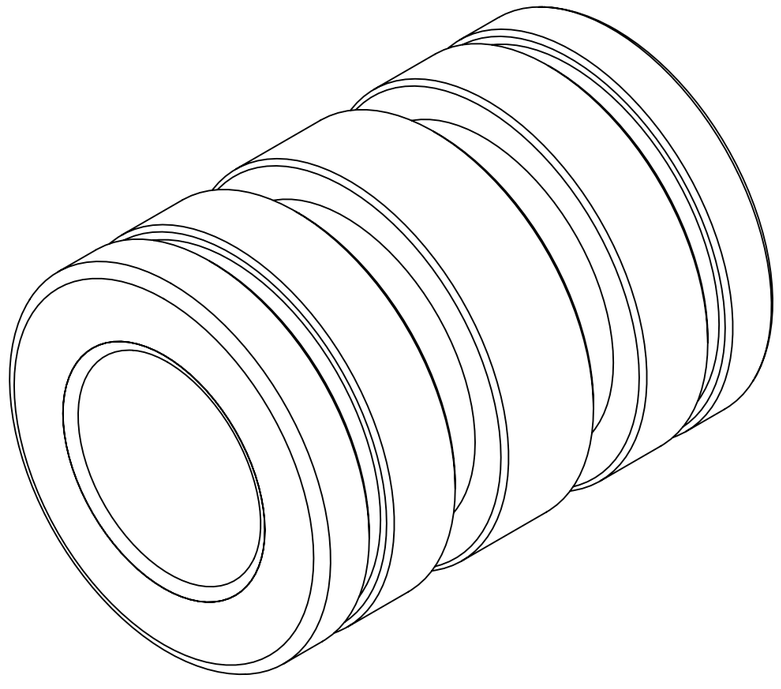
OP #: SEE ROUTING

OP: ASSEMBLY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	3000008	6061-T6511	1
2	2900185	TA COMBO 1060015 2040013	1



PART WEIGHT: LBS/EA

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TOLERANCES UNLESS OTHERWISE SPECIFIED

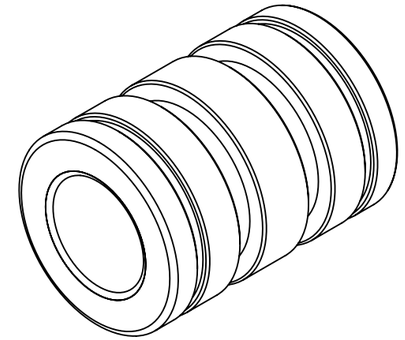
INCH		MM		ANGLES ±1°
.X	±.030	X	±.75	MAX SURFACE FINISH 125 Ra
.XX	±.010	.X	±.25	
.XXX	±.005	.XX	±.13	BREAK ALL CORNERS

TITLE: SIMPLICITY PLAIN BEARING

PART NO.	REV.
FL08	CA

MATERIAL	3RD ANGLE PROJ.	SIZE	SCALE	SHEET
		B	1:1	1 OF 10

OP #: SEE ROUTING
OP: PART NUMBER MATRIX



SERIES	FL	=	STANDARD INCH SERIES
OD FEATURE		=	STANDARD STRAIGHT O.D. BEARING
ID FEATURE		=	STANDARD PRECISION RUNNING CLEARANCE ON THE I.D.
CLOSED/OPEN STYLE		=	STANDARD CLOSED BEARING
BEARING SHELL MATERIAL		=	STANDARD ALUMINUM ALLOY
NOMINAL SHAFT DIAMETER	08	=	0.5 INCH I.D.
SEAL OPTIONS		=	NO SEALS
BEARING LINER MATERIAL		=	FRELON GOLD LINER AND PURPLE ADHESIVE
INTERNAL LUBRICATION		=	STANDARD BEARING - NO LUBE SYSTEM
SPECIAL MODIFICATIONS		=	STANDARD OPTIONS

ANODIZED COLOR: RED

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TOLERANCES UNLESS OTHERWISE SPECIFIED

INCH		MM		ANGLES ±1°
.X	±.030	X	±.75	MAX SURFACE FINISH 125 Ra
.XX	±.010	.X	±.25	BREAK ALL CORNERS
.XXX	±.005	.XX	±.13	

TITLE: SIMPLICITY PLAIN BEARING

PART NO.: FL08

REV.: CA

MATERIAL

3RD ANGLE PROJ.

