



MS PART NO.	A		B		C		D
	INCHES	0.01 MM	INCHES	0.01 MM	INCHES	0.01 MM	0.01 MM
-3	.040	102 ⁺⁰ / ₋₁	.010	26 ⁺⁰ / ₋₄	.004	10 ⁺⁴ / ₋₀	2.00
-5					.0048	12 ⁺⁴ / ₋₀	
-7	.050	127 ⁺⁰ / ₋₁	.0125	34 ⁺⁰ / ₋₅	.0063	16 ⁺⁴ / ₋₀	TO
-9					.008	20 ⁺⁴ / ₋₀	8.00
-11					.010	25.5 ⁺⁴ / ₋₁	
-13	.0625	160 ⁺⁰ / ₋₁	.020	50 ⁺⁰ / ₋₅	.0125	32 ⁺³ / ₋₂	6.00
-14					.0157	40 ⁺³ / ₋₂	
-14A					.0183	46.5 ⁺⁵ / ₋₀	TO
-15					.020	5 ⁺³ / ₋₂	12.00
-16	.080	204 ⁺⁰ / ₋₁	.031	80 ⁺⁰ / ₋₅	.025	63.5 ⁺⁵ / ₋₀	9.00
-17					.0313	79.5 ⁺⁵ / ₋₁	
-18	.100	254 ⁺⁰ / _{-1.5}	.031	80 ⁺⁰ / ₋₅	.040	102 ⁺⁵ / ₋₁	TO
-19					.050	127 ⁺⁵ / ₋₁	
-20	.156	397 ⁺⁰ / ₋₂	.031	80 ⁺⁰ / ₋₅	.0625	159 ⁺⁵ / _{-2.5}	15.00
-21					.080	203.5 ^{+2.5} / ₋₅	

NOTES -

- UNIT OF MEASURE: 0.01 MM
- CHAMFER SHAPE AT THE OPTION OF THE JEWEL MANUFACTURER
- BREAK ALL SHARP CORNERS EXCEPT THAT INTERSECTION OF CUP AND FLAT SURFACE MUST BE WELL DEFINED
- DIA'S 'A' AND 'C' TO BE ROUNDED WITHIN 0.5
- DIA'S 'A' AND 'C' TO BE CONCENTRIC WITHIN 1
- FLAT ON CUP SIDE MUST BE LARGE ENOUGH TO ALIGN JEWEL IN ITS SETTING
- DEPTH AND SHAPE OF CUP IS AT THE OPTION OF THE MANUFACTURER, BUT THE LENGTH OF THE HOLE MAY NOT EXCEED DIA 'C' NOR BE LESS THAN 1/3 DIA 'C'
- 'D' MIN CLEARANCE FOR PIVOT FILLET RADIUS. SHAPE AT THE OPTION OF JEWEL MANUFACTURER
- THE 'BOMBE' MUST BE UNIFORM
- HIGH POINT OF 'BOMBE' TO CONCENTRIC TO DIA 'C' WITHIN 3

FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN
 REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATIONS FOR BID
 DIMENSIONS IN INCHES ARE FOR REFERENCE ONLY

REVIEWER: ARMY (EL)
NAVY (AS)
A.F. 82

THIS MILITARY STANDARD IS APPROVED BY THE DEPARTMENT OF DEFENSE AND IS MANDATORY ON ALL ACTIVITIES. SELECTION FOR ALL NEW ENGINEERING AND DESIGN APPLICATIONS AND FOR REPETITIVE USE SHALL BE MADE FROM THIS DOCUMENT.

APPROVED 20 JAN 1961 REVISED 30 Oct 61 20 MAY 1970

P.A. Air Force II	TITLE	MILITARY STANDARD
Other Cust Army - MU Navy - SH	BEARING, JEWEL - BAR HOLE, BOMBE'	MS27049
PROCUREMENT SPECIFICATION MIL-B-27497	SUPERSEDES:	SHEET 1 OF 1

DD FORM 672 (COORDINATED)
1 SEP 57

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.