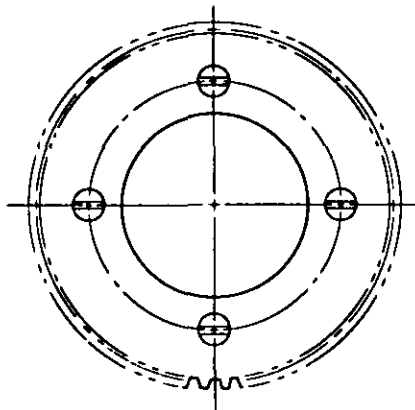


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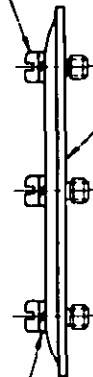
USER INTEREST:  
ARMY - AV  
NAVY - AS, CG, MC  
AF - 17

REVIEW INTEREST:  
ARMY - MJ, EL, M1  
NAVY - AS, BH  
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.



MS90402-2  
(4 REQ'D)



SEE TABLE I AND II

MS35337-78  
(4 REQ'D)

TABLE I - CLAMPING DISC					
DASH NO.	B DIA +.0008 -.0000	C DIA	"D" OD +.000 -.003	E	F RADIUS
-1	.6250	.812	1.156	.412	.277
-2	.8750	1.100	1.531	.569	.461
-3	.9375	1.250	1.844	.659	.959

#### NOTES:

1. MATERIAL: CLAMPING DISC -1, -2 AND -3; STEEL, CORROSION RESISTING, QQ-S-766, CLASS 410, CONDITION A. (COLD FINISH).
2. FINISH: CLAMPING DISC -1, -2 AND -3; PASSIVATE IN ACCORDANCE WITH QQ-P-35, TYPE II OR III.
3. HEAT TREATMENT: HEAT 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. INTERPRET DIMENSIONING AND TOLERANCING IN ACCORDANCE WITH MIL-STD-8.
6. EACH CLAMPING DISC ASSEMBLY SHALL INCLUDE MS90402-2 (4 REQUIRED) AND MS35337-78 (4 REQUIRED).

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 Other Comd ARMY - MJ NAVY - AS AF - 11	TITLE  CLAMPING DISC ASSEMBLY	MILITARY STANDARD	
		MS90400	
PROCUREMENT SPECIFICATION NOTE	SUPERSEDES: BUORD 677030, 677031, 677032, 854459, 854460, 854461.	SHEET	OF
		1	2

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE. W68

PLATE NO. 15120

APPROVED 6 JUNE 1967 REVISED

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

REVIEWER INTEREST:  
ARMY - MJ, EL, MI  
NAVY - AS, SE  
AF - 11, 85

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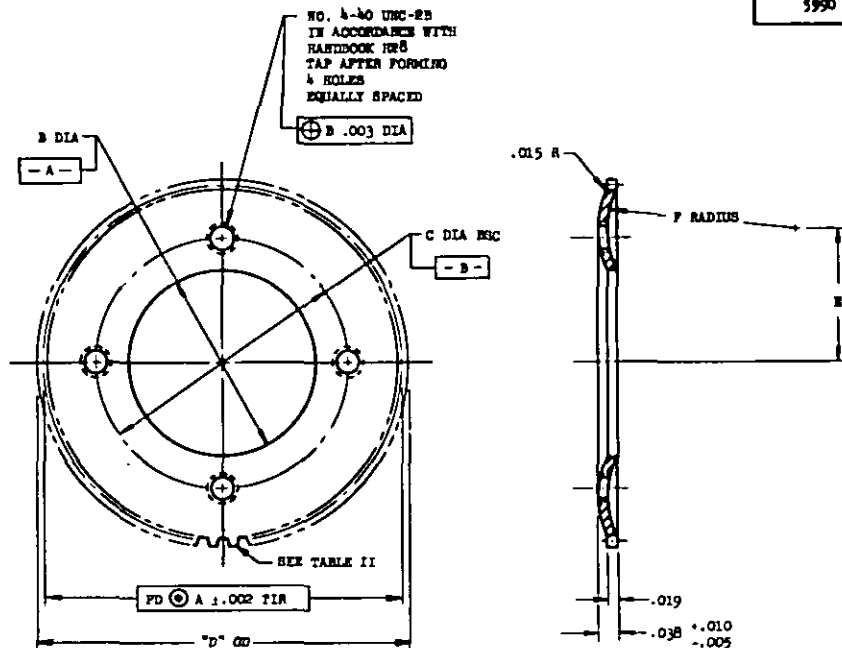


TABLE II - GEAR DATA

DATA	DARK NO.		
	-1	-2	-3
TOOTH FORM	FULL DEPTH THIN INVOLUTE	FULL DEPTH THIN INVOLUTE	FULL DEPTH THIN INVOLUTE
PRESSURE ANGLE	20°	20°	20°
NO. OF TEETH	72	96	116
DIAMETRAL PITCH	64	64	64
PITCH DIA (DATUM)	1.125	1.500	1.813
ROOT DIA (MAX)	1.096	1.456	1.771
BACKLASH	.0010 +.0015 -.0000	.0010 +.0015 -.0000	.0010 +.0015 -.0000

P.A. NAVY - AS

Other Cast  
ARMY - MJ  
NAVY - AS  
AF - 11

PROCUREMENT SPECIFICATION  
FOR

TITLE

CLAMPING DISC ASSEMBLY

SUPERSEDES:  
BORD 677030, 677031, 677032, 854459, 854460, 854461

MILITARY STANDARD

MS90400

SHEET 2

DD FORM 672-1 (Coordinated)

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PLATE NO. 15320

APPROVED 6 JUNE 1967 REVISED