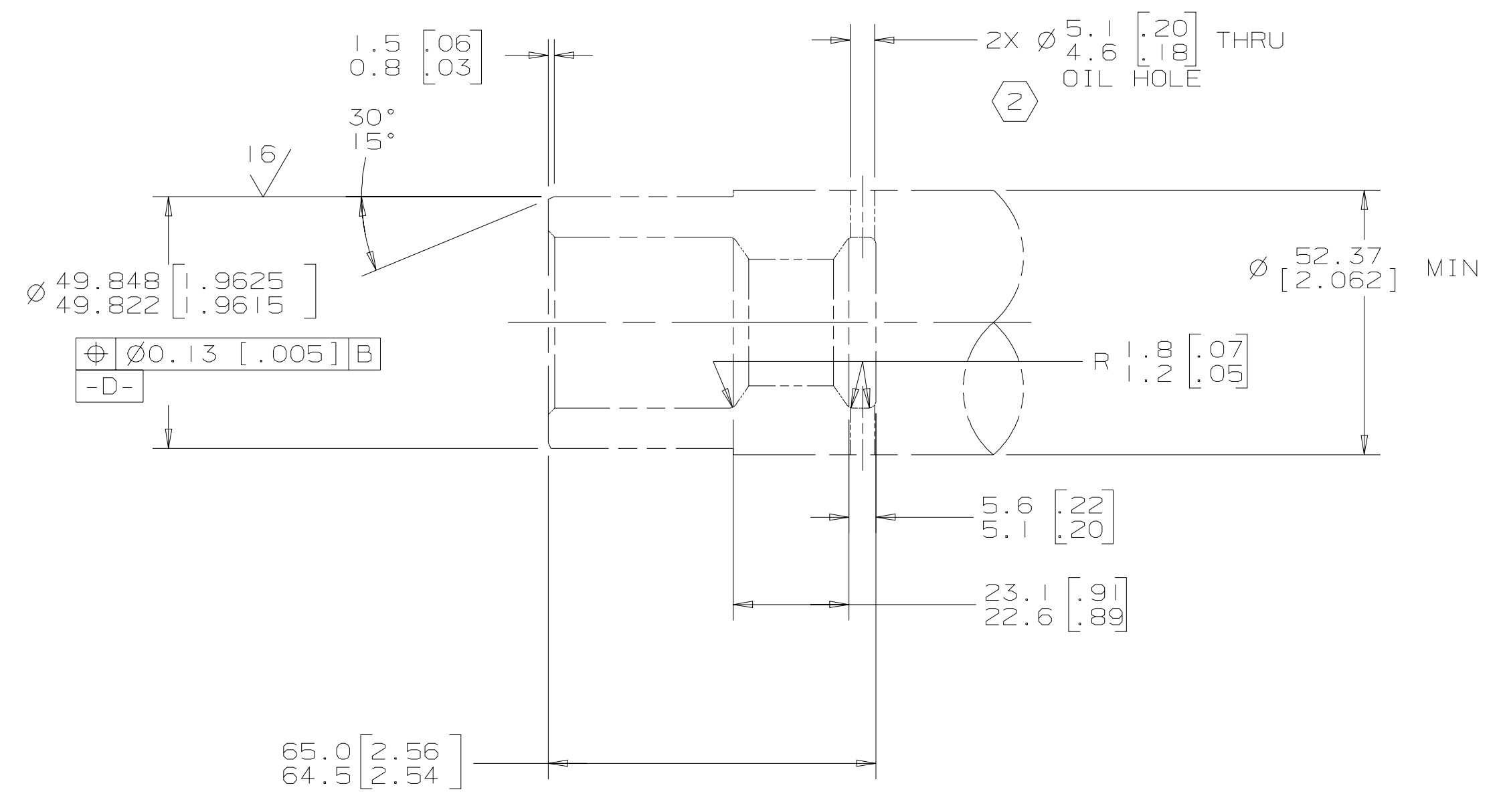