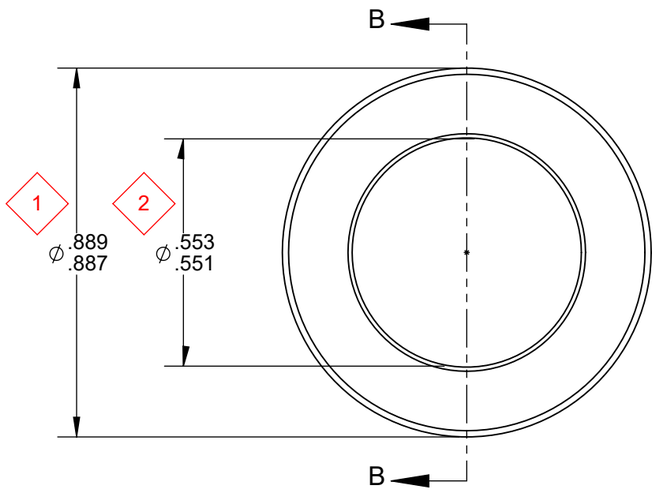
SIZE: B

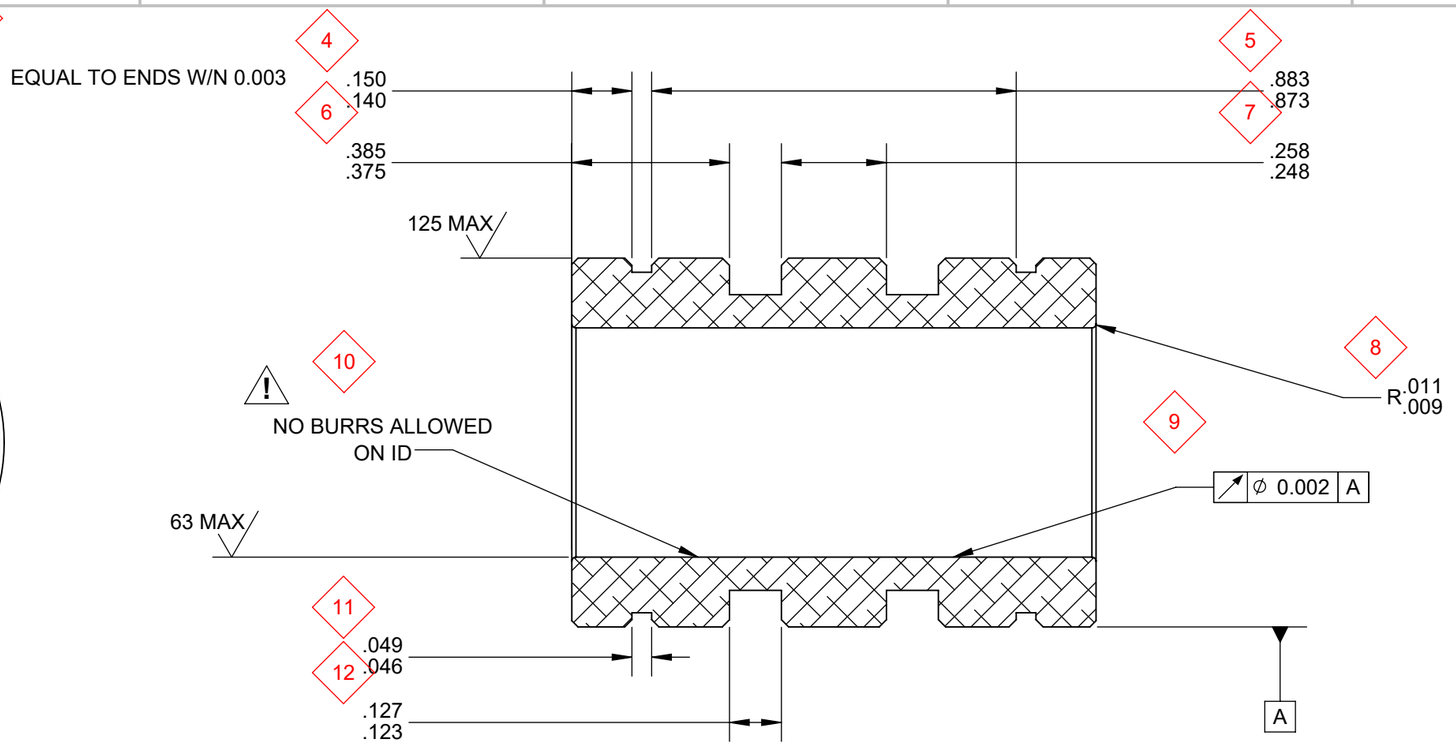
SCALE: 1:1

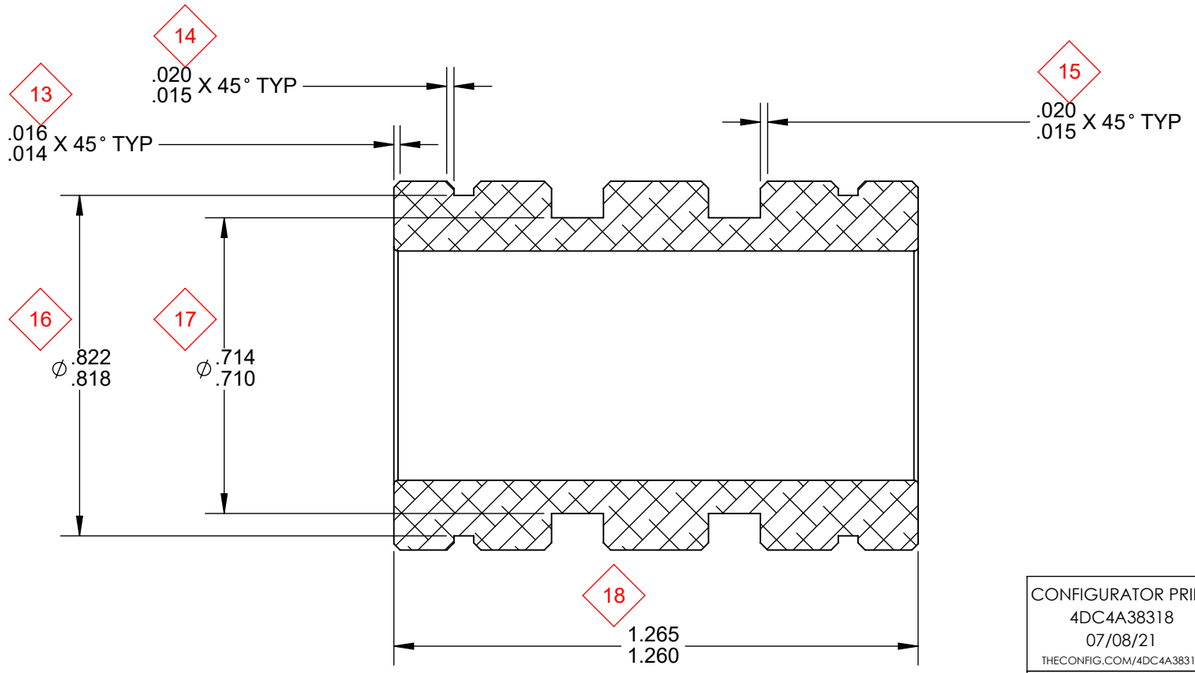
SHEET: 2 OF 10

OP #: SEE ROUTING

OP: TURN BLANK







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TOLERANCES UNLESS OTHERWISE SPECIFIED

INCH		MM		ANGLES ±1°
.X	±.030	X	±.75	MAX SURFACE FINISH 125 Ra
.XX	±.010	.X	±.25	BREAK ALL CORNERS
.XXX	±.005	.XX	±.13	

TITLE: SIMPLICITY PLAIN BEARING

PART NO.: FL08

REV.: CA

MATERIAL

3RD ANGLE PROJ.

