



STANDARDS SHEET

When press swaged bearings are required, the following housing design shall be specified on the drawing.

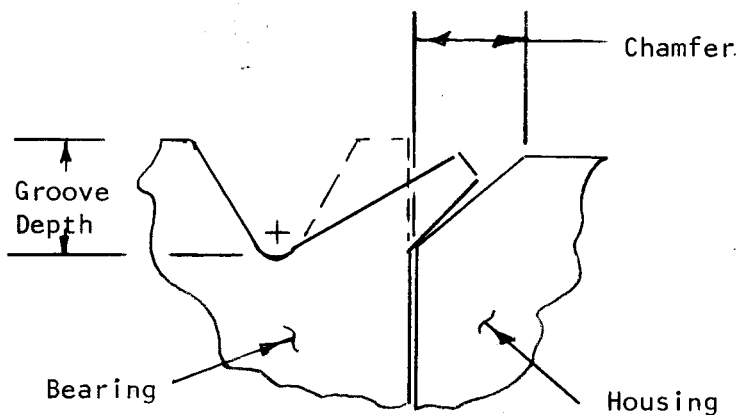
BORE:

- (1) Steel housing - .0003 larger than the max. O.D. of bearing with a +.0000/-.0005 tolerance. The installed bearing could be .0008 loose to .0002 tight.
- (b) Aluminum housing - +.0003 to -.0015 clearance and installed with Loctite, Grade AA to P.P.S. 19.02.

CHAMFER:

- The chamfer should be $45^{\circ} \times C$ as tabulated below.

*Bearing Size	Groove Depth	C
-3	.030	.030
-4	.015	.020
-5 to	.040	.035
-7	.025	.025
-8 to	.060	.055
-16	.045	.045



Drawing Note:

Bearing to be installed by press swaging to PPS 12.06.

* From applicable bearing standard or drawing

REF: SECTION 510.6.4 IN BOEING DESIGN MANUAL

DRAWN	KROMKAMP	CLASSIFICATION	STANDARD
CHECKED	STOKES	HOUSING DIMENSIONS -	
STRESSED	<i>[Signature]</i>	PRESS SWAGED BEARINGS	DS 105
APPROVED	<i>[Signature]</i>		

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