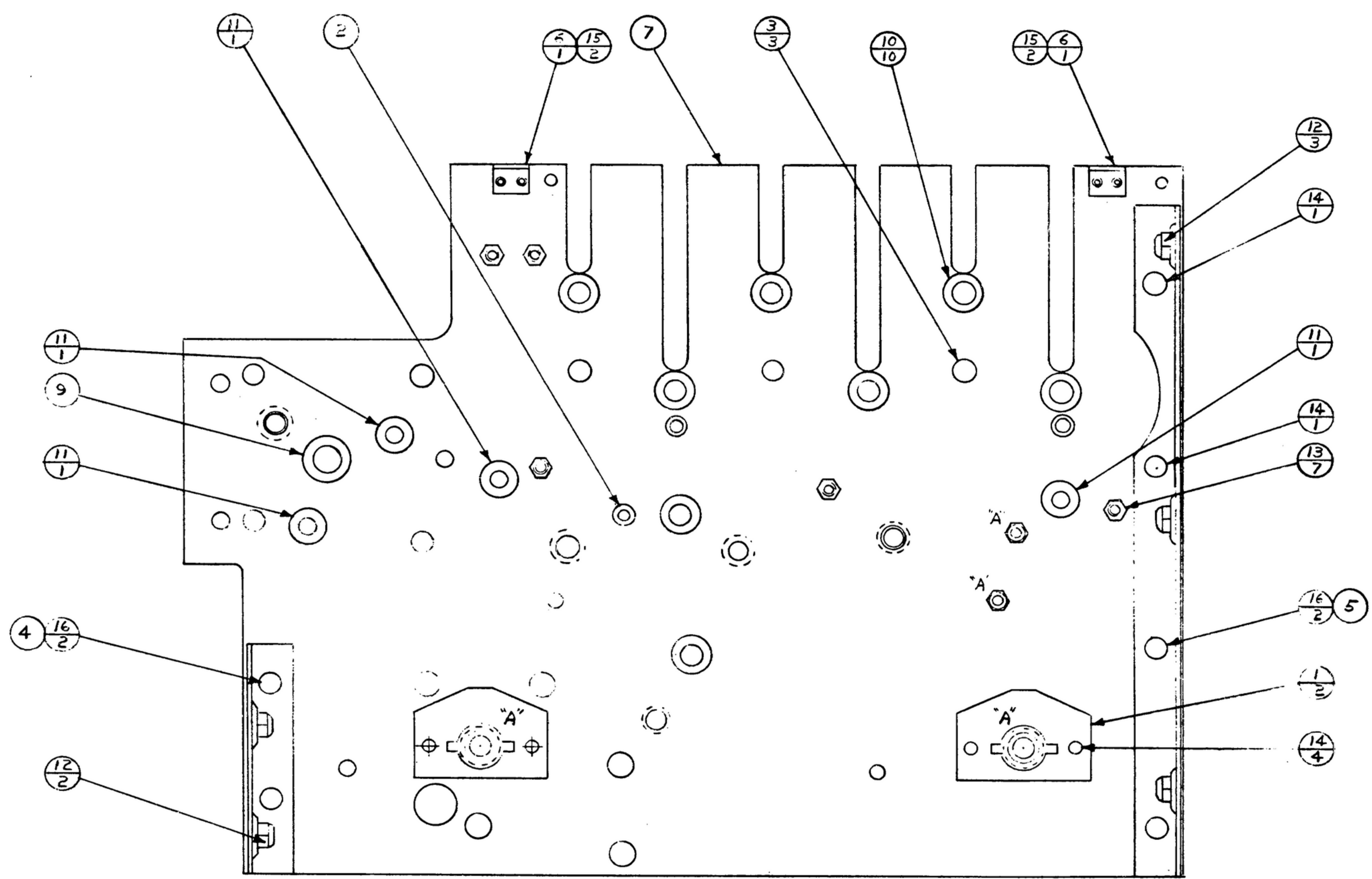


UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES AND DECIMALS ARE TO BE ROUNDED UP TO THE NEXT HIGHER DECIMAL PLACE. DIMENSIONS ARE TO BE TAKEN FROM THE UNFINISHED SURFACE UNLESS OTHERWISE SPECIFIED. DIMENSIONS ARE TO BE TAKEN FROM THE UNFINISHED SURFACE UNLESS OTHERWISE SPECIFIED. DIMENSIONS ARE TO BE TAKEN FROM THE UNFINISHED SURFACE UNLESS OTHERWISE SPECIFIED.

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

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL



- NOTES:
1. PRESS BEARINGS (9, 10 & 11) & NUTS (13) INTO PLATE (7).
  2. BEARINGS & NUTS MARKED "A" TO BE PRESSED IN FROM OPPOSITE SIDE SHOWN.
  3. RIVET BRACKET (5) TO PLATE (7) USING RIVETS (14 & 16).
  4. RIVET BRACKET (4) TO PLATE (7) USING RIVETS (16).
  5. RIVET HEADS TO BE ON OPPOSITE SIDE SHOWN.
  6. BURNISH BEARING (9) TO  $-.3125^{+0.0005}$  DIA., BEARINGS (10) TO  $-.2500^{+0.0005}$  DIA. & BEARINGS, (11) TO  $-.1875^{+0.0010}$  DIA.
  7. PRESS STUD (2) INTO PLATE (7) FROM SIDE SHOWN, AND STAKE OR ROLL OPPOSITE SIDE.
  8. PRESS SHAFT (3) INTO PLATE (7) FROM OPPOSITE SIDE, AND CROSS STAKE.
  9. RIVET PLATE (1) TO PLATE (7) USING RIVETS (14).
