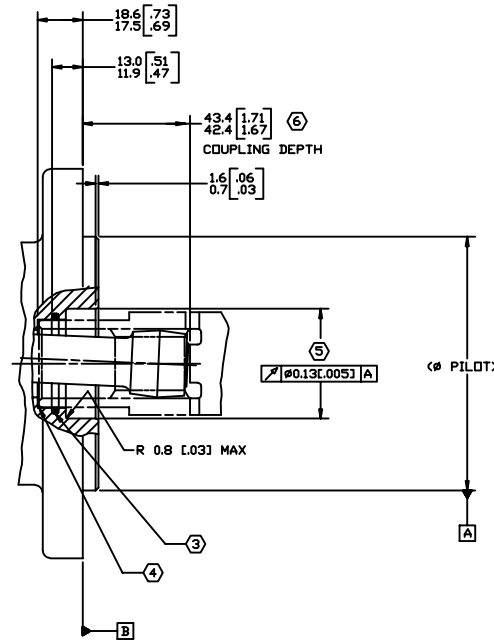
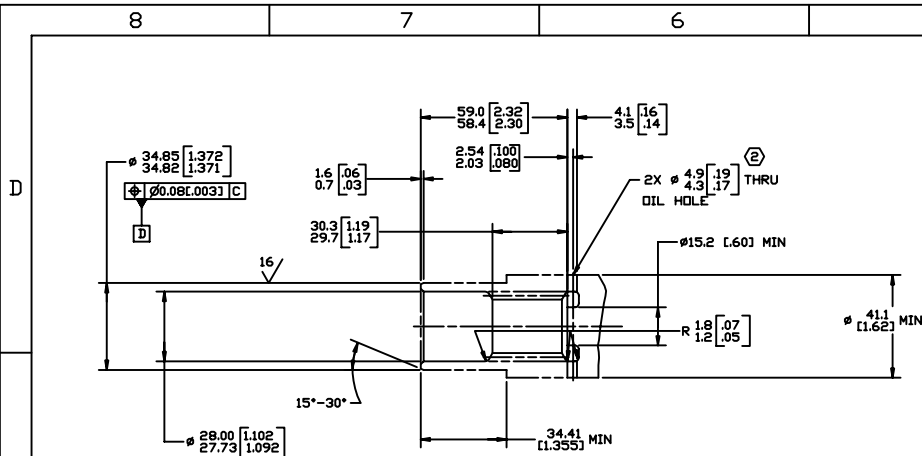


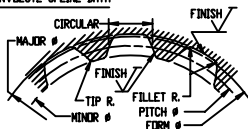
SYM	REVISION	BY	DATE	ECN
A	ENGINEERING RELEASE	AGJ	9-24-93	22833
B	MOVED 42.7/41.6(1.68/1.64) TO COUPLING BOTTOM	MGF		31874
C	ADDED 2.54/2.03 [100/.080] DIM TO OIL HOLE	MJZ	12-2-93	32050
D	(2B)ADDED NOTE (6)	AGJ	9-28-93	45274
E	-1X(4C)DIM 42.7 [1.68] WAS 40.6 [1.60] 41.6 [1.64] WAS 37.5 [1.48] -2X(3B)NOTE 6 WAS 42.7(1.68) MAX..... -3UPDATED DRAWING TO ASME Y14.5M 1994 STANDARD	AAB	09-27-12	M85208
F	-1X(4C)DIM 43.4 [1.71] WAS 40.6 [1.60] 42.4 [1.67] WAS 37.5 [1.48] -2X(3B)NOTE 6 WAS 40.6 [1.60] MAX.....	AAB	06-09-14	0056848



