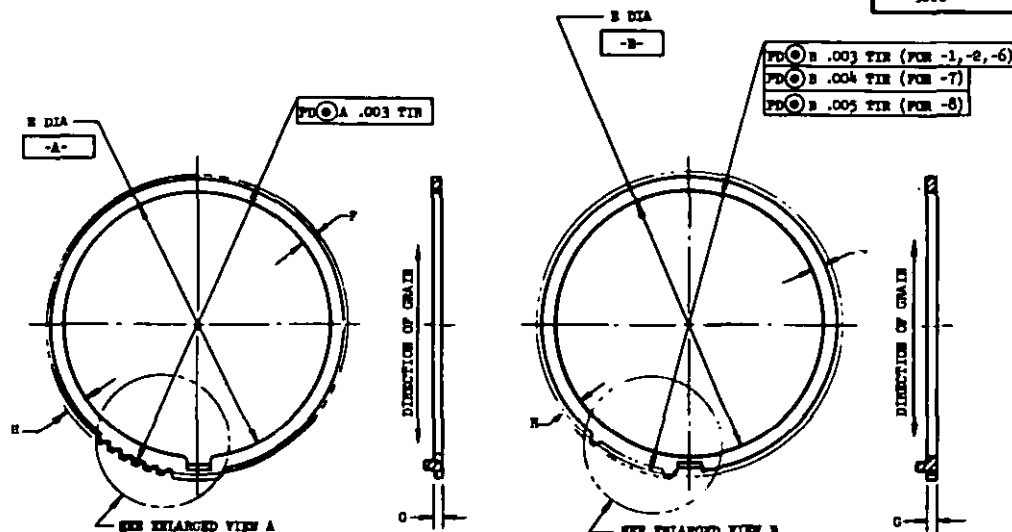


NOTES - REVIEW/USER INFORMATION IS CURRENT AS OF DATE OF THIS DOCUMENT. FOR FUTURE COORDINATION OF CHANGES TO THIS DOCUMENT, FIRST CIRCULATION SHOULD BE BASED ON THE INFORMATION IN THE CURRENT EDITIONS.

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

REVIEWER INTEREST:  
ARMY - MU, EL, MI  
NAVY - AS, SH  
AF - 11, 15

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 revision use shall be made from this document.



RING, ZEROING -1  
RING, ZEROING -4  
RING, ZEROING -5

RING, ZEROING -1  
RING, ZEROING -2  
RING, ZEROING -6  
RING, ZEROING -7  
RING, ZEROING -8

TABLE I - RING DIMENSIONS

DASH NO.	SIZE	R DIA	V	O	H	J	K	L	M
-1	05	0.3756	.0620	.0150	.1145	--	10°	40°	.020
-2	08	0.5006	.1240	.0150	.1875	--	8°	40°	.020
-3	11	1.0002-.0005	.032	.019 ±.003	.077	12°	13°	30°	.010
-4	15	1.3122+.0015-.0000	.069	.032	.108	10°	10°	30°	.020
-5	18	1.5622+.0015-.0000	.095	.032	.140	10°	10°	31°	.040
-6	23	2.000+.004-.000	.185	.041	.174	--	7°	29°11'	.014
-7	31	2.753+.004-.000	.172	.041	.216	--	6°	28°30'	.012
-8	37	3.377+.002-.001	.124	.041	.172	--	5°	30°30'	.014

NOTES:

1. MATERIAL: STEEL, CORROSION RESISTING, QQ-S-766, CLASS 410, CONDITION A, FINISH 2B.
2. FINISH: PASSIVATE IN ACCORDANCE WITH QQ-P-35, TYPE II OR TYPE III.
3. HEAT TREATMENT: HEAT TREAT IN ACCORDANCE WITH MIL-H-6875, 3B to 43 ROCKWELL HARDNESS.
4. REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
5. DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES: DECIMALS ±.0005 FOR -1 AND -2, ±.005 FOR -3, -4, -5, -6, -7, AND -8, ANGLES ±30'. INTERPRET DIMENSIONING AND TOLERANCING IN ACCORDANCE WITH MIL-STD-8.

FOR DESIGN FEATURES PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BID.

