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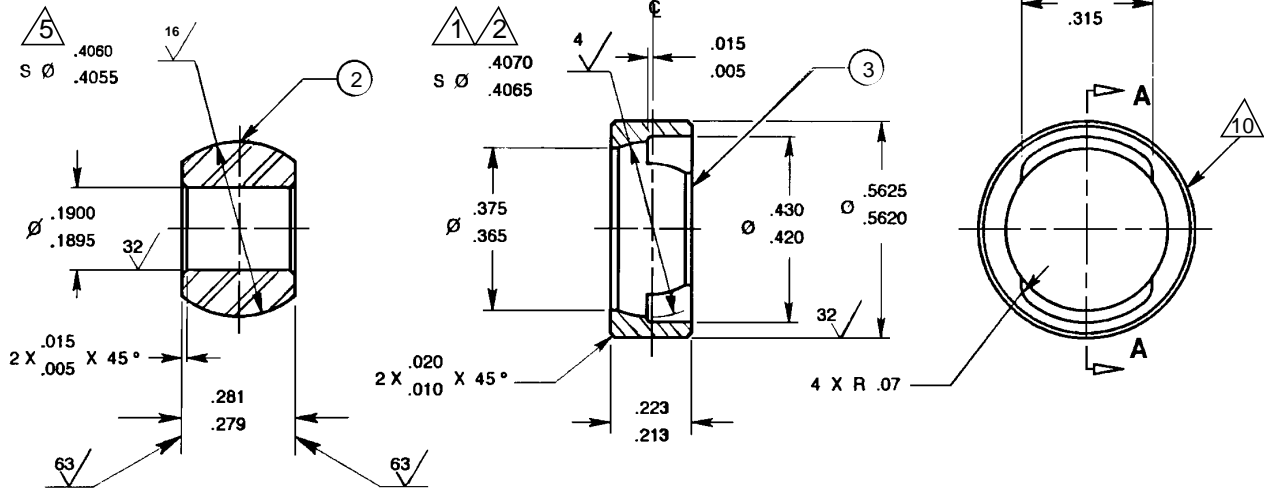
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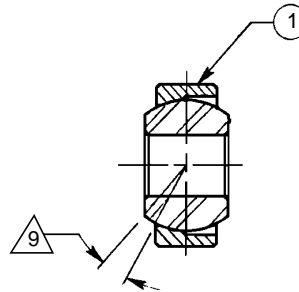
SOURCE CONTROL DRAWING

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SOURCE CONTROL DRAWING



SECTION A - A



DRAWING NOT TO SCALE

LIST OF CURRENT SHEETS

SHEET	1	2	3							
REV	C	C	B							

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	B. McDONALD
CHECKED	P. LAM
STRESS	S. CHENG
APPROVED	S. HAMID

TITLE:
**BEARING, ASSEMBLY,
SLOTTED ENTRY**

DSC 528

PAGE 1 OF 3

© SHT 2 WAS REV B

REV: REV: REV: REV: C - 31 AUG 98 REV: B - 6 FEB 98 REV: A - 12 DEC 97 APPROVED: 17 NOV 1997

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SOURCE CONTROL DRAWING

NOTES:

1. 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-1907, GRADE C.
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 WITH EVERLUBE #967 (0.0003/0.0005). DIMENSION AND SURFACE FINISH TO BE MET BEFORE DRY FILM.
6. BALL MUST ROTATE UNDER FINGER PRESSURE AT 72°F.
7. BALLS MUST BE FULLY INTERCHANGEABLE. NO SELECTIVE ASSEMBLY ALLOWED.
8. RADIAL STATIC LOAD LIMIT: 2600 LBS - ULTIMATE LOAD 3900 LBS (ENG REF)
9. BALL MISALIGNMENT CAPABILITY: 10° REF.
10. PERMANENT MARK - MANUFACTURER'S ID AND PART NUMBER IN THIS AREA.
11. OPERATING TEMPERATURE RANGE: -65°F to +800°F

MATERIAL:

ITEM	DESCRIPTION	MATERIAL	HEAT TREAT	PROCESS
-3	RACE	BAR: 15-5 PH TO AMS 5659	HT1025 (155 - 175 KSI) Rc 35 - 39	1 2 3
-2	BALL	CASTING: STELLITE #6 TO AMS 5387	Rc 37 MIN	4 5
-1	ASSY	-2 / -3	-----	6

TOLERANCES: UNLESS OTHERWISE NOTED

LINEAR: .XX ± .03 .XXX ± .010

ANGLES: ± 2 DEGREE

BREAK SHARP EDGES: .005/.015

SURFACE FINISH: $\sqrt{125}$

SEE ENGINEERING STANDARDS APPROVAL RECORD FOR ORIGINAL SIGNATURES AND CHANGE SUMMARY

DRAWN	B. McDONALD	TITLE: BEARING, ASSEMBLY, SLOTTED ENTRY	DSC 528
CHECKED	P. LAM		
STRESS	S. CHENG		PAGE 2 OF 3
APPROVED	S. HAMID		

NOTE 5 - .0003/.0005 was .0001/.0003
TOLERANCES: ±2 DEGREE was ±1/2 DEGREE

REV:

REV:

REV:

REV: C - 31 AUG 98

REV: B - 6 FEB 98

REV: A - 12 DEC 97

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APPROVED VENDORS

DSC	ITEM	APPROVED VENDOR'S PART NUMBER			
		PSI BEARINGS	AURORA BEARING CO)	VALLEY TODECO INC	NHBB
528-1	ASSEMBLY	P22000	BSE-3D-2	VTB13030	AMB3-4001

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.

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