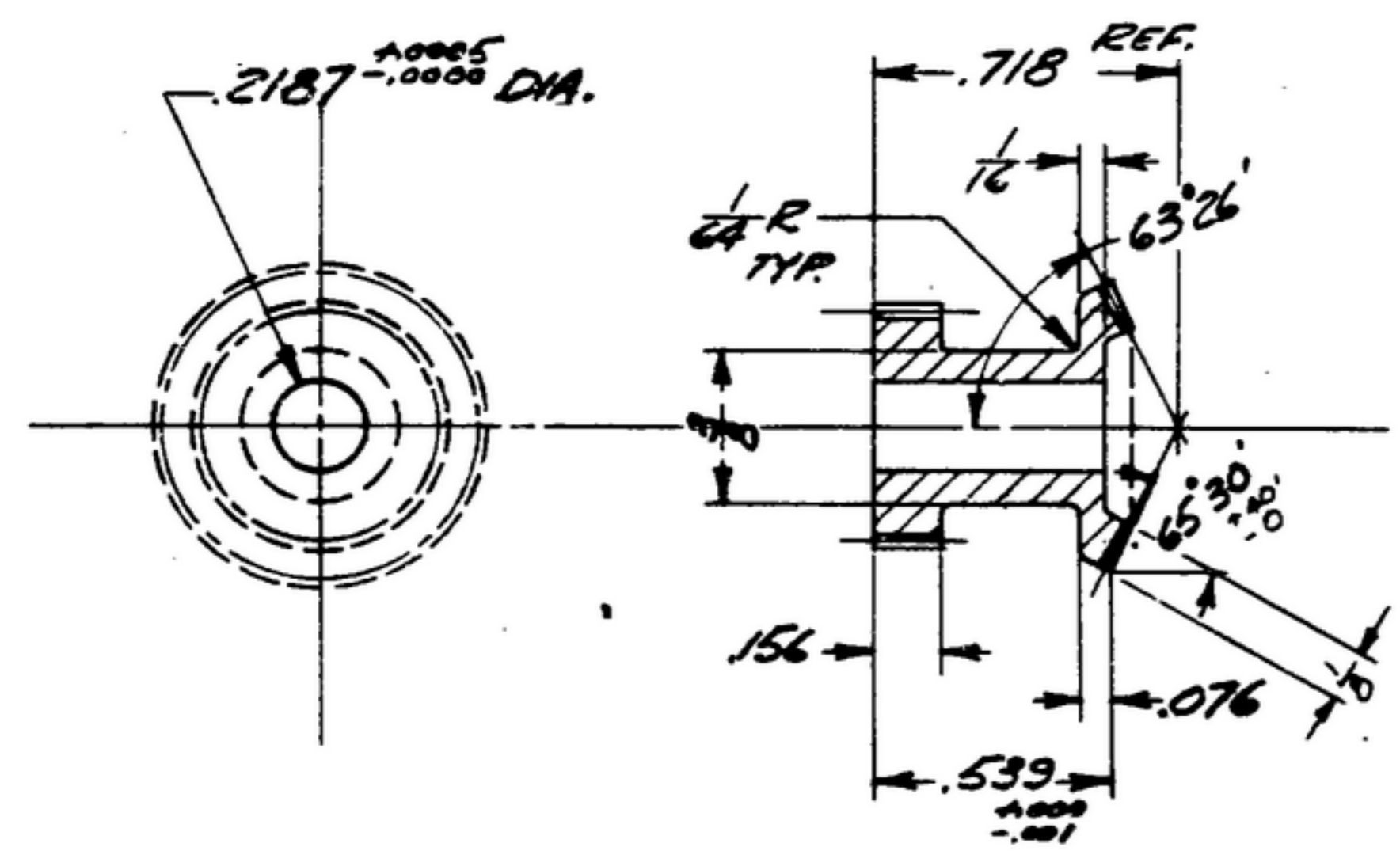
NOTE:
*FOR INFORMATION ONLY, CONTRACTOR MAY AT HIS OPTION DEVIATE FROM THESE PROCESS DETAILS

*SWE. APPROVAL
SYM PR10072-4

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A ₂	A ₁ -REVISED FIN NOTE, WAS PER SPEC. MIL-P-12011; A ₂ -ADDED APPL. SM-B-178752, SC-DL-248775.	8 OCT. 59	42428-PC-59-A1-51 REV'D. P.T.E.

GEAR DATA:
 NORMAL DIAMETRAL PITCH 48
 NORMAL PRESSURE ANGLE 20°
 NUMBER OF TEETH 27
 THEORETICAL PITCH DIAMETER .5625
 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 A.G.M.A. STANDARDS

BEVEL GEAR DATA:
 NORMAL DIAMETRAL PITCH 64
 NORMAL PRESSURE ANGLE 20°
 NUMBER OF TEETH 48
 THEORETICAL PITCH DIAMETER .750
 BACKLASH .000 TO .001 WHEN REFERRED TO THE THEORETICAL PITCH CIRCLE
 CROWN TO BACK DIMENSION .539 TO .538
 FACE ANGLE 65°30' ±.40'
 PITCH ANGLE 63°41' TO 63°11'
 MOUNTING DISTANCE .718
 AMERICAN STANDARD INVOLUTE TOOTH FORM
 ALL TERMS USED AS DEFINED BY A.G.M.A. STANDARDS
 SEE NOTE NO. 1 (PERTINENT TO BEVEL GEAR ONLY)



STEEL CLASS 7 TIDEA PER SPEC QQ-5-763

- 1- ECCENTRICITY BETWEEN PITCH DIAMETER & BORE SHALL NOT EXCEED .002 T.I.R. (BEVEL GEAR)
- 2- PART MUST BE FREE OF BURRS & SHARP EDGES.
- 3- BEVEL GEAR TO BEVEL PINION RATIO 48:24.
- 4- FINISH: E 200 PER MIL-F-14072.

QTY	PART NO.	DESCRIPTION	UNIT	UNIT QTY
LIST OF MATERIAL				

UNLESS OTHERWISE SPECIFIED		AUTHENTICATION		GEAR	SIGNAL CORPS ENGINEERING LABORATORIES PORT MONMOUTH NEW JERSEY SM-C-178753
DIMENSIONS ARE IN INCHES		DRAWN 2182-PC-59-93			
TOLERANCES ON FRACTIONS DECIMALS ANGLES		TRACED PHOTO			
±.005 ±.005		CHECKED			
		VERIFIED P.D.B.R.			
NEXT ASSY USED ON		APPROVED P.D.B.R.			
APPLICATION		REVIEWED P.M.E.			
		DATE 27-OCT-59		SCALE 2/1	