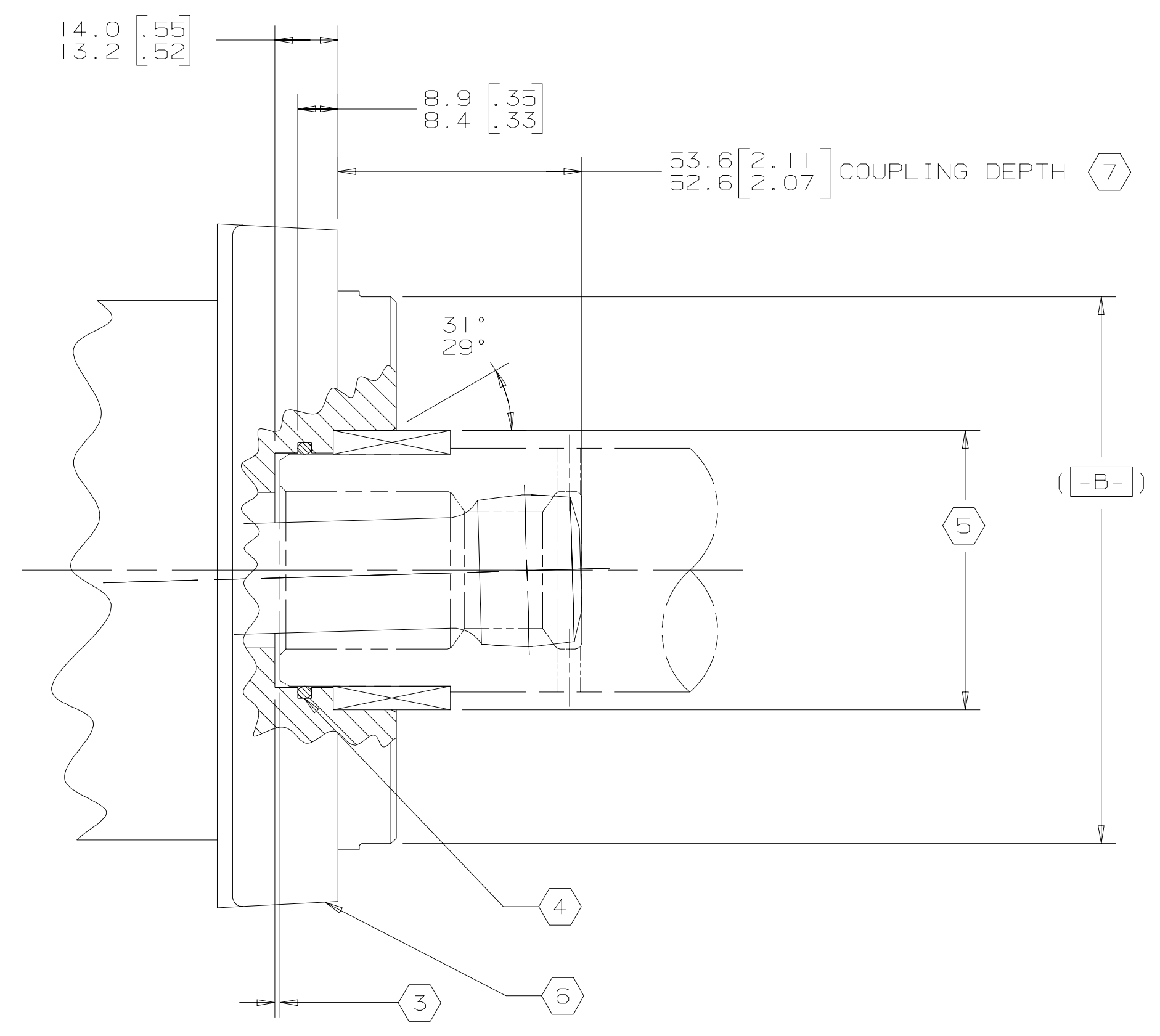