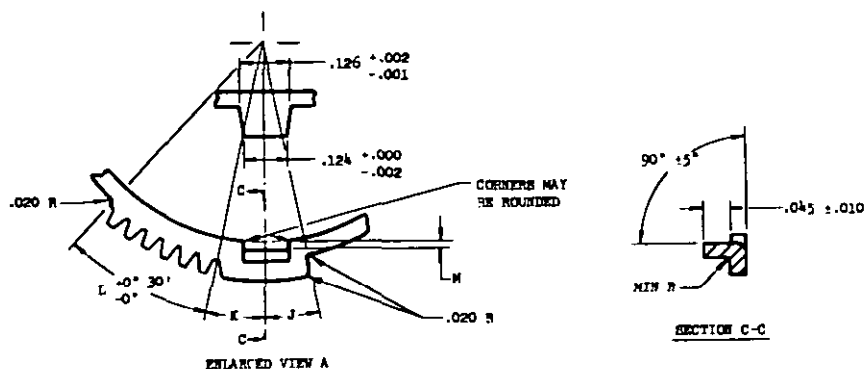
P.A. NAVY-AS Other Cost ARMY - MU NAVY - AS AF - 11	TITLE RING, ZEROING	MILITARY STANDARD MS90398
PROCUREMENT SPECIFICATION NONE	SUPERSEDES: SUORD 813859, 813860, 813861, 854592, 854593, 854594	SHEET 1 OF 2

NOTICE - REVIEW/USER INFORMATION IS CURRENT AS OF DATE OF THIS DOCUMENT. FOR FUTURE COORDINATION OF CHANGES TO THIS DOCUMENT, HARP CIRCULATION SHOULD BE MAILED IN THE INFORMATION IN THE CURRENT DTD/ISS.

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

REVIEWER INTEREST:  
ARMY - MU, EL, M  
NAVY - AS, CH  
AF - 11, 85

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.



FED. SUP CLASS  
5490

TABLE II - GEAR DATA (FOR TOOLING PURPOSES)

DATA	DASH NO.			
	-1	-2	-3	-4
TOOTH FORM	FULL DEPTH TRUE INVOLUTE	FULL DEPTH TRUE INVOLUTE	FULL DEPTH TRUE INVOLUTE	FULL DEPTH TRUE INVOLUTE
PRESSURE ANGLE	20°	20°	20°	20°
TEETH PER COMPLETE GEAR (REV)	36	54	72	96
TEETH PER COMPLETE SECTOR	4	6	6	8
DIAMETRAL PITCH	64	64	64	64
ROOT DIA (MAX)	0.523	0.705	1.086	1.461
BACKLASH	.002 +.002 / -.000	.002 +.002 / -.000	.002 +.002 / -.000	.002 +.002 / -.000
PITCH DIA (DATUM)	.5625	.8437	1.125	1.500

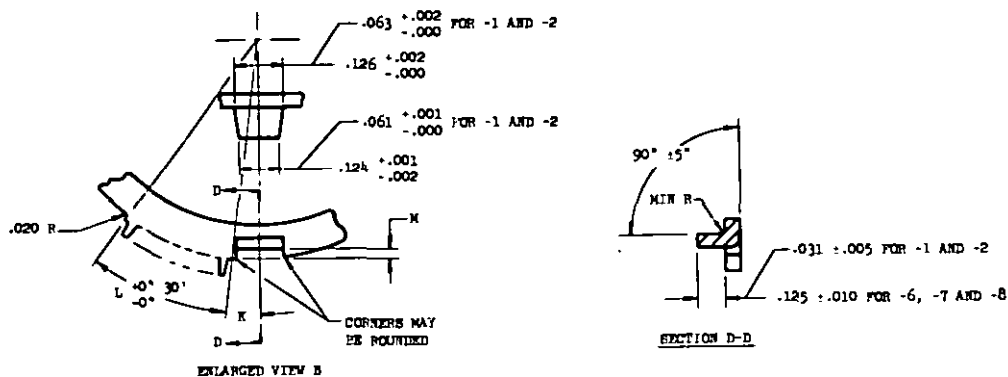


TABLE III - GEAR DATA (FOR TOOLING PURPOSES)

DATA	DASH NO.			
	-5	-6	-7	-8
TOOTH FORM	FULL DEPTH TRUE INVOLUTE	FULL DEPTH TRUE INVOLUTE	FULL DEPTH TRUE INVOLUTE	FULL DEPTH TRUE INVOLUTE
PRESSURE ANGLE	20°	20°	20°	20°
TEETH PER COMPLETE GEAR (REV)	116	148	202	236
TEETH PER COMPLETE SECTOR	10	12	16	20
DIAMETRAL PITCH	64	64	64	64
ROOT DIA (MAX)	1.774	2.274	3.111	3.643
BACKLASH	.002 +.002 / -.000	.002 +.002 / -.000	.002 +.002 / -.000	.002 +.002 / -.000
PITCH DIA (DATUM)	1.813	2.3125	3.156	3.6875

P.A. NAVY - AS	TITLE	MILITARY STANDARD
Other Cases ARMY - MU NAVY - AS AF - 11	RING, ZEROING	MS90398
PROCUREMENT SPECIFICATION N/A	SUPERSEDES: EJORD 813859, 813860, 813861, 854592, 854593, 854594	SHEET 2

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE.

PLATE NO. 15320

APPROVED 6 JUNE 1967 REVISED