

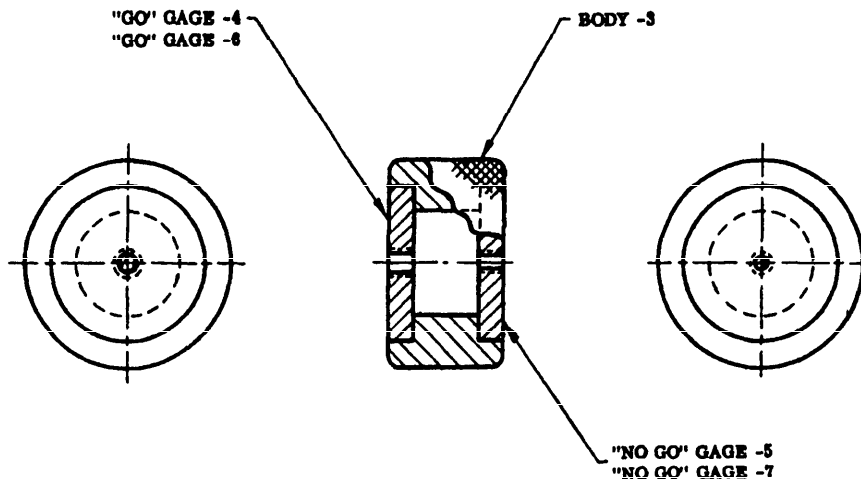
USER SYMBOLS:
ARMY - AV
NAVY - AS, CG, MC
AF - 17

REVIEWER SYMBOLS:
ARMY - MU, EL, MI
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design applications and for repetitive use shall be made
from this document.

FED. SUP CLASS
8220



DASH NO.	"GO" GAGE	"NO GO" GAGE
-1	-4	-5
-2	-6	-7

NOTES:

- MATERIAL: (A) BODY -3; STEEL, QQ-S-637, COMP B1112, CONDITION CDSR.
(B) "GO" RING GAGE -4, -6 AND "NO GO" RING GAGE -5 AND -7; STEEL, HIGH SPEED, QQ-T-590.
- SURFACE ROUGHNESS: (A) BODY; $125/\sqrt{\text{ALL OVER}}$, PRIOR TO KNURLING.
(B) "GO" RING GAGE -4, -6 AND "NO GO" RING GAGE -5 AND -7, $16/\sqrt{\text{ALL OVER}}$.
FINISH IN ACCORDANCE WITH ASA B46.1.
- HEAT TREATMENT: "GO" RING GAGE -4, -6 AND "NO GO" RING GAGE -5 AND -7; OIL HARDEN TO ROCKWELL C60 -63.
- REMOVE ALL BURRS AND BREAK ALL SHARP EDGES.
- THE MARKING ON GAGE -4, -5, -6 AND -7 SHALL INCLUDE THE MS PART NO. AND LATEST REVISION LETTER, THE WORDS "GO" OR "NO GO" AS APPLICABLE, THE NO. OF TEETH, THE DIAMETRAL PITCH AND THE PRESSURE ANGLE.
- DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED TOLERANCES; DECIMALS $\pm .005$ ANGLES, $\pm 1^\circ$.
INTERPRET DIMENSIONING AND TOLERANCING IN ACCORDANCE WITH MIL-STD-8.

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 Code ARMY - MU NAVY - AS AF - 11	TITLE GAGE, RING, SPLINE (GO-NO GO)	MILITARY STANDARD MS90406
PROCUREMENT SPECIFICATION	SUPERSEDES: BUORD SA-2412503 AND SA-2412504	SHEET 1 OF 2

DD FORM 672-1 (Coordinated)

PREVIOUS EDITIONS OF THIS FORM ARE OBSOLETE. W73

PLATE NO. 15320

APPROVED 6 JUNE 1967 REVISED

USER SYMBOLS:
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REVIEWER SYMBOLS:
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FED. SUP CLASS
5220

BODY -3

IDENTIFICATION AND MARKING
(SEE NOTE 5)

SEE ENLARGED SPLINE
VIEW AND TABLE I.

1.5008 $\pm .0007$
DIA

1.000 DIA

INVOLUTE FORM MUST
BE TRUE WITHIN
SPECIFIED LIMITS,
INSIDE THIS DIA

ENLARGED SPLINE VIEW

TABLE I - SPLINE DATA

DATA	DASH NO.			
	-4	-5	-6	-7
GAGE TYPE	"GO"	"NO GO"	"GO"	"NO GO"
TOOTH FORM (a)	FULL DEPTH TRUE INVOLUTE	FULL DEPTH TRUE INVOLUTE	FULL DEPTH TRUE INVOLUTE	FULL DEPTH TRUE INVOLUTE
PRESSURE ANGLE	20°	20°	20°	20°
NO. OF TEETH	21	21	13	13
DIAMETRAL PITCH	120	120	120	120
A DIA (REF)	.1889 $\pm .0000$ -.0001	.1581 $\pm .0001$ -.0000	.0918 $\pm .0000$ -.0001	.0909 $\pm .0001$ -.0000
B $\pm .0002$ (INSIDE DIA)	.1644	.1644	.1018	.1018
C (PITCH DIA) (REF)	.175	.175	.1083	.1083
D (TRUE INVOLUTE FORM DIA)	.1872	.1872	.1247	.1247
E (MIN ROOT DIA)	.189	.189	.126	.126
F (CIRCULAR SPACE WIDTH) (REF)	.01309	.01286	.01309	.01285
G (BASE CIRCLE DIA)				

(a) ALLOWABLE ERRORS: SPACING $\pm .0002$, INVOLUTE PROFILE $\pm .0002$.

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