SYM	REVISION	BY	DATE	ECN
A	ENGINEERING RELEASE	SDR	2-8-92	21551
B	(5A) REVISED NOTE (7)	AGJ	9-30-03	45274
C	-1) (6D) 53.6/52.6 [2.11/2.07] WAS 52.8/51.8 [2.08/2.04] -2) (6A) NOTE (7) WAS 52.8 [2.08]...	AAK	11-15-06	0001154



INTERNAL INVOLUTE SPLINE DATA	
SPLINE PITCH	10/20
PRESSURE ANGLE	30°
NUMBER OF TEETH	12
CLASS OF FIT - REF.	5
TYPE OF FIT	SIDE
PITCH DIAMETER - REF.	30.480000 [1.2000000] $\sqrt{0.20 [0.008] D}$
BASE DIAMETER - REF.	26.396455 [1.0392305]
MAJOR DIAMETER	33.43 [1.316] MAX 33.23 [1.308] MIN
MINOR DIAMETER	28.40-28.58 [1.118-1.125]
FORM DIAMETER, MIN.	32.59 [1.283]
FILLET RADIUS	0.63-0.76 [0.025-.030]
TIP RADIUS	0.26-0.51 [0.010-.020]
FINISH	(63)
INVOLUTE PROFILE VARIATION	+0.000 -0.025 [+0.0000 -0.0010]
TOTAL INDEX VARIATION	0.038 [0.0015]
LEAD VARIATION	0.013 [0.0005]
CIRCULAR SPACE WIDTH:	
MAXIMUM ACTUAL	5.045 [0.1986]
MINIMUM EFFECTIVE	4.995 [0.1951]
MAXIMUM EFFECTIVE - REF.	5.009 [0.1972]
MINIMUM ACTUAL - REF.	4.986 [0.1963]
DIMENSION BETWEEN TWO PINS - REF.	22.783-22.929 [0.8970-.9027]
PIN DIAMETER	5.334 [0.2100] - NOTE: PIN TO HAVE 3.73 [0.147] WIDE FLAT FOR ROOT CLEARANCE

INSTALLATION INFORMATION

- 1 INTERNAL SPLINE IN MATING PART TO BE PER SPLINE DATA SPEC. MATERIAL TO BE ASTM A304, 8620H VACUUM DEGAISED ALLOY STEEL CARBURIZE TO A HARDNESS OF 59-62 Rc WITH CASE DEPTH (TO 50 Rc) 0.76-1.02 [0.030-.040] DIMENSIONS APPLY AFTER HEAT TREAT
- (2) MATING PART TO HAVE CRITICAL DIMENSIONS AS SHOWN OIL HOLES MUST BE PROVIDED AND OPEN FOR PROPER CIRCULATION
- (3) SOME MEANS OF MAINTAINING CLEARANCE BETWEEN SHAFT AND MOUNTING FLANGE MUST BE PROVIDED
- (4) SEAL IS TO BE FURNISHED WITH MOTOR FOR PROPER OIL CIRCULATION THRU SPLINES
- (5) COUNTERBORE DESIGNED TO ADAPT A STANDARD SLEEVE BEARING 50.010-50.040 [1.9689-1.9700] I.D. BY 60.050-60-080 [2.3642-2.3653] OILITE BRONZE SLEEVE BEARING SOURCE: BEARING SALES CORPORATION PART NUMBER 60226
- (6) SIMILAR TO SAE "C" FOUR BOLT FLANGE
- (7) 53.6 [2.11] MAX DIMENSION TO BE MAINTAINED WHEN ASSEMBLING SHIPPING AND INSTALLING UNIT TO INSURE VALVE DRIVE ENGAGEMENT WITH VALVE.

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN		DRAWING BASED ON ANSI Y14.5M-1982			
INCHES	<input type="checkbox"/>	THE REPRODUCTION, DISTRIBUTION, AND UTILIZATION OF THIS DOCUMENT, AS WELL AS THE COMMUNICATION OF ITS CONTENTS TO OTHERS WITHOUT EXPPLICIT AUTHORIZATION IS PROHIBITED. OFFENDERS WILL BE HELD LIABLE FOR THE PAYMENT OF DAMAGES. ALL RIGHTS RESERVED IN THE EVENT OF THE GRANT OF A PATENT, UTILITY MODEL, OR DESIGN. (PER ISO 16016)			
MILLIMETERS (INCHES)	<input checked="" type="checkbox"/>				
TOLERANCES					
.X	----	DRWN BY/DATE	SDR 6-26-92	MATERIAL/HEAT TREAT	
.XX	+REF	CHECKED BY/DATE	KJR 8-4-92		
.XXX	+ONLY	UNSPECIFIED RADI ARE	ENGR BY/DATE	RVA 8-4-92	TITLE
<	----	UNSPECIFIED DRAFT ANGLES ARE	METALLURGY BY/DATE	----	4000 SERIES MOTOR COUPLING INSTALLATION
					NUMBER
					A-557
					SCALE
					1/1
					SHEET
					1 OF 1

GSK