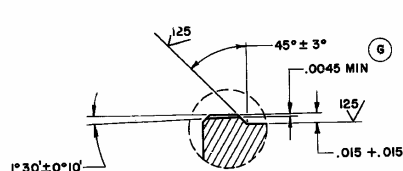
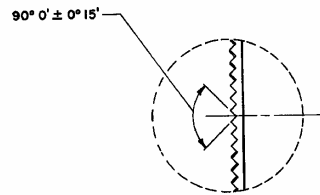


NOTES:

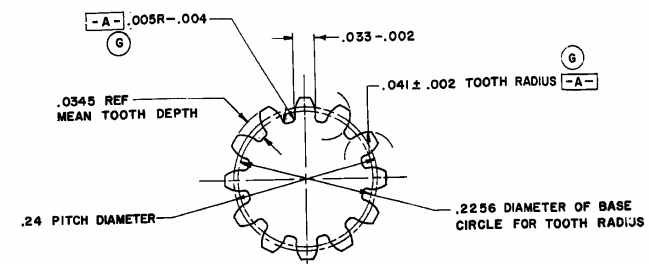
1. FINISH  $\frac{63}{\sqrt{}}$  EXCEPT AS NOTED.
2. ALL CORNERS AND EDGES SHALL BE FREE FROM BURRS WITH MAX RADIUS OF .005 UNLESS OTHERWISE SPECIFIED.
3. 100 SERRATIONS MUST BE RADIAL (CHECK FROM DIMENSION [-D-]) AND EQUIDISTANT. WHEN SERRATIONS OF ONE PINION ARE MESHED WITH SERRATIONS OF ANOTHER, THE DEPTH OF ENGAGEMENT SHALL BE .004 MIN ALL AROUND THE SERRATED SURFACES, AND DIMENSION [-D-] OF ONE PINION SHALL BE CONCENTRIC WITH SAME DIMENSION ON THE OTHER PINION WITHIN .003.
4. DIAMETERS [-C-], [-E-] AND [-B-] SHALL BE GROUND AFTER HEAT TREATMENT AND PROTECTIVE FINISH.
5. HEAT TREATMENT: HEAT AT 1525°F TO 1550°F, OIL QUENCH, TEMPER 30 MINUTES AT 800°F. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
6. FINAL PROTECTIVE FINISH: 53.12 OR 53.2.2 OF MIL-STD-171.
7. MIL-W-13855 SHALL APPLY.



DETAIL B  
SCALE: 10/1



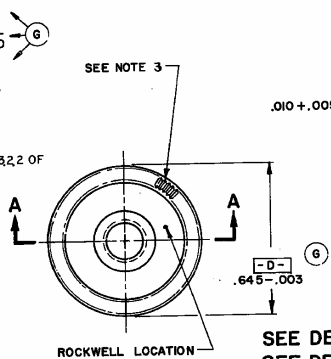
DETAIL C  
SCALE: 20/1



12 TEETH - 50 PITCH - .0628 CP - STANDARD MODIFIED [-A-]  
NUTTALL 20° PRESSURE ANGLE STUB TOOTH. NOTE:  
24 PITCH DIA TO BE CONCENTRIC WITH BEARING SURFACES  
[-B-] AND [-C-] WITHIN .003 WITH RESULTANT TOOTH DEPTH OF  
.030 ± .009

SCALE 10/1

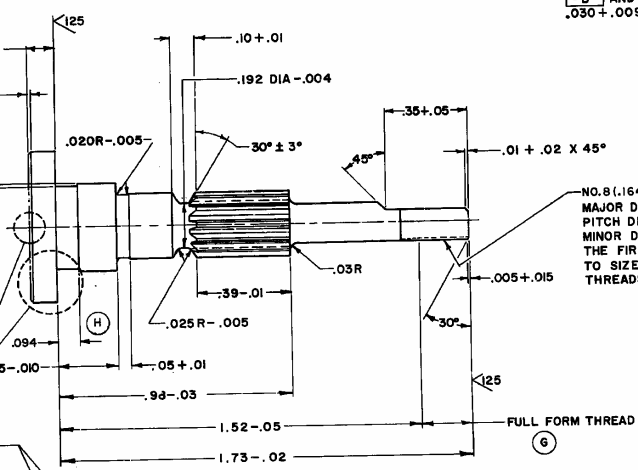
THESE EDGES ARE  
IMPORTANT FUNCTIONING  
POINTS AND SHALL BE  
SHARP TO .003R AND  
FREE FROM BURRS.



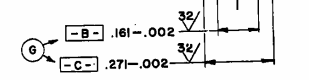
ROCKWELL LOCATION

SEE DETAIL C  
SEE DETAIL D

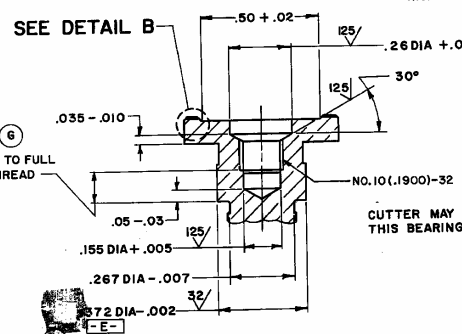
CUTTER MUST NOT  
NICK THESE EDGES



NO. 8 (1.640) - 36 UNF - 3A - MOD  
MAJOR DIA .161 - .004 MOD  
PITCH DIA .1460 - .0021  
MINOR DIA .1299 MAX  
THE FIRST THREAD MUST GAGE  
TO SIZE AS WELL AS THE OTHER  
THREADS.



[-B-] .161 - .002  
[-C-] .271 - .002



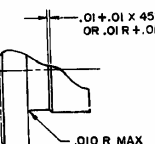
PARTIAL SECTION A-A

CUTTER MAY RUNOUT IN ANY PART OF  
THIS BEARING

VIEW SHOWING PERMISSIBLE RUNOUT OF GEAR  
TOOTH CUTTER  
ALTERNATIVE METHOD

CURRENT DESIGN ACTIVITY FROM NO. 19200  
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

DETAIL D



.01 ± .01 X 45°  
OR .01 R ± .01

PHYSICAL PROPERTIES		TOLERANCES ON DIMENSIONS		ORIGINAL DATE OF DRAWING	
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