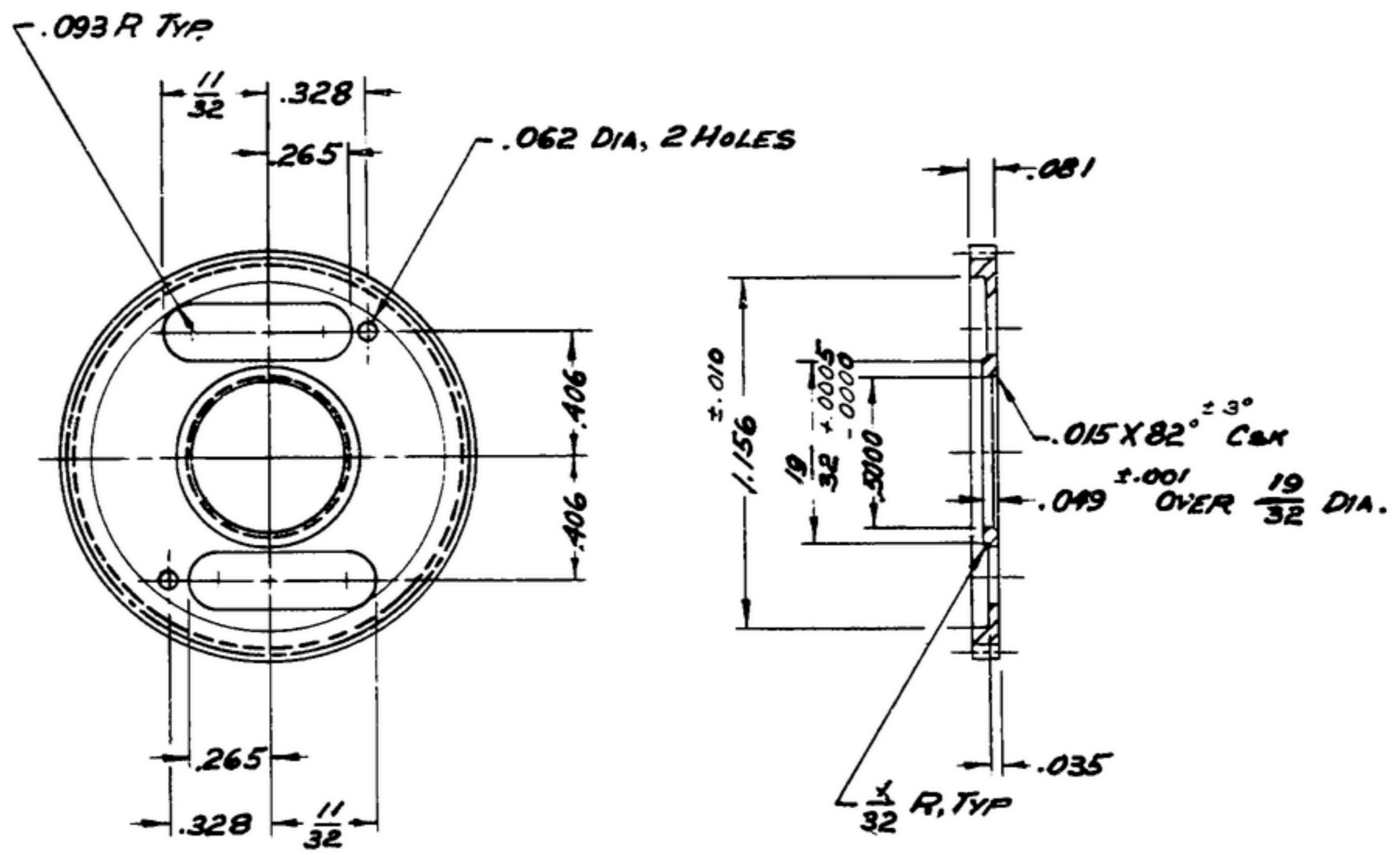


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NOTE:
*FOR INFORMATION ONLY,
CONTRACTOR MAY AT HIS
OPTION DEVIATE FROM
THESE PROCESS DETAILS

NEXT ASSEMBLY	USED ON	SWE	REVISIONS	DATE	APPROVAL
SM-C-178869	SC-DL-178967	APPROVAL			
SM-C-178869	SC-DL-248775	SY	A ₃	6 OCT. 59	42428-PC-59-A1-51 REV'D. PME
SM-C-343590		PR			
		Y			
		M			
		CA	B ₁	15 OCT. 60	42428-PC-59 REV'D. PME
		CA	C	24 OCT. 60	42428-PC-59 REV'D. PME



- (A₁)
NOTES: (C₁)
- BRASS, COMPOSITION 1, HARD, PER SPEC. QQ-B-613 (A₃)
 - NORMAL DIAMETRAL PITCH: 48
THEORETICAL PITCH DIAMETER: 1.3125
PRESSURE ANGLE: 14 1/2°
NUMBER OF TEETH: 63
BACKLASH ON NORMAL PITCH CIRCLE WHEN MATED WITH MASTER .0015-.0025.
AMERICAN STANDARD TOOTH FORM.
 - ECCENTRICITY BETWEEN BORE DIAMETER AND PITCH DIAMETER SHALL NOT EXCEED .002 TIR.
 - REMOVE ALL BURRS AND SHARP EDGES.
 - FINISH: CHEMICAL POLISH PER IRIDITE #7 METCOTE PROCESS BU,
ALLIED RESEARCH PRODUCTS INC., BALTIMORE, MD., OR EQUAL.
- (B₁)

UNLESS OTHERWISE SPECIFIED	AUTHENTICATION	SCALE	DATE
DIMENSIONS ARE IN INCHES	DRAWN 21852-PH	2/1	30 JUNE 53
TOLERANCES ON	TRACED PHOTO		
FRACTIONS ± 1/64	CHECKED [Signature]		
DECIMALS ± .005	VERIFIED P.D.B.R.		
ANGLES ±	APPROVED P.D.B.R.		
COMMERCIAL TOLERANCES APPLY TO STOCK SIZES	REVIEWED PME		
ALL SURFACES ✓	DATE 30 JUNE 53		

GEAR

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

SM-C-178870