

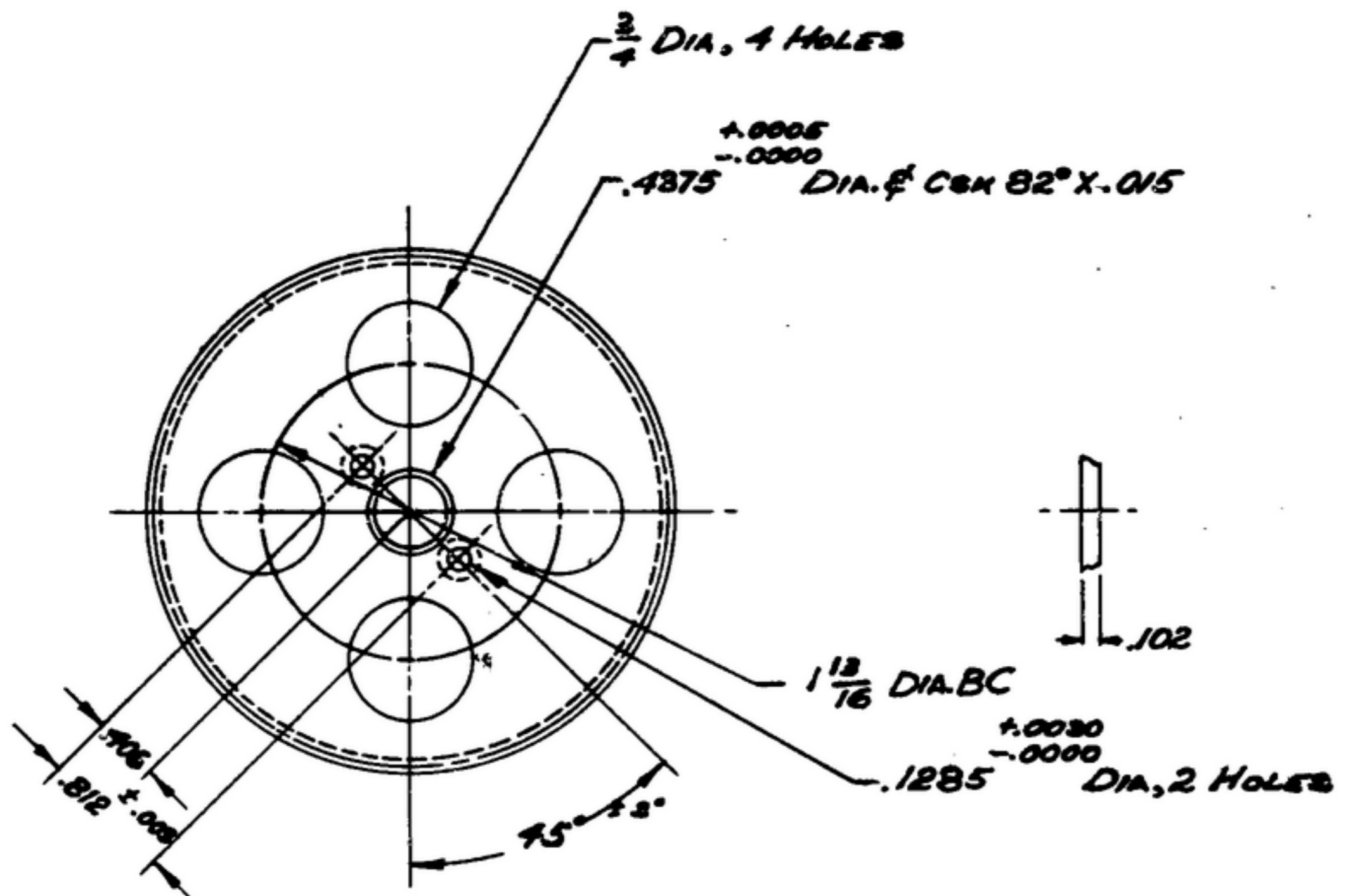
506-1820-002 R-391

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

APPROVAL	SYMBOL	DATE	DESCRIPTION	DATE	APPROVAL
SM-B-178935	SC-DL-176467				
SM-B-178935	SC-DL-248775				
A ₂		8 OCT. 59	A ₁ - RENUMBERED NOTES; A ₂ - ADDED APPL. SM-B-178935, SC-DL-248775.		REV'D. PME
B ₁		28 FEB. 60	B ₁ - WAS QQ-B-626.		REV'D. PME
C ₁		15 SEP. 60	(1) - ADDED NOTE #5.		REV'D. PME



- NOTES: (A₁) (B₁) (C₁)
- BRASS COMPOSITION 1, 1/2 HARD, PER SPEC QQ-B-613
 - NORMAL DIAMETRAL PITCH: 32
 THEORETICAL FITCH DIAMETER 3.125
 NUMBER OF TEETH 100
 PRESSURE ANGLE 20°
 BACKLASH ON NORMAL PITCH CIRCLE WHEN MATED WITH MASTER.001-.002.
 AMERICAN STANDARD INVOLUTE TOOTH FORM.
 - ECCENTRICITY BETWEEN PITCH DIAMETER AND BORE MUST NOT EXCEED .002 TIR.
 - REMOVE ALL BURRS & SHARP EDGES.
 - FINISH: CHEMICAL POLISH PER IRIDITE #7 METCOTE PROCESS BU ALLIED RESEARCH PRODUCTS INC., BALTIMORE, MD., OR EQUAL.

UNLESS OTHERWISE SPECIFIED	AUTHENTICATION	ISSUE	DATE	NOTE
DIMENSIONS ARE IN INCHES	DRAWN 2182-PH-50-93			
TOLERANCES ON FRACTIONS ± 1/64	TRACED PHOTO			
DECIMALS ± .005	CHECKED [Signature]			
ANGLES ±	VERIFIED P.D.B.R.			
COMMERCIAL TOLERANCES APPLY TO STOCK SIZES	APPROVED P.D.B.R.			
ALL SURFACES	REVIEWED PME			
	DATE 22 JUNE 58	SCALE 1/1	90-585	

GEAR

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

SM-C-178937

WHEN REFERRING TO THIS DRAWING STATE DRAWING NO., APPLICABLE ISSUE SYMBOL AND DATE