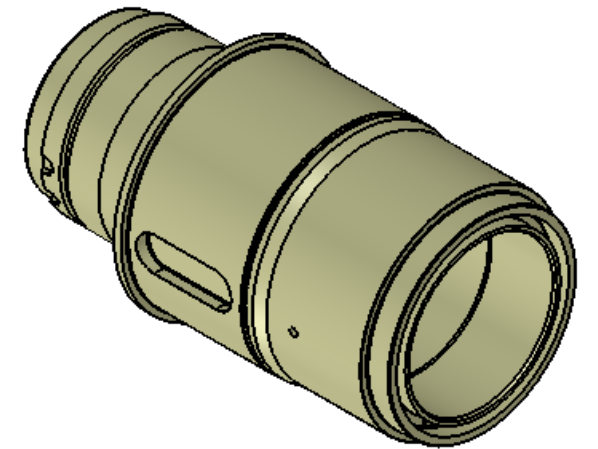




6

— SPLINE DATA SHEET
ON 251249



MAKE FROM MODEL 1509-GS-010-B

1. MATERIAL: EXISTING SHAFT 251249 (Rev E)
2. INSPECT DIMENSIONS MARKED - RESIZE TO DIMENSIONS SHOWN. IF UNDERSIZE, GRIND TO CLEAN UP, HARD CHROME PLATE AND RE-GRIND TO SIZE INDICATED.

ALT: REPAIR BY METAL SPRAY, 45 Rc min HARDNESS.
RECORD PROCESS USED AND DIMENSIONS AS IDENTIFIED.
3. INSPECT CONDITION OF END FACE GROOVE, REMOVE ANY EDGE BUMPS OR DEFECTS.
4. REMACHINE DAMAGED DIAMETER TO THIS SIZE, FULL CLEAN-UP NOT REQUIRED
5. CRACK TESTING: MAGNETIC PARTICLE TESTING OR DYE PENETRANT TEST GROUND SURFACES TO ISO 6336-5 (ALT: AGMA 2001-D04-GRADE 3) NO CRACKS ALLOWED.
6. VISUALLY INSPECT EXISTING SPLINE 100%. NO STEP ALLOWED ON PROFILE. MICRO INSPECT WORST TOOTH IN THREE (3) PLACES ALONG THE LENGTH.
7. NON SPECIFIED FILLETS - R3, NON SPECIFIED CHAMFERS - 1x45°

REV	CHANGED FROM	BY	DATE	APRD	<div>REPORT ERRORS & CHANGES REMOVE ALL BURRS AND SHARP EDGES DIMENSIONS ARE IN MILLIMETERS. UNSPECIFIED TOLERANCES: DECIMALS: FINISH: ANGLES:</div> <div>X. ±1.0 6.3 < ± 0.5° .X ±0.5 .XX ±0.25 √ μm Ra</div> <div>COPYRIGHT ©</div> <div>NOT TO BE REPRODUCED OR USED TO MAKE OTHER DRAWINGS OR MACHINERY</div>									
A	PRE-RELEASE	JFC	8/13/12											
B	REVIEWED & UPDATED PER 1509-ENC-004 IF REQUIRED	CPS	1/18/13		TITLE: <div>HOLLOW SHAFT - REMACHINED</div>									
C	UPDATE PER 1509-DDS-017-A004 REQUEST	CPS	2/28/13											
D	UPDATE PER REVIEW AND RELEASE FOR PRODUCTION	CPS	4/18/13		SIZE DWG. NO. REV <div>B 254494 F</div>									
E	REPAIR DANGLING DIMENSIONS AND NOTES	JMG	10/17/13											
F	CHANGES REQUESTED PER MANUFACTURER REVIEW	CPG	12/11/13		SCALE: 1:5 WEIGHT: 16.95 kgs SHEET 1 OF 1									