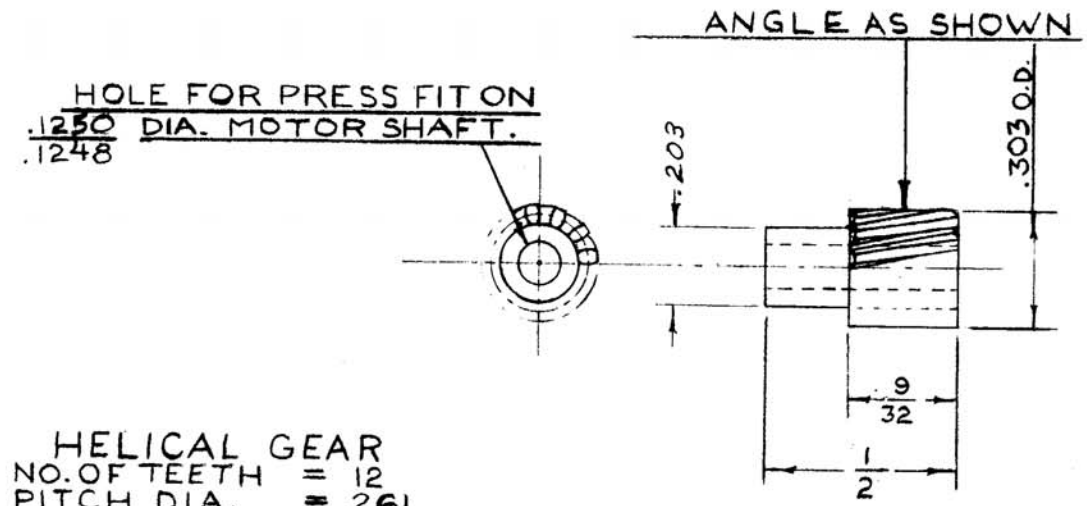
IF IT IS FOUND DESIRABLE TO CHANGE ANY TOLERANCE OR OTHER DETAIL SPECIFIED ON THIS DRAWING NOTIFY THE PURCHASER PROMPTLY.

MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

RELEASED

GR-104 D

USED ON			
MODEL	PROJECT NO.	ASS'Y. NO.	DATE
TWR-115	151	A-211	9-22-52



HELICAL GEAR
NO. OF TEETH = 12
PITCH DIA. = .261
HELIX ANGLE = 17°
PRESSURE ANGLE = 20°
OUTSIDE DIA. = .303
REAL DIA. PITCH = 46

NORMAL DIA. PITCH (PITCH OF CUTTER) } = 48

(COMMERCIAL CLASS 3 TOL.)

ISSUE	ITEM	CHANGED FROM	DATE	CN. NO.	DRAFTS	CHECKER	ENG. APP.
D	1	ADD. "PRESS ANGLE = 20°"	4.4.67	18031	[illegible]	[illegible]	[illegible]
C	1	DIMENSION .203 ADDED	6-3-55	3	PB	[illegible]	[illegible]
B	1	CLASS 3 TOL. ADDED	5-16-55	2	PB	[illegible]	[illegible]
A	1	NOR. PITCH ADDED	7/13/53	1		[illegible]	[illegible]

TOLERANCES

SCALE 2" TO 1"

ALL OTHERS: DEC. DIM. ± .005; FRAC. DIM. ± 1/64; ANGULAR DIM. ±

DRILL, PUNCH, COMMERCIAL STOCK SIZES AND MANUFACTURERS TOLERANCES ARE NOT INCLUDED.

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
		— // —	THE TECHNICAL MATERIEL CORP. MAMARONECK, NEW YORK	
		STOCK SIZE		
		STEEL — // —	HELICAL PINION GEAR	
		MATERIAL / WEIGHT PER PC.		
		CARBON		
		TYPE & TEMPER	L. Gabel DRAWN / ELEC. DES. APP. / MECH. DES. APP.	
		— // —	JAQ 11/6/52 CHECKED / FINAL APPROVAL	
		HEAT TREAT. SPEC.		
		— // —		
		FINISH & SPEC. NO.		

GR-104 D

FORM — 108