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REV:

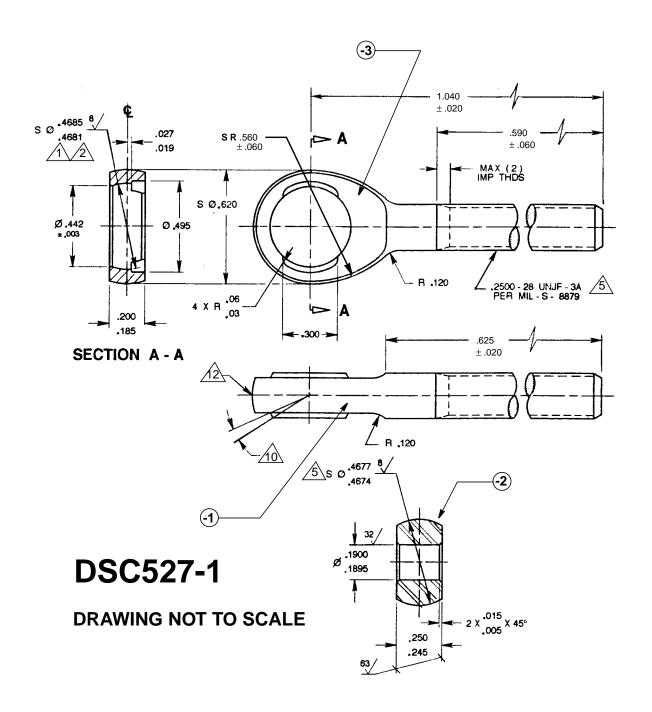
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SOURCE CONTROL DRAWING



LIST OF CURRENT SHEETS										
SHEET	1	2	3							
REV	В	В	Α							

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

								63/	_	245	(- .			EV: A - 12 DEC 97
					LIST	r of cu	RRENT:	SHEETS					7	
		SHEET	1	2	3									176
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DRAWN	DRAWN B. McDONALD TITLE:							-						
CHECKED P.LAM			B	EAR	ING	, ROI	D EN	D, SL	CTO	ED		D	SC 527	APPROVED:
STRESS	STRESS S. CHENG ENTRY, SHORT THREAD						MOE 4 OE 6	PRO						
APPROVED	S. HAI	MID										F	PAGE 1 OF 3	API

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REV: A - 12 DEC

SOURCE CONTROL DRAWING -

NOTES:



MALCOLMIZE SPHERICAL ID (ENTRY OPTIONAL) 0.004/0.008 THICK AT 1000°F. MINIMUM CASE THICKNESS AFTER LAPPING 0.002. HARDNESS R15N90 MINIMUM

/2\ DIAMETERS MUST BE WITHIN Ra 63 AND 0.0015 OF FINISHED SIZE PRIOR TO MALCOLMIZING AND LAPPED TO FINAL SIZE AND FINISH AFTER MALCOLMIZING.

/3\ MAGNETIC PARTICLE INSPECT PER MIL-STD-1949 OR ASTM E 1444, ACCEPTANCE CRITERIA PER MIL-STD-2175, GRADE C (Casting) or MIL-STD-1907, GRADE C (Bar Stock)

/4\. PENETRANT INSPECT PER ASTM 1417 OR MIL-STD-6866, ACCEPTANCE CRITERIA PER MIL-STD-2175, GRADE C.

/5\\ DRY FILM LUBRICANT SPHERICAL O.D. OF BALL AND THREAD: EVERLUBE #967 (0.0001./ 0.0003). DIMENSION AND SURFACE FINISH TO BE MET BEFORE DRY FILM.

♠ SCUFFING OF DRY FILM ON BALL RESULTANT FROM ASSEMBLY IS ALLOWED.

 $\sqrt{7}$ \. BALL MUST ROTATE UNDER FINGER PRESSURE AT 72 $^{
m o}$ F.

- 8. BALLS MUST BE FULLY INTERCHANGEABLE. NO SELECTIVE ASSEMBLY ALLOWED.
- 9. RADIAL STATIC LOAD LIMIT: 1400 LBS ULTIMATE LOAD 2100 LBS (ENGINEERING REF)



BALL MISALIGNMENT CAPABILITY: 8° REF.

11. BALL MUST BE POSITIVELY RETAINED

 $\sqrt{12}$ PERMANENT MARK - MANUFACTURER'S ID AND PART NUMBER IN THIS AREA.

13. OPERATING TEMPERATURE RANGE: -65°F to +600°F

MATERIAL:

ITEM	DESCRIPTION	MATERIAL	HEAT TREAT	PROCESS
2	PODY	B CASTING: 17-4 PH TO AMS5355: PER MIL-C-6021, CLASS 3, GR. B	HT1025 (145 KSI MIN) Rc 34 MIN	1 2 2
-3 BODY	ВОВТ	BAR: 15-5 PH TO AMS 5659	HT1025 (155 - 175 KSI) Rc 35 - 39	71/2/23
-2	BALL	CASTING:STELLITE #6 TO AMS 5387	Rc 37 MIN	4/5
-1	ASSY	-2 / -3		6/7

TOLERANCES: UNLESS OTHERWISE NOTED

LINEAR: .XX ± .03 $.XXX \pm .010$

(B) ANGLES: ±2 DEGREE

BREAK SHARP EDGES: .005/.015

	SURFACE FINISH: $\sqrt{125}$									
SE	SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY									
DRAWN	B. McDONALD	TITLE:	DSC 527][
CHECKED	P.LAM	BEARING, ROD END, SLOTTED	DSC 521							
STRESS	S. CHENG	ENTRY, SHORT THREAD	DACE 2 OF 2	100						
APPROVED	S. HAMID		PAGE 2 OF 3							

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APPROVED VENDORS

DSC		APPROVED VENDOR'S PART NUMBER						
	ITEM	PSI BEARINGS	AURORA BEARING CO	VALLEY TODECO INC	NHBB			
527-1	ASSEMBLY	P38100	SEM-3D-1	VTA10600	AMBM3-4027			

VENDOR'S ADDRESS

PSI BEARINGS: SUN VALLEY, CA - CAGE CODE 57606

AURORA BEARING CO.: AURORA, IL - CAGE CODE 56644 VALLEY TODECO INC.: SYLMAR, CA - CAGE CODE 06710

NEW HAMPSHIRE BALL BEARINGS INC.: LACONIA, NH - CAGE CODE 15860

PROCUREMENT INFORMATION:

PROCUREMENT DEPT SHALL SPECIFY THE DSC NUMBER AND MANUFACTURER'S PART NUMBER ON THE PURCHASE ORDER.

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	B. McDONALD	TITLE:	DSC 527	7
CHECKED	P.LAM	BEARING, ROD END, SLOTTED	DSC 321	ċ
STRESS	S. CHENG	ENTRY, SHORT THREAD	DACE 2 OF 2	
APPROVED	S. HAMID		PAGE 3 OF 3	

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7 NOV 1997 | REV: A - 12 DEC 97