SIZE: B

SCALE: 1:1

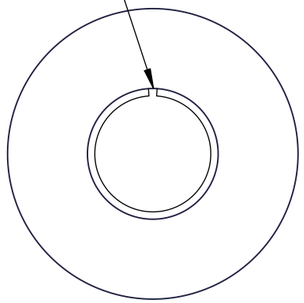
SHEET: 3 OF 10

OP #: SEE ROUTING

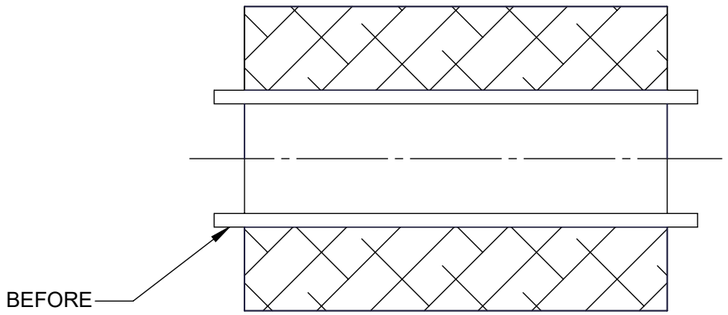
OP: BOND

ADHESIVE TYPE:	Purple
ADHESIVE THICKNESS:	0.008
TEFLON TYPE:	Frelon Gold Liner
TEFLON THICKNESS:	0.027
T/A COMBO THICKNESS:	0.035

EXAMPLE OF
A BAD SEAM

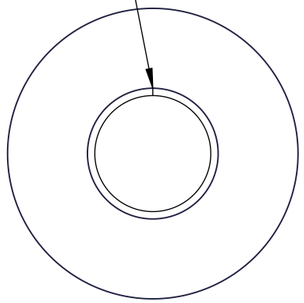


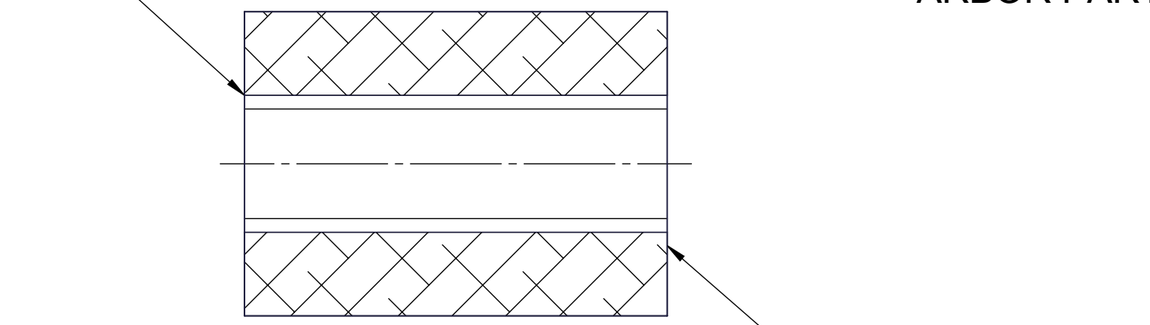
TRIM TEFLON FLUSH TO FACE
NO CHATTER MARKS (BOTH SIDES)



T/A COMBO PART NO:	2900185
ARBOR PART NO:	FL08-ARBOR

EXAMPLE OF
A GOOD SEAM





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TOLERANCES
UNLESS OTHERWISE SPECIFIED

INCH		MM		
.X	±.030	X	±.75	ANGLES ±1°
.XX	±.010	.X	±.25	MAX SURFACE FINISH 125 Ro
.XXX	±.005	.XX	±.13	BREAK ALL CORNERS

TITLE
SIMPLICITY PLAIN BEARING

PART NO.
FL08

REV.
CA

MATERIAL

3RD ANGLE PROJ.

