

		GREEN AND HEAT TREAT DIMENSIONS		<table><tr><th>Gage Name</th><th>Gage Size</th><th>Gage Number</th><th>Set Indicator</th><th>Read +/-</th></tr><tr><td>Length</td><td></td><td></td><td></td><td>.003</td></tr><tr><td>I.D.</td><td></td><td></td><td></td><td>.003</td></tr><tr><td>I.D. Radius Surf "A"</td><td></td><td></td><td></td><td></td></tr><tr><td>I.D. Radius Surf "C"</td><td></td><td></td><td></td><td></td></tr><tr><td></td><td></td><td></td><td></td><td></td></tr><tr><td>Large Rib O.D.</td><td></td><td></td><td></td><td>.003</td></tr><tr><td>Large Rib O.D. Radius</td><td></td><td></td><td></td><td></td></tr><tr><td></td><td></td><td></td><td></td><td></td></tr><tr><td>Small Rib O.D.</td><td></td><td></td><td></td><td>.003</td></tr><tr><td>Small Rib Radius & Recess</td><td></td><td></td><td></td><td></td></tr><tr><td></td><td></td><td></td><td></td><td></td></tr><tr><td>O.D. Raceway</td><td></td><td></td><td></td><td>.003</td></tr><tr><td>O.D. Taper & Roll Clear</td><td></td><td></td><td></td><td></td></tr><tr><td></td><td></td><td></td><td></td><td></td></tr><tr><td>Recess Profile</td><td></td><td></td><td></td><td></td></tr><tr><td colspan="5"></td></tr><tr><td>Recess Diameter</td><td></td><td></td><td></td><td>.003</td></tr><tr><td colspan="5"></td></tr><tr><td colspan="5">Ball Diameter = in @ in.</td></tr><tr><td colspan="5">HEAT TREAT GAGES</td></tr><tr><th>Gage Name</th><th>Gage Size</th><th>Gage Number</th><th>Set Indicator</th><th>Read +/-</th></tr><tr><td>OD Taper Surface "A"</td><td></td><td></td><td>0.000</td><td>.004</td></tr><tr><td>Length</td><td></td><td></td><td>0.000</td><td>.004</td></tr><tr><td>I.D.</td><td></td><td></td><td>0.000</td><td>.004</td></tr><tr><td>Heat Treat Tools</td><td colspan="4"></td></tr><tr><td>Quench Die</td><td colspan="4"></td></tr><tr><td colspan="5">HEAT TREAT ALLOWANCE</td></tr><tr><td></td><td>Carb</td><td>Plug</td><td>Draw</td><td></td></tr><tr><td>Large O.D.</td><td>0.000</td><td>0.000</td><td>0.000</td><td></td></tr><tr><td>I.D.</td><td>0.000</td><td>0.000</td><td>0.000</td><td></td></tr><tr><td>R.W.</td><td>0.000</td><td>0.000</td><td>0.000</td><td></td></tr><tr><td colspan="5">HEAT TREAT DIMENSIONS</td></tr><tr><td></td><td>Carb</td><td>Plug</td><td>Draw</td><td></td></tr><tr><td>Large O.D.</td><td>0.000</td><td>0.000</td><td>0.000</td><td></td></tr><tr><td>I.D.</td><td>0.000</td><td>0.000</td><td>0.000</td><td></td></tr><tr><td>R.W.</td><td>0.000</td><td>0.000</td><td>0.000</td><td></td></tr><tr><td colspan="5">STOCK CONDITION</td></tr><tr><td></td><td>Carb</td><td>Plug</td><td>Draw</td><td></td></tr><tr><td>Large O.D.</td><td>0.000</td><td>0.000</td><td>0.000</td><td></td></tr><tr><td>I.D.</td><td>0.000</td><td>0.000</td><td>0.000</td><td></td></tr><tr><td>R.W.</td><td>0.000</td><td>0.000</td><td>0.000</td><td></td></tr><tr><td colspan="5"></td></tr><tr><td colspan="3">APPLICABLE STANDARDS</td><td colspan="2">TD\9650</td></tr><tr><td colspan="3">METALLURGICAL REQUIREMENTS</td><td colspan="2">PDS-103-0</td></tr><tr><td colspan="3">FINAL PRODUCT TOLERANCES</td><td colspan="2">PDS-220-0</td></tr><tr><td colspan="3">CASE DEPTH REQUIREMENTS</td><td colspan="2">PDS-262-0</td></tr><tr><td colspan="3">TAPER BEARING NUMBERING SYSTEM</td><td colspan="2">PDS-100-2</td></tr><tr><td colspan="3">LOCATION OF MARKING</td><td colspan="2">PDS-154-MA</td></tr><tr><td colspan="3"></td><td colspan="2"></td></tr></table>					Gage Name	Gage Size	Gage Number	Set Indicator	Read +/-	Length				.003	I.D.				.003	I.D. Radius Surf "A"					I.D. Radius Surf "C"										Large Rib O.D.				.003	Large Rib O.D. Radius										Small Rib O.D.				.003	Small Rib Radius & Recess										O.D. Raceway				.003	O.D. Taper & Roll Clear										Recess Profile										Recess Diameter				.003						Ball Diameter = in @ in.					HEAT TREAT GAGES					Gage Name	Gage Size	Gage Number	Set Indicator	Read +/-	OD Taper Surface "A"			0.000	.004	Length			0.000	.004	I.D.			0.000	.004	Heat Treat Tools					Quench Die					HEAT TREAT ALLOWANCE						Carb	Plug	Draw		Large O.D.	0.000	0.000	0.000		I.D.	0.000	0.000	0.000		R.W.	0.000	0.000	0.000		HEAT TREAT DIMENSIONS						Carb	Plug	Draw		Large O.D.	0.000	0.000	0.000		I.D.	0.000	0.000	0.000		R.W.	0.000	0.000	0.000		STOCK CONDITION						Carb	Plug	Draw		Large O.D.	0.000	0.000	0.000		I.D.	0.000	0.000	0.000		R.W.	0.000	0.000	0.000							APPLICABLE STANDARDS			TD\9650		METALLURGICAL REQUIREMENTS			PDS-103-0		FINAL PRODUCT TOLERANCES			PDS-220-0		CASE DEPTH REQUIREMENTS			PDS-262-0		TAPER BEARING NUMBERING SYSTEM			PDS-100-2		LOCATION OF MARKING			PDS-154-MA						
Gage Name	Gage Size	Gage Number	Set Indicator	Read +/-																																																																																																																																																																																																																																																														
Length				.003																																																																																																																																																																																																																																																														
I.D.				.003																																																																																																																																																																																																																																																														
I.D. Radius Surf "A"																																																																																																																																																																																																																																																																		
I.D. Radius Surf "C"																																																																																																																																																																																																																																																																		
Large Rib O.D.				.003																																																																																																																																																																																																																																																														
Large Rib O.D. Radius																																																																																																																																																																																																																																																																		
Small Rib O.D.				.003																																																																																																																																																																																																																																																														
Small Rib Radius & Recess																																																																																																																																																																																																																																																																		
O.D. Raceway				.003																																																																																																																																																																																																																																																														
O.D. Taper & Roll Clear																																																																																																																																																																																																																																																																		
Recess Profile																																																																																																																																																																																																																																																																		
Recess Diameter				.003																																																																																																																																																																																																																																																														
Ball Diameter = in @ in.																																																																																																																																																																																																																																																																		
HEAT TREAT GAGES																																																																																																																																																																																																																																																																		
