

FED. SUP CLASS
5990

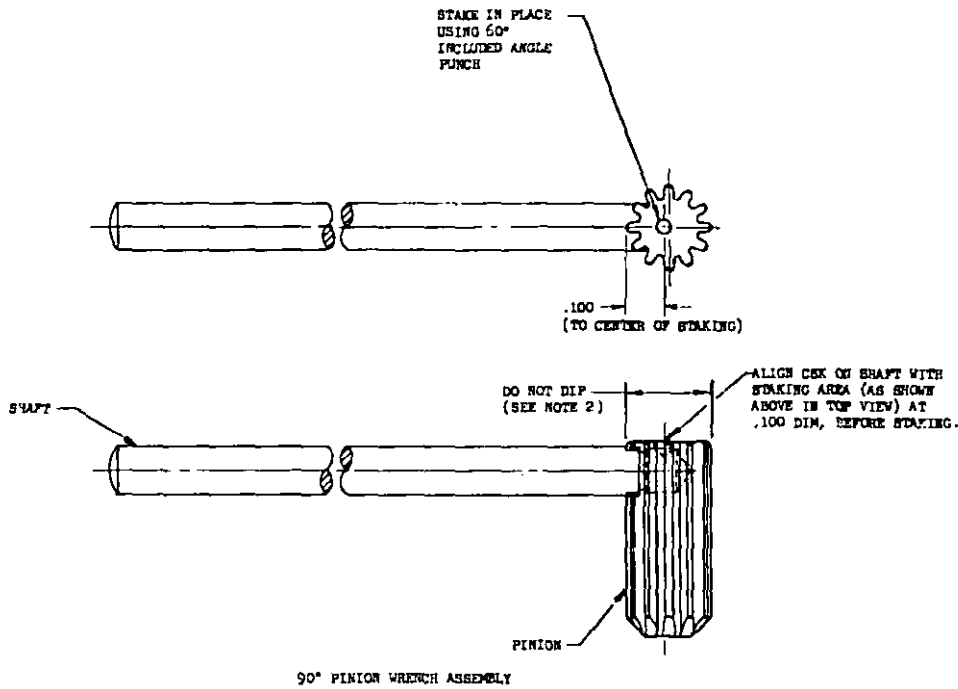
REVIEW/USER INFORMATION IS CURRENT AS OF DATE OF THIS DOCUMENT. FOR FUTURE COORDINATION OF CHANGES TO THIS DOCUMENT, DRAFT CIRCULATION SHOULD BE BASED ON THE INFORMATION IN THE CURRENT DODDIES.

NOTICE:

USER INTEREST:
ARMY - AV
NAVY - AS, CG, MC
AF - 17

REVIEWER INTEREST:
ARMY - MU, IL, MI
NAVY - AS, SR
AF - 11, B5

This military standard is approved by the Department of Defense and is mandatory for use by all Departments & Agencies of the Department of Defense. Selection for all new engineering and design applications and for repetitive use shall be made from this document.



DASH NO.

-2

NOTES:

1. MATERIAL: (A) SHAFT: STEEL, CORROSION RESISTING, QQ-S-763, CLASS 410, COND A, ANNEALED.
(B) PINION: STEEL, CORROSION RESISTING, QQ-S-763, CLASS 410, COND A, ANNEALED.
2. FINISH: WRENCH ASSEMBLY; DIP IN TT-V-119 VARNISH, SPAR, PHENOLIC RESIN, EXCEPT AS NOTED.
3. HEAT TREATMENT: PINION; HEAT TO 1800-1825°F, QUENCH IN OIL, DRAW TO ROCKWELL C 30-35, APPROX DRAW TEMP 950°F.
4. REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
5. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS; ±.005, ANGLES; ± 1°. INTERPRET DIMENSIONING AND TOLERANCING IN ACCORDANCE WITH MIL-STD-2.

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.

P.A. NAVY-AS	TITLE	MILITARY STANDARD
Other Cust ARMY - MU NAVY - AS AF - 11	WRENCH, PINION, 90°	MS90394
PROCUREMENT SPECIFICATION NONE	SUPERSEDES BUORD 644870, 644871, 677064	SHEET 1 OF 2

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

PLATE NO 1451P

APPROVED 6 JUNE 1967 REVISED

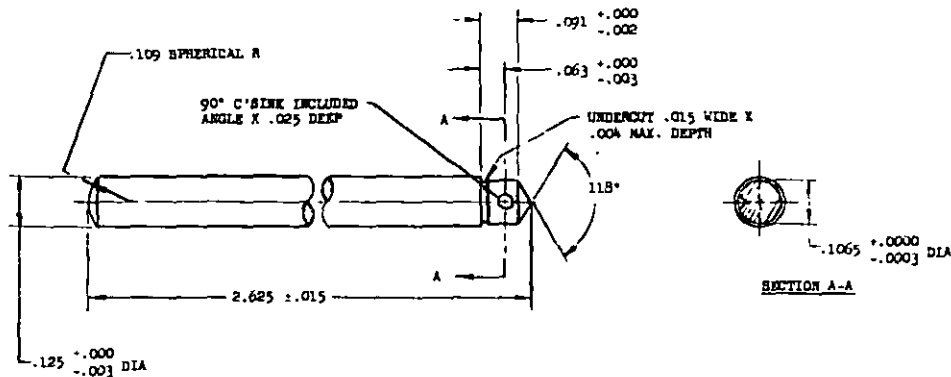
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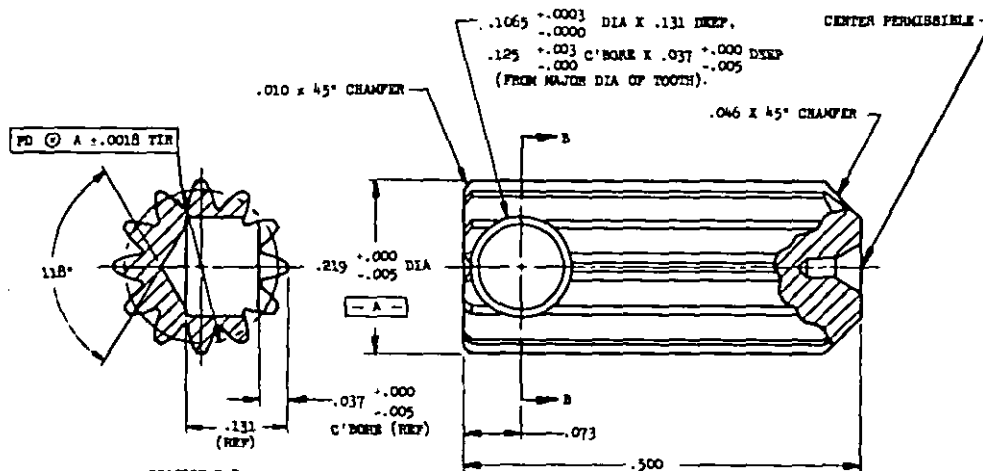
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SHAFT



PINION

GEAR DATA

TOOTH FORM	FULL DEPTH TRUE INVOLUTE
PRESSURE ANGLE	20°
NO. OF TEETH	12
DIAMETRAL PITCH	64
PITCH DIA (DATUM)	.1875
ROOT DIA (MAX)	.146
BACKLASH	.0010 +.0015/-.0000

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P.A. NAVY-AS	TITLE	MILITARY STANDARD
Other Cases ARMY - MI NAVY - AS AF - 11	WRENCH, PINION, 90°	MS90394
PROCUREMENT SPECIFICATION ROSE	SUPERSEDES: NORD 64470, 64471, 67704	SHEET 2

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PLATE 90, 15220