

.6250^{+0.0003}/_{-0.0002} DIA THRU SOLID SECTION. ^{2.00} DIA WHERE BORE BREAKS OUT. 4 HOLES

VERTICAL BEARING BORES

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

.010

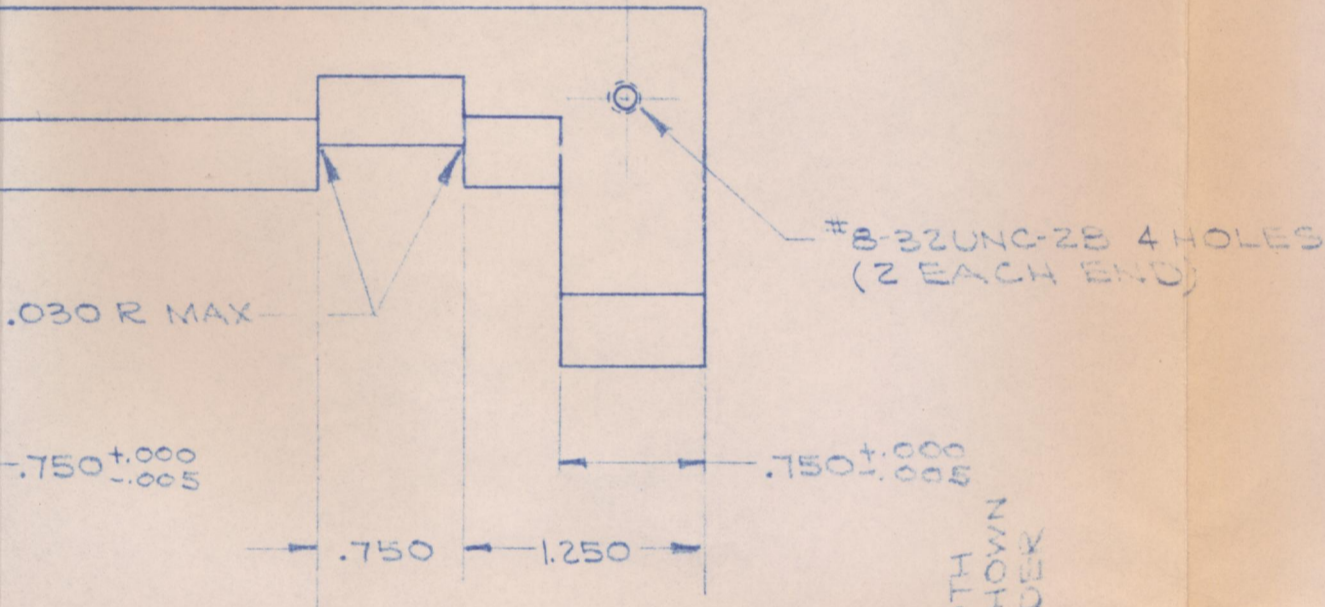
.1875 DIA. 4 HOLES

SECTION D-D

ALIGNMENT CHECKS

1. WITH PINION ASSEMBLED, PINION BREAKAWAY TORQUE NOT TO EXCEED ONE INCH-OUNCE.
2. HORIZONTAL BEARING BORES (6) 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
.375
.375



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

.750 ± .0005

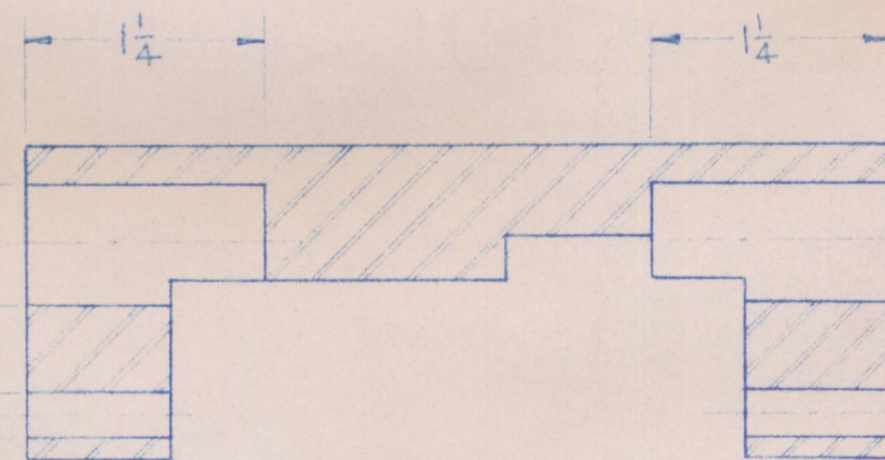
.750
.1250
.6250^{+0.0003}/_{-0.0002} DIA. BOTH SIDES TO DEPTH SHOWN .25 DIA. FOR REMAINDER OF BORE

DEPTH OF PRECISION BORE

.060
.275

SECTION C-C

.2500^{+0.0002}/_{-0.0001} DIA 4 HOLES
.6250^{+0.0003}/_{-0.0002} DIA 4 HOLES



HORIZONTAL BEARING BORES

SECTION E-E

40 OR 4340 ALLOY STEEL
HARDENED TO: Rc 28-32

NEXT ASSY D-317

REF. GENERAL MILLS
DWG. 533018



McCartney MFG. CO.
BAXTER SPRINGS KANSAS

CARRIAGE

UNLESS OTHERWISE SPECIFIED
TOLERANCE FRACTIONS ± 1/64 DECIMALS ± .005
BREAK SHARP CORNERS AND EDGES .010 R ALL OVER
SURFACE FINISH 125 ALL OVER

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