

.6250^{+0.0003}/_{-0.0003} DIA THRU SOLID SECTION. WHERE BORE BREAKS OUT. 4 HOLES

VERTICAL BEARING BORES

#8-32UNC-2B 4 HOLES (2 EACH SIDE)

0.10

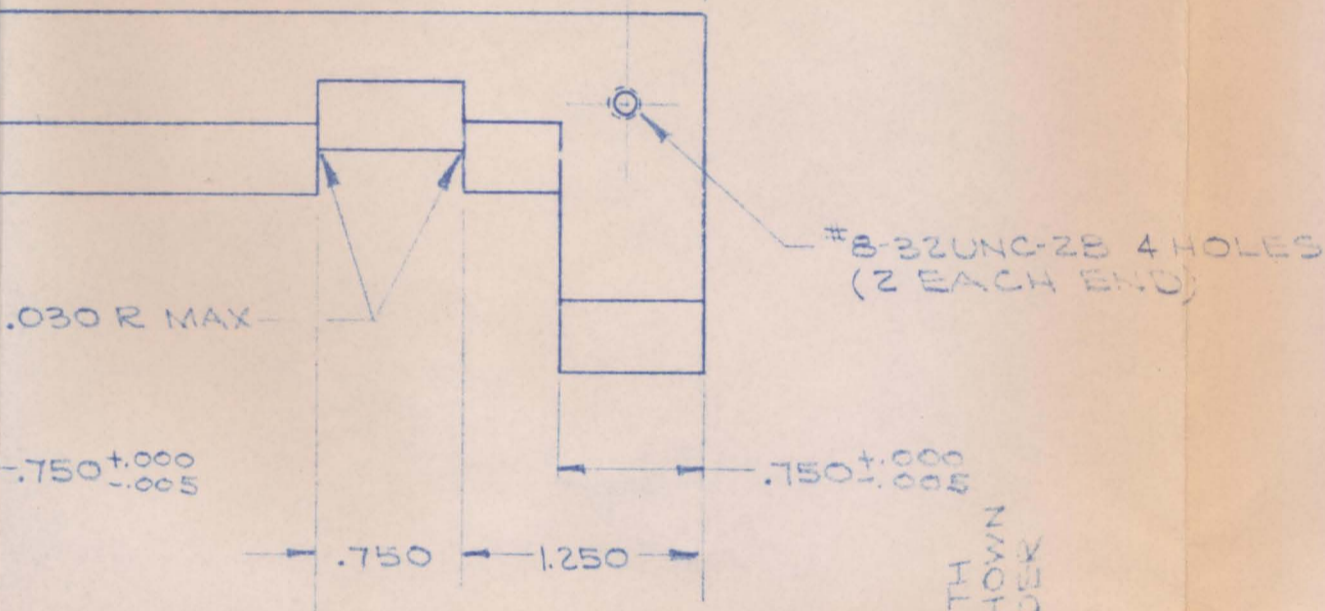
.1875 DIA. 4 HOLES

SECTION D-D

ALIGNMENT CHECKS

1. WITH PINION ASSEMBLED, PINION BREAKAWAY TORQUE NOT TO EXCEED ONE INCH-OUNCE.
2. HORIZONTAL BEARING BORES (B) TO BE PARALLEL TO PINION JOURNALS WITHIN .001 INCH/INCH.
3. VERTICAL BEARING BORES (4) TO BE PERPENDICULAR TO PINION JOURNALS WITHIN .001 INCH/INCH.
4. OUTER RACES OF LOWER HORIZONTAL BEARING BORES (4) TO LIE IN THE SAME PLANE WITHIN .001.
5. PLANE ESTABLISHED IN ITEM 4 TO BE PARALLEL TO PINION JOURNALS WITHIN .0015 INCH/INCH.
6. TANGENT LINE TO OUTER RACES OF VERTICAL CONCENTRIC BEARINGS (2) TO BE PERPENDICULAR TO PINION JOURNALS WITHIN .001 INCH/INCH.

4.500
0.375
0.375



#8-32UNC-2B 4 HOLES (2 EACH END)

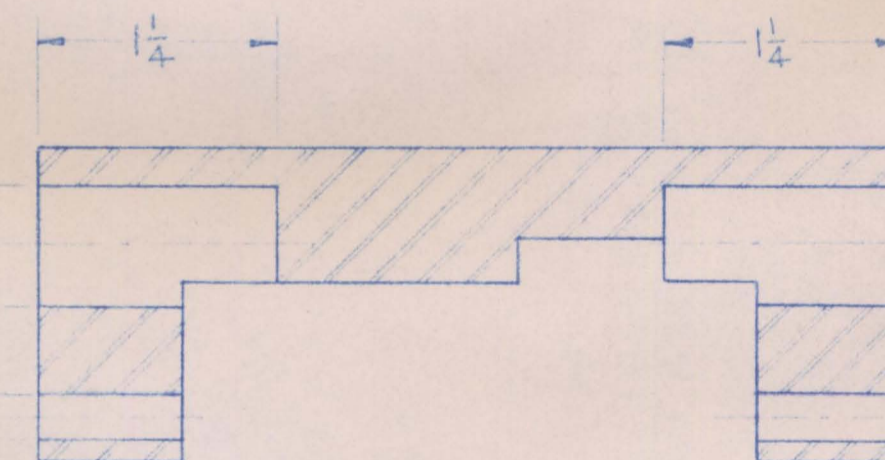
.750^{+0.000}/_{-0.005}
0.750
1.250
0.750^{+0.000}/_{-0.005}

DEPTH OF PRECISION BORE

0.10
0.375

.6250^{+0.0003}/_{-0.0003} DIA BOTH SIDES TO DEPTH SHOWN .39 DIA FOR REMAINDER OF BORE

.2500^{+0.0002}/_{-0.0002} DIA 4 HOLES
.6250^{+0.0003}/_{-0.0003} DIA 4 HOLES



HORIZONTAL BEARING BORES

SECTION C-C

SECTION E-E

40 OR 4340 ALLOY STEEL
HARDENED TO Rc 28-32

NEXT ASSY D-317

REF. GENERAL MILLS
DWG. 539018



McCARTNEY MFG. CO.
BAKTER SPRINGS KANSAS

CARRIAGE

UNLESS OTHERWISE SPECIFIED
TOLERANCE FRACTIONS $\pm \frac{1}{64}$ DECIMALS $\pm .005$
BREAK SHARP CORNERS AND EDGES .010 R ALL OVER
SURFACE FINISH $\sqrt{125}$ ALL OVER

SCALE FULL	DATE 10-7-63
MATERIAL NOTED	HEAT TREAT NOTED
CATALOG NO.	DWG NO. D-316