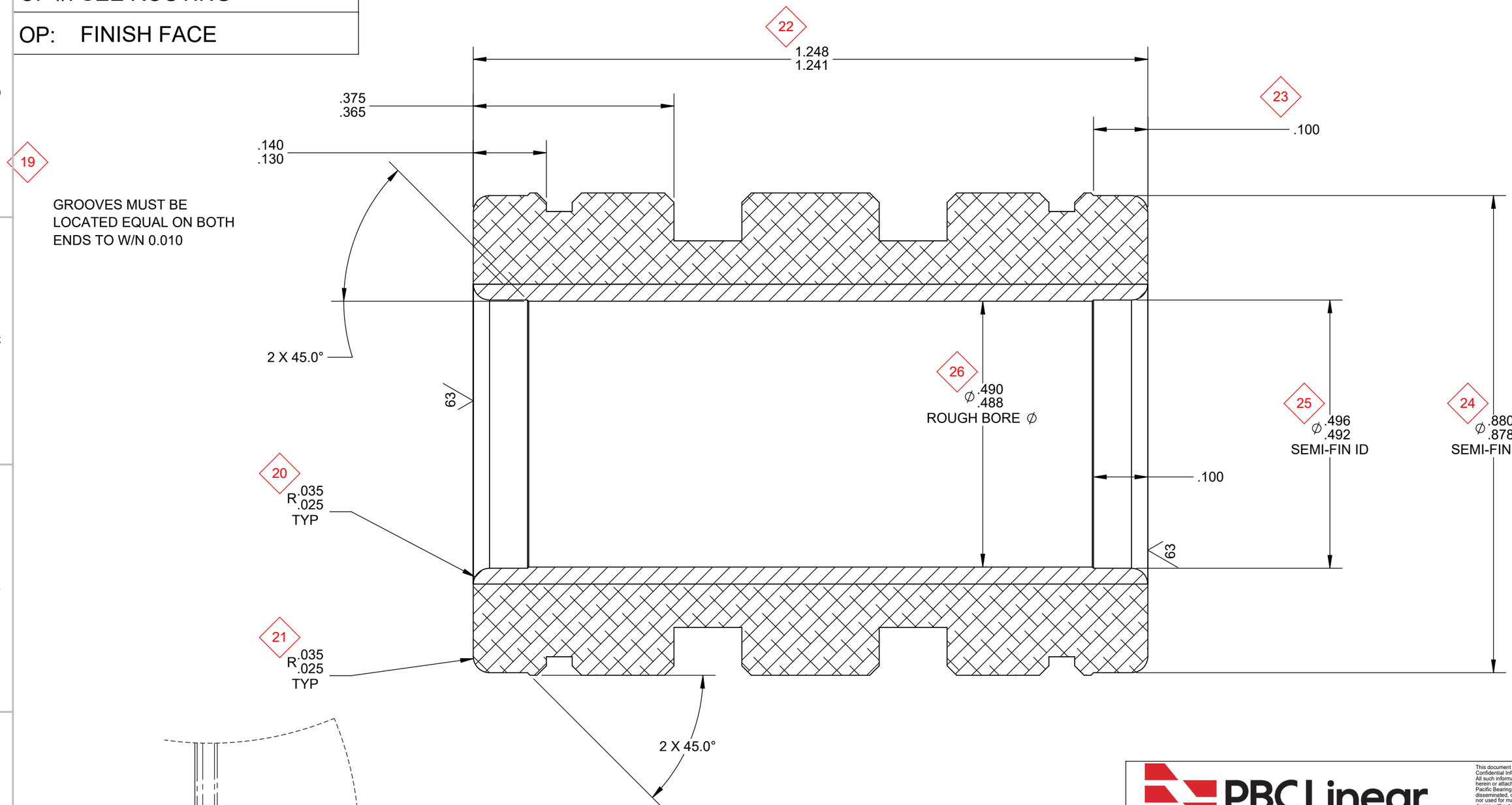
SIZE
B

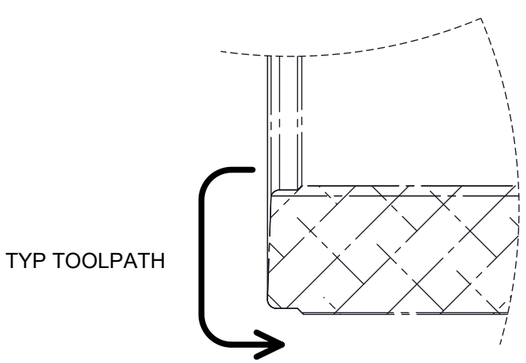
SCALE
1:1

SHEET
4 OF 10

OP #: SEE ROUTING

OP: FINISH FACE





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TOLERANCES UNLESS OTHERWISE SPECIFIED

