

2. FINISH 125/ EXCEPT AS NOTED.
3. ALL CORNERS AND EDGES SHALL BE BROKEN .005-010 UNLESS OTHERWISE SPECIFIED.
4. STEEL, CORN 1137 THRU 1141 FORDING SPEC MIL-S-3100B, OR
5. STEEL TUBING, SEAMLESS, GRADE 100, ASTM-A513 OR
6. STEEL, CORN 1141 SPEC ASTM-A-108.
7. HEAT TREATING: HEAT TO 1525-1550°F. OIL QUENCHED. TEMPER 20 MINUTES AT 1000 TO HARDNESS SPECIFIED. HEAT TREATING IS FOR GUIDANCE EXCEPT THAT TEMPERING SHALL NOT BE REQUIRED IF THE HARDNESS SPECIFIED.
8. DIMENSION SHALL BE ADJUSTED TO OBTAIN A SLIDING FIT (WITH NO PERCEPTIBLE LOOSENESS) WITH SPECIFIC, REF DESG 779131, DIMENSION .489-.002. DIMENSION .489 USA-2.00 WHEN THIS IS PRACTICABLE.
9. SURFACES SHALL BE FREE OF PROTECTIVE FINISH.
10. DIMENSION SHALL BE ADJUSTED DURING FINAL ASSEMBLY TO OBTAIN A SLIDING FIT (WITH NO PERCEPTIBLE LOOSENESS) WITH SPECIFIC, REF DESG 779131, DIM. .489-.002.
11. REAR SHIELD: REF: DIMS 779151, DIM. .452-0.002.
12. FINAL PROTECTIVE FINISH:
FINISH 3.1, 3.2 OF MIL-STD-171.
13. HTG-13855, SHLL, REF. Y.

STN	DESCRIPTION	DATE	APPROVAL
L	REDRAWN WITH CHANGE NOR W650060/860613 (ECP W652066/861215)	881102	ORF173



CUT 17 SPACES ——— MODIFIED ⊕
NUTTAL 20 DEGREE STUB TEETH
2200 TEETH IN COMPLETE CIRCLE
50 PER INCH .0628 CIRCULAR PITCH
2.200 PITCH RADIUS.
ACCUMULATED BUILDUP OF TOLERANCE IN
CIRCULAR PITCH SHALL NOT EXCEED
.005 IN 7 TEETH.

PARTIAL
SECTION E-E

[illegible]