Gage Name	Gage Size	Gage Number	Set Indicator	Read +/-																																																																																																																																																																																																																																																														
OD Taper Surface "A"			0.000	.004																																																																																																																																																																																																																																																														
Length			0.000	.004																																																																																																																																																																																																																																																														
I.D.			0.000	.004																																																																																																																																																																																																																																																														
Heat Treat Tools																																																																																																																																																																																																																																																																		
Quench Die																																																																																																																																																																																																																																																																		
HEAT TREAT ALLOWANCE																																																																																																																																																																																																																																																																		
	Carb	Plug	Draw																																																																																																																																																																																																																																																															
Large O.D.	0.000	0.000	0.000																																																																																																																																																																																																																																																															
I.D.	0.000	0.000	0.000																																																																																																																																																																																																																																																															
R.W.	0.000	0.000	0.000																																																																																																																																																																																																																																																															
HEAT TREAT DIMENSIONS																																																																																																																																																																																																																																																																		
	Carb	Plug	Draw																																																																																																																																																																																																																																																															
Large O.D.	0.000	0.000	0.000																																																																																																																																																																																																																																																															
I.D.	0.000	0.000	0.000																																																																																																																																																																																																																																																															
R.W.	0.000	0.000	0.000																																																																																																																																																																																																																																																															
STOCK CONDITION																																																																																																																																																																																																																																																																		
	Carb	Plug	Draw																																																																																																																																																																																																																																																															
Large O.D.	0.000	0.000	0.000																																																																																																																																																																																																																																																															
I.D.	0.000	0.000	0.000																																																																																																																																																																																																																																																															
R.W.	0.000	0.000	0.000																																																																																																																																																																																																																																																															
APPLICABLE STANDARDS			TD\9650																																																																																																																																																																																																																																																															
METALLURGICAL REQUIREMENTS			PDS-103-0																																																																																																																																																																																																																																																															
FINAL PRODUCT TOLERANCES			PDS-220-0																																																																																																																																																																																																																																																															
CASE DEPTH REQUIREMENTS			PDS-262-0																																																																																																																																																																																																																																																															
TAPER BEARING NUMBERING SYSTEM			PDS-100-2																																																																																																																																																																																																																																																															
LOCATION OF MARKING			PDS-154-MA																																																																																																																																																																																																																																																															
LARGE END ID RADIUS		SMALL END ID RADIUS																																																																																																																																																																																																																																																																
SMALL END FLANGE		LARGE END FLANGE (SCREW MACHINE RECESS)																																																																																																																																																																																																																																																																
UNLESS OTHERWISE SPECIFIED, CORNER BREAK TOLERANCES: ANGLES ±1°, LINEAR ±.005, RADII ±.005, RECESS RADII ± .002.																																																																																																																																																																																																																																																																		