INCH		MM		ANGLES ±1°
.X	±.030	X	±.75	MAX SURFACE FINISH 125 Ro
.XX	±.010	.X	±.25	
.XXX	±.005	.XX	±.13	BREAK ALL CORNERS

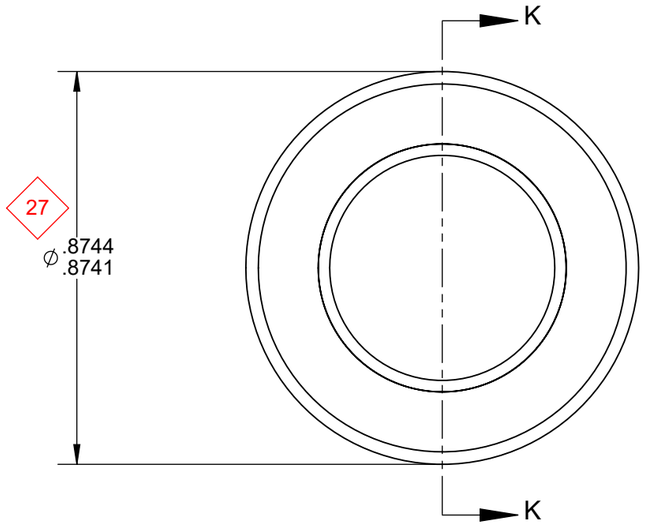
TITLE: SIMPLICITY PLAIN BEARING

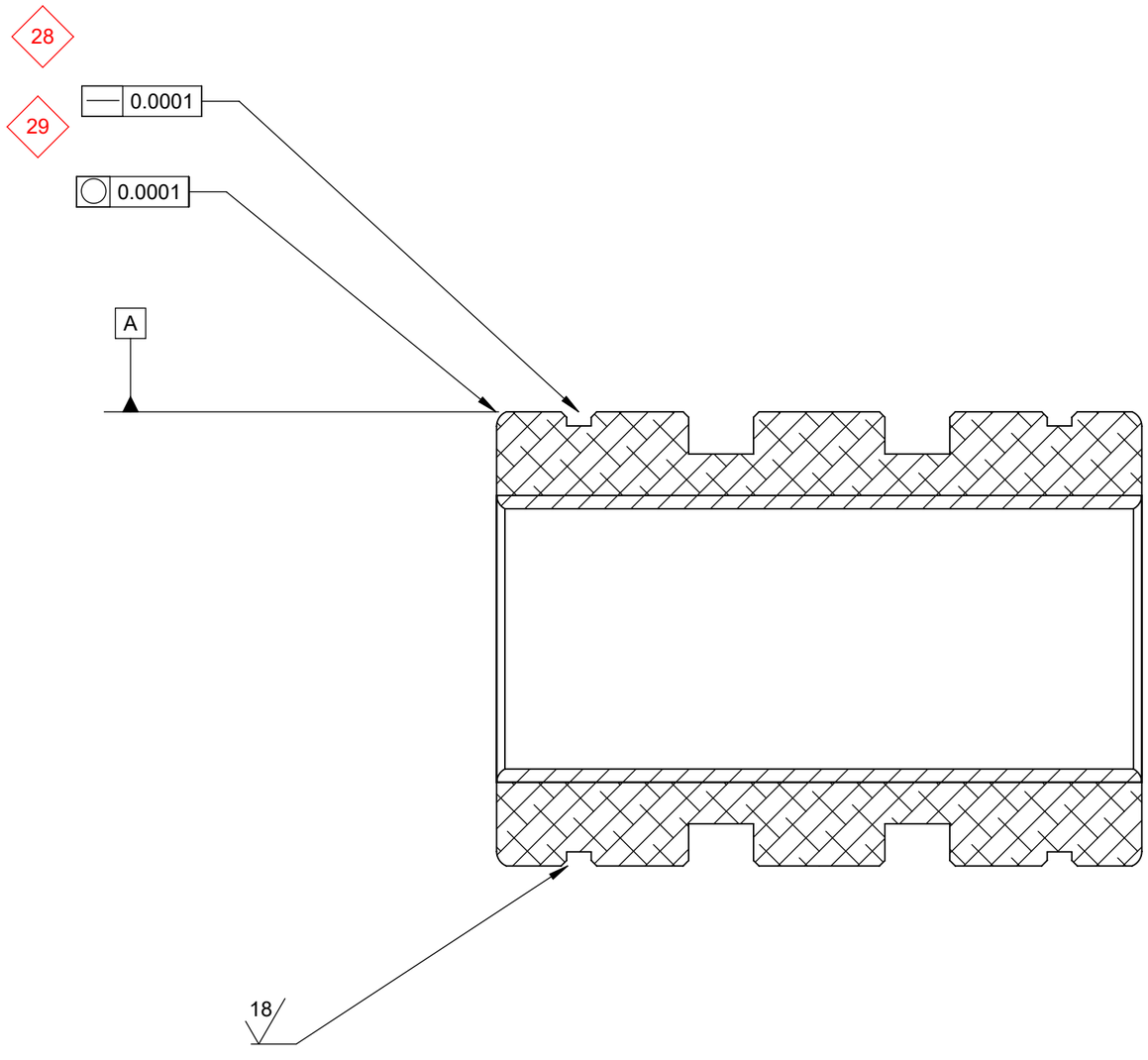
PART NO.	REV.
FL08	CA

MATERIAL	3RD ANGLE PROJ.	SIZE	SCALE	SHEET
		B	1:1	5 OF 10

OP #: SEE ROUTING

OP: FINISH GRIND OD





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TOLERANCES UNLESS OTHERWISE SPECIFIED

INCH		MM	
.X	±.030	X	±.75
.XX	±.010	.X	±.25
.XXX	±.005	.XX	±.13

ANGLES ±1°
MAX SURFACE FINISH 125 Rα
BREAK ALL CORNERS

TITLE: SIMPLICITY PLAIN BEARING

PART NO.: FL08

REV.: CA

MATERIAL

3RD ANGLE PROJ.

SIZE: B

SCALE: 1:1

SHEET: 6 OF 10

OP #: SEE ROUTING

OP: ANODIZE

1. SCOPE
THIS SPECIFICATION DESCRIBES THE GENERAL REQUIREMENT FOR **RED** COAT ANODIZE.

2. APPLICABLE SPECIFICATIONS
THE FOLLOWING FORM A PART OF THIS SPECIFICATION WHERE SPECIFIED, OR APPLY AS A WHOLE WHEN NOT SPECIFICALLY REFERENCED:
MIL-A-8625F, TYPE II, CLASS 2 **(RED)**

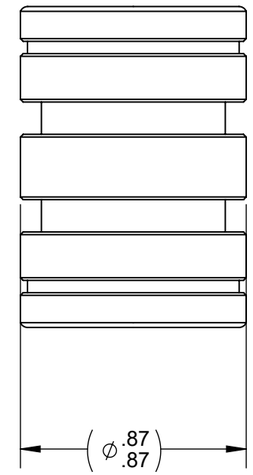
3. REQUIREMENTS (UNLESS OTHERWISE SPECIFIED)
THE SUPPLIER ASSUMES THE RESPONSIBILITY FOR MAINTAINING THE QUALITY OF EACH SHIPMENT OF THIS MATERIAL CONSISTENT WITH THE REQUIREMENTS OF THIS SPECIFICATION. NO CHANGE IN COMPOSITION IS PERMITTED WITHOUT PRIOR WRITTEN APPROVAL OF PACIFIC BEARING CORP.

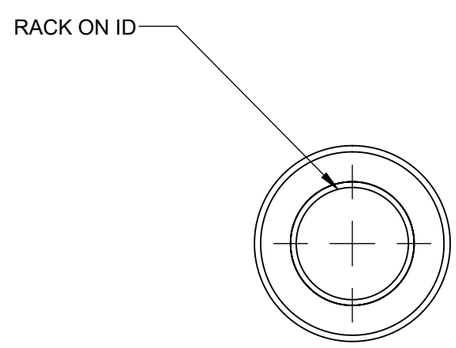
A. ETCHING
FLASH ETCH PARTS (5 TO 15 SECONDS) OR DO NOT ETCH PARTS.