INSTALLATION INFORMATION

- INTERNAL SPLINE IN MATING PART TO BE PER SPLINE DATA SPEC MATERIAL TO BE ASTM A304, B620H VACUUM DEGASSED ALLOY STEEL CARBURIZE TO A HARDNESS OF 59-62 Rc WITH CASE DEPTH TO (.50 Rc) 0.76-1.02 [0.30-0.40] DIMENSIONS APPLY AFTER HEAT TREAT
- MATING PART TO HAVE CRITICAL DIMENSIONS AS SHOWN OIL HOLES MUST BE PROVIDED AND OPEN FOR PROPER CIRCULATION
- SEAL IS TO BE FURNISHED WITH MOTOR FOR PROPER OIL CIRCULATION THRU SPLINES
- SOME MEANS OF MAINTAINING CLEARANCE BETWEEN SHAFT AND MOUNTING FLANGE MUST BE PROVIDED
- COUNTERBORE DESIGNED TO ADAPT A STANDARD SLEEVE BEARING 35.010-35.040 [1.3784-1.3795] I.D. BY 44.040-44.070 [1.7339-1.7350] O.D. (OILITE BRONZE SLEEVE BEARING AAM35-44X22)
- 43.4 [1.71] MAX DIMENSION TO BE MAINTAINED WHEN ASSEMBLING SHIPPING AND INSTALLING UNIT TO INSURE VALVE DRIVE ENGAGEMENT WITH VALVE.

INTERNAL INVOLUTE SPLINE DATA



SPLINE PITCH	.12/.24
PRESSURE ANGLE	.30°
NUMBER OF TEETH	12
CLASS OF FIT - REF.	5
TYPE OF FIT	SIDE
PITCH DIAMETER - REF.	25.400000 [1.0000000] [0.21 [0.008] D]
BASE DIAMETER - REF.	21.997045 [0.8660254]
MAJOR DIAMETER	27.74 [1.092] MAX 27.59 [1.086] MIN
MINOR DIAMETER	23.097-23.224 [0.9093-.9143]
FORM DIAMETER, MIN.	26.93 [1.060]
FILLET RADIUS	0.64-0.76 [0.025-.030]
TIP RADIUS	0.25-0.38 [0.010-.015]
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	4.318 [1.700]
MINIMUM EFFECTIVE	4.216 [1.660]
MAXIMUM EFFECTIVE - REF.	4.270 [1.681]
MINIMUM ACTUAL - REF.	4.247 [1.672]
DIMENSION BETWEEN TWO PINS - REF.	19.020-19.190 [0.7488-.7555]
PIN DIAMETER	4.496 [1.770] - NOTE: PIN TO HAVE 3.38 [0.133] WIDE FLAT FOR ROOT CLEARANCE

REVIEWED FOR CLASSIFICATION PER ESP -042

DRAWING BASED ON ASME Y14.5M-1994													
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES FRACTIONS DECIMALS	THE REPRODUCTION, DISTRIBUTION AND UTILIZATION OF THIS DOCUMENT, AS WELL AS THE COMMUNICATION OF ITS CONTENTS TO OTHERS WITHOUT EXPLICIT AUTHORIZATION BY PROHIBITED OFFENDERS WILL BE HELD LIABLE FOR THE PAYMENT OF DAMAGES. ALL RIGHTS RESERVED IN THE EVENT OF A PATENT, UTILITY MODEL, OR DESIGN (PER ISO 9000)												
TOLERANCES	<table border="1"> <tr> <td>XX ± REF</td> <td>BY DATE</td> <td>NATURAL/HEAT TREAT</td> </tr> <tr> <td>XXX ± ONLY</td> <td>BY DATE</td> <td></td> </tr> <tr> <td>UNSPECIFIED DIMS ARE</td> <td>BY DATE</td> <td></td> </tr> <tr> <td>UNSPECIFIED SHAFT ANGLES ARE</td> <td>BY DATE</td> <td></td> </tr> </table>	XX ± REF	BY DATE	NATURAL/HEAT TREAT	XXX ± ONLY	BY DATE		UNSPECIFIED DIMS ARE	BY DATE		UNSPECIFIED SHAFT ANGLES ARE	BY DATE	
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XXX ± ONLY	BY DATE												
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UNSPECIFIED SHAFT ANGLES ARE	BY DATE												
D SIZE	DO NOT SCALE												

2000 SERIES MOTOR COUPLING INSTALLATION

A-684-009

SCALE 1/1 SHEET 1 OF 1