  10. SECURE BRACKET (6) TO PLATE (7) WITH RIVETS (15). RIVET HEADS TO BE ON OPPOSITE SIDE FROM BRACKET.
  11. PLATE TO BE FLAT WITHIN  $.015$  TIR.
  12. SLOTS TO BE  $+.265^{+0.002}$  AFTER ASSY.
  13. IN ALL SPLIT BALLBOONS, TOP FIGURE IS MATERIAL LIST ITEM INDICATOR, AND BOTTOM FIGURE IS QUANTITY.

ITEM	QTY	PART NO.	DESCRIPTION	MATL	MATL SPEC	NOTES
16	4	AMN70ADN-6	RIVET			
15	4	AMN66ADN-5	RIVET			
14	6	AMN28ADN-4	RIVET			
13	7	SM-C-283166-4	NUT-INSERT CAPTIVE			
12	6	SM-B-283158-1	NUT-STOP			
11	8	SM-B-283158	BEARING			
10	10	SM-B-283157	BEARING			
9	1	SM-C-283156-3	BEARING			
7	1	SM-D-343602	PLATE-FRONT GEAR			
6	2	SM-B-248976	BRACKET-DUST COVER			
5	1	SM-C-248928	BRACKET-LONG			
4	1	SM-C-248927	BRACKET-SHORT			
3	3	SM-B-343602-2	SHAFT-ROLLER			
2	1	SM-B-248899	STUD-GEAR			
1	2	SM-B-248871	PLATE-LOCKING			

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES ± ± ±		STEWART-WARNER ELECTRONICS 42428-PC-59-AI-51 SIGNAL CORPS	PLATE ASSY, FRONT GEAR	DEPARTMENT OF THE ARMY SIGNAL CORPS ENGINEERING LABORATORIES FORT MONMOUTH NEW JERSEY
DRAWN BY C. J. [Signature]		REVIEWED PHE		
CHECKED BY [Signature]		APPROVED PHE	SM-D-343612	
NEXT ASSY USED ON		DATE 7 OCT 59		
APPLICATION		SCALE 1/1		