B. THICKNESS
THE ANODIZING THICKNESS SHALL BE BETWEEN .00007 AND .00010 INCHES.

C. RACKING
PARTS MAY ONLY BE HELD AT POINTS OR SURFACES LABELED ACCEPTABLE ON PART DRAWING.
IF NO DRAWING EXIST, CONTACT PACIFIC-BEARING FOR RACKING LOCATION.
RACK MARKS ALLOWED ONLY AT POINT OF CONTACT UNLESS OTHERWISE SPECIFIED.

D. APPEARANCE AND WORKMANSHIP
THE ANODIZING SHOULD BE SMOOTH, COVER THE ENTIRE PART, AND BE WITHOUT SCRATCHES, CHEMICAL STAINS, OR BLEED OUT. IT IS ACCEPTABLE FOR THE SURFACES HELD DURING ANODIZING TO HAVE VOIDS, AS LONG AS THE PARTS WERE RACKED AS DESCRIBED IN SECTION C ABOVE.





4. INSPECTION
REQUIREMENTS INCLUDED IN ANY PURCHASE ORDER CONTRARY TO THIS SPECIFICATION ARE AMENDMENTS FOR THAT ORDER ONLY. FAILURE OF THE MATERIAL TO COMPLY WITH THIS SPECIFICATION AND THE PURCHASE ORDER REQUIREMENTS WILL BE REASON FOR REJECTION.

5. PACKAGING
PARTS SHALL BE PACKAGED IN THE SAME PACKAGING SENT TO THE ANODIZER UNLESS OTHERWISE SPECIFIED. IF PARTS ARE PACKAGED IN OIL PAPER, FRESH PAPER SHOULD BE USED TO RETURN THE PARTS.

SPECIAL NOTES
A. WHEN PROCESSING, HANDLING, AND PERFORMING TEST PROCEDURES, APPROPRIATE SAFETY PRECAUTION SHOULD BE TAKEN. MACHINED EDGES ON PARTS MAY BE VERY SHARP.

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CONFIGURATOR PRINT 4DC4A38318 07/08/21 THECONFIG.COM/4DC4A38318	TITLE: SIMPLICITY PLAIN BEARING						
	PART NO.: FL08						REV.: CA
TOLERANCES UNLESS OTHERWISE SPECIFIED: INCH .X ±.030, .XX ±.010, .XXX ±.005; MM X ±.75, .X ±.25, .XX ±.13; ANGLES ±1°	MATERIAL	3RD ANGLE PROJ.	SIZE: B	SCALE: 1:1	SHEET: 7 OF 10		

MAX SURFACE FINISH 125 Ra
BREAK ALL CORNERS

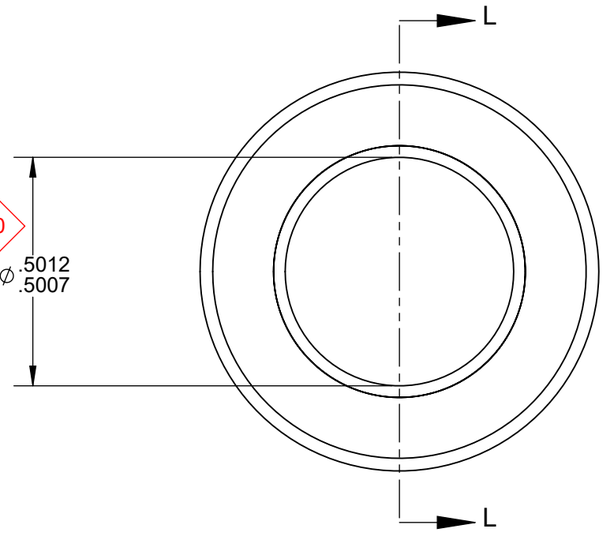
OP #: SEE ROUTING

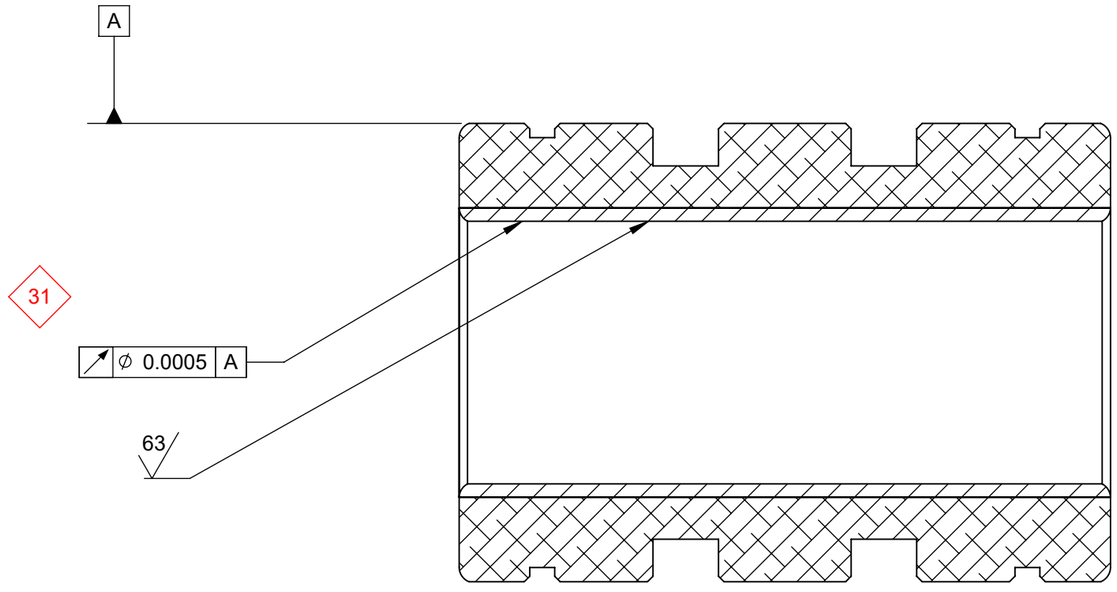
OP: FINISH GRIND ID

FINISH ID PLUG GAGE: INCH-08-FIN

PLUG GAGE GO SIZE: 0.5007

PLUG GAGE NOGO SIZE: 0.5012





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TOLERANCES UNLESS OTHERWISE SPECIFIED

INCH		MM		ANGLES ±1°
.X	±.030	X	±.75	MAX SURFACE FINISH 125 Ra
.XX	±.010	.X	±.25	BREAK ALL CORNERS
.XXX	±.005	.XX	±.13	

TITLE: SIMPLICITY PLAIN BEARING

PART NO.: FL08

REV.: CA

MATERIAL

3RD ANGLE PROJ.

