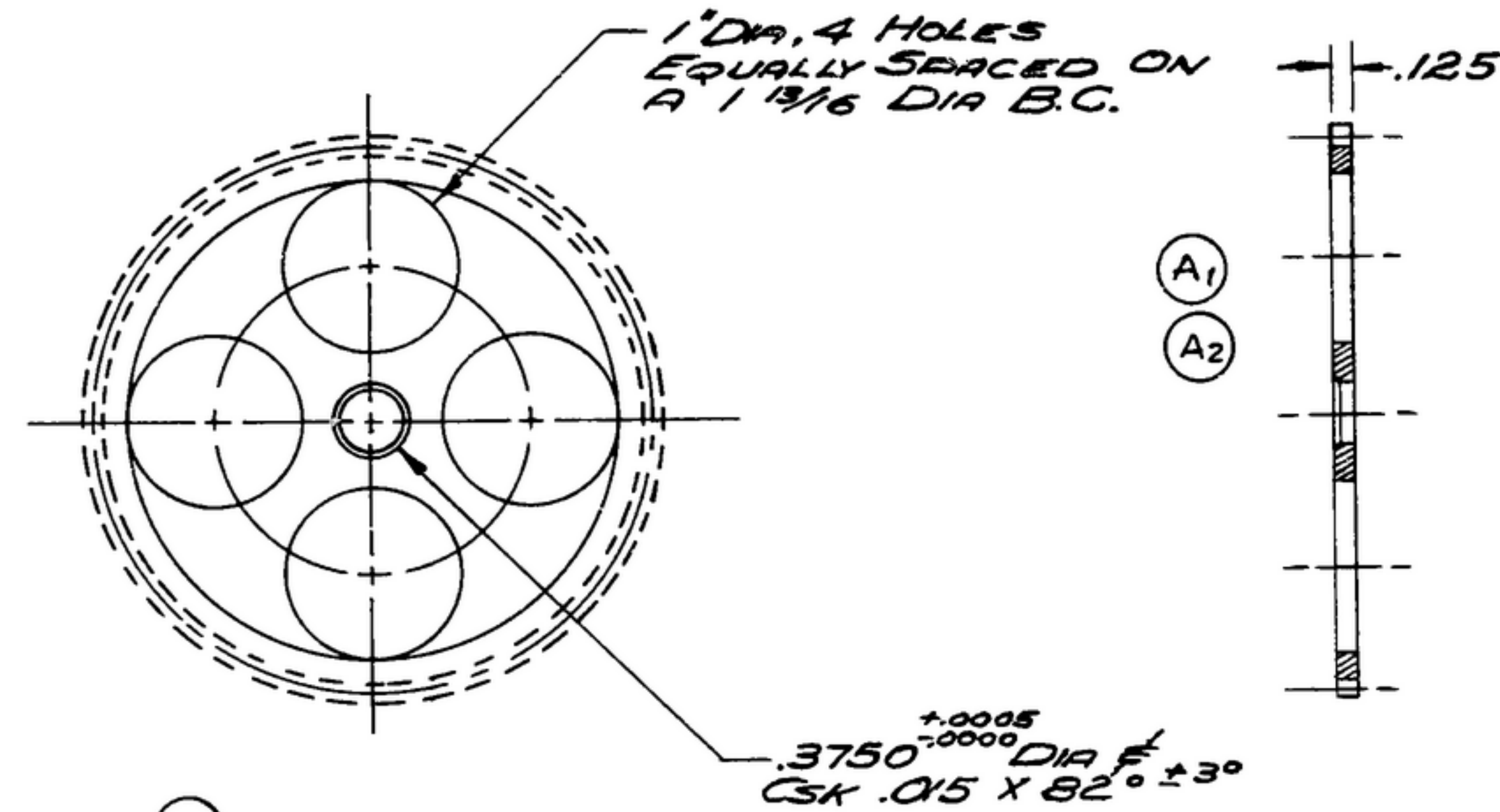


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NOTE: *FOR INFORMATION ONLY, CONTRACTOR MAY AT HIS OPTION DEVIATE FROM THESE PROCESS DETAILS

* SWE. APPROVAL		REVISIONS			
SYM	PR	SYM	DESCRIPTION	DATE	APPROVAL
	PR10042-4	A4	A ₁ - REMOVED .150 & 2 13/16 DIM. A ₂ - REVISED PICTORIAL; A ₃ - ADDED APPL. SM-B-178864, SC-DL-248775; A ₄ - REVISED NOTES.	8 OCT. 59	42428-PC-59-A1-51 REV'D.
	CA 84835	B1	(1) - ADDED NOTE *6.	13 OCT. 60	42428-PC-59 REV'D. PME



NOTES: (A₄)

- BRASS, COMP 1, TEMPER H, PER SPEC QQ-B-626.
- GEAR DATA
 NORMAL DIAMETRICAL PITCH: 32
 THEORETICAL PITCH DIA. 3.1875
 PRESSURE ANGLE: 20°
 NO. OF TEETH 102
 BACKLASH ON NORMAL PITCH CIRCLE
 WHEN MATED WITH MASTER .001-.002
 AMERICAN STANDARD INVOLUTE TOOTH FORM
- ECCENTRICITY BETWEEN PITCH DIA. & BORE NOT TO EXCEED .0012
- AXIAL RUNOUT NOT TO EXCEED .010 T.I.R. AT 1.500 RADIUS.
- REMOVE ALL BURRS & SHARP EDGES.
- FINISH: CHEMICAL POLISH (A₃)
 IRIDITE #7 METCOTE
 PROCESS BU, ALLIED RESEARCH PRODUCTS INC. BALTIMORE, MD., OR EQUAL.

REQD	PART NO.	DESCRIPTION	MATL	MATL SPEC
LIST OF MATERIAL				
GEAR				
AUTHENTICATION				
DRAWN 21852-PH -50-93				
TRACED PHOTO				
CHECKED <i>[Signature]</i>				
VERIFIED P. D. BR.				
APPROVED P. D. BR.				
REVIEWED P. M. E.				
DATE 3 JULY 53 SCALE 1/1				
SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY				SM-B-178865