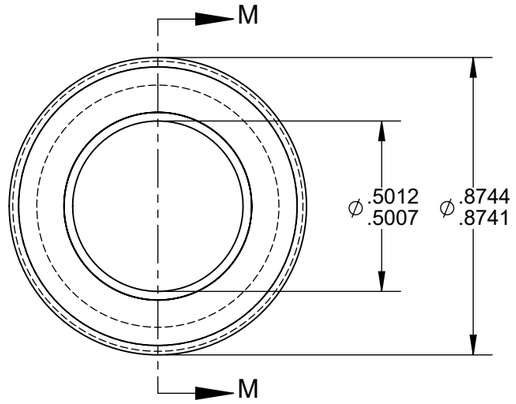
SIZE: B

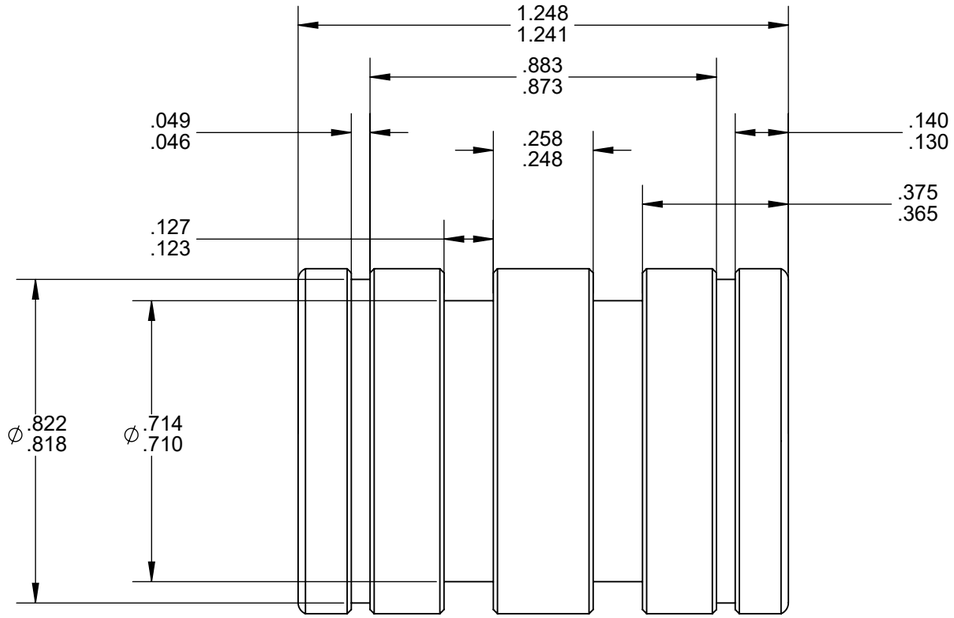
SCALE: 1:1

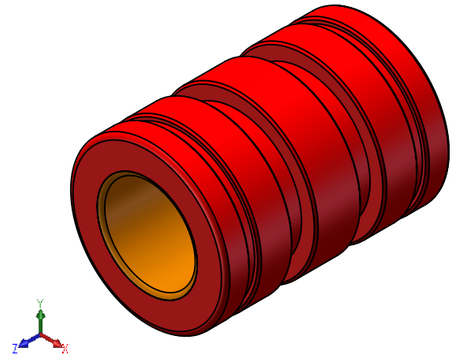
SHEET: 8 OF 10

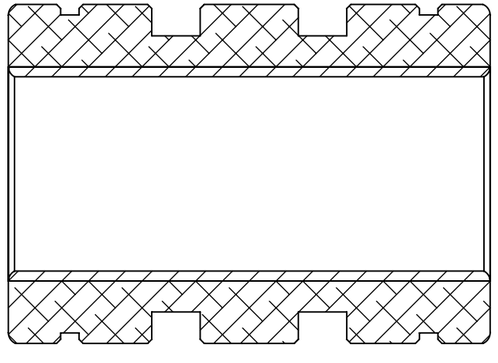
OP #: SEE ROUTING

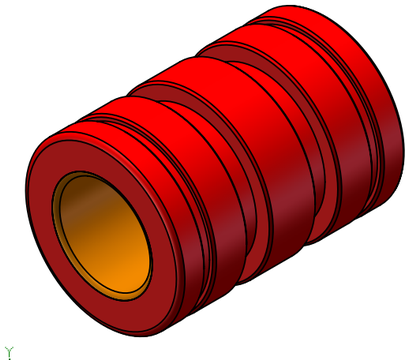
OP: FINISH DIM'S (MFG)











FINISH ID PLUG GAGE: INCH-08-FIN

PLUG GAGE GO SIZE: 0.5007

PLUG GAGE NOGO SIZE: 0.5012

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TOLERANCES UNLESS OTHERWISE SPECIFIED

INCH		MM		ANGLES ±1°
.X	±.030	X	±.75	MAX SURFACE FINISH 125 Rq
.XX	±.010	.X	±.25	
.XXX	±.005	.XX	±.13	BREAK ALL CORNERS

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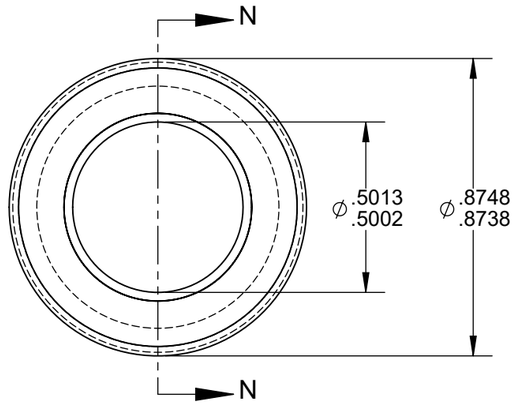
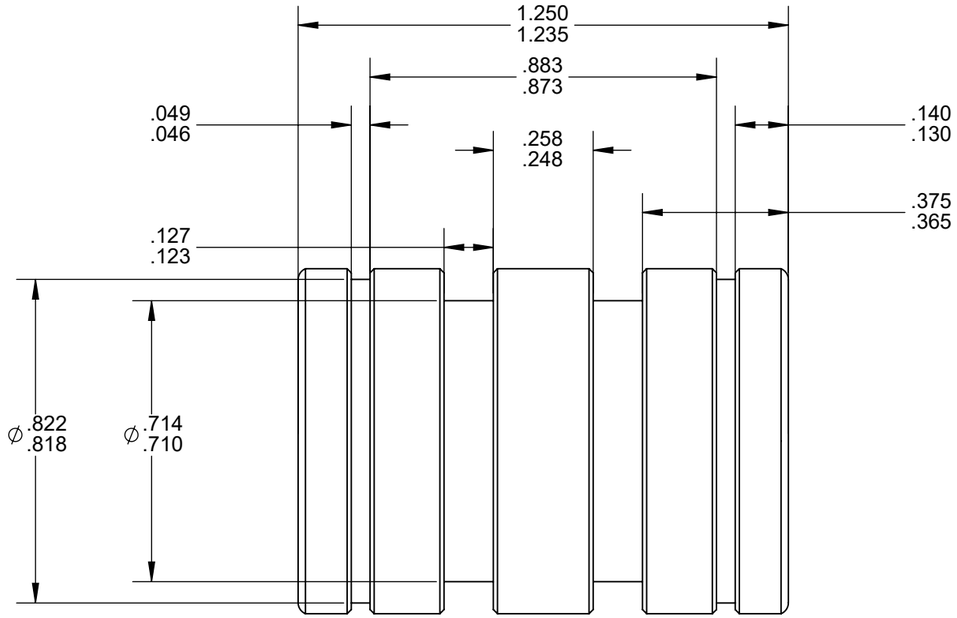
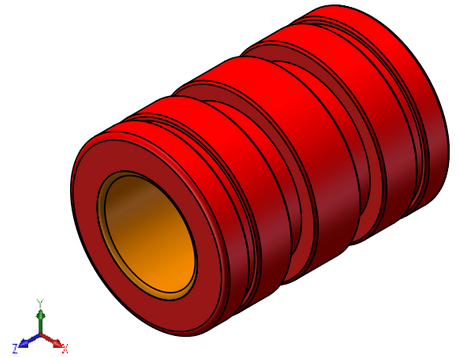
TITLE				
SIMPLICITY PLAIN BEARING				
PART NO. FL08				REV. CA
MATERIAL	3RD ANGLE PROJ.	SIZE B	SCALE 1:1	SHEET 9 OF 10

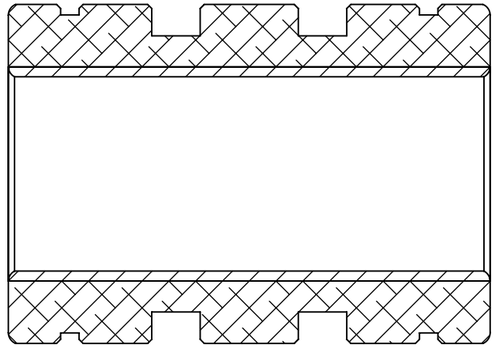
OP #: SEE ROUTING

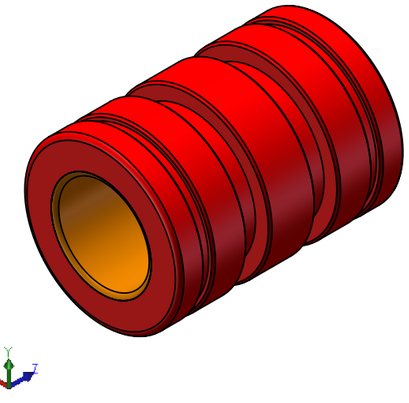
OP: FINISH DIM'S (MFG)











FINISH ID PLUG GAGE: FL-08-CAT

PLUG GAGE GO SIZE: 0.5002

PLUG GAGE NOGO SIZE: 0.5013

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TOLERANCES
UNLESS OTHERWISE SPECIFIED

INCH		MM		ANGLES ±1°
.X	±.030	X	±.75	MAX SURFACE FINISH 125 Rq
.XX	±.010	.X	±.25	
.XXX	±.005	.XX	±.13	BREAK ALL CORNERS

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TITLE: SIMPLICITY PLAIN BEARING

PART NO.: FL08

REV.: CA

MATERIAL

3RD ANGLE PROJ.

SIZE: B

SCALE: 1:1

SHEET: 10 OF 10

INSPECTION SHEET

PART NUMBER	FL08			MATL		COMMENT CODES	A=CHANGE TOOL	F=WRONG PAPERWORK
PART DESCRIPTION	SIMPLICITY PLAIN BEARING			MATL DESC			B=WORK HOLDER PROB.	G=GAGE PROBLEM
OPERATION	TURN BLANK			JOB NUMBER			C=CHG SPEED	H=PROGRAM PROBLEM
DRAW REV-BY-DATE	CA	CFG	07/08/21	JOB DATE			D=CHG. FEED	I=MAT'L PROB.
INSP REV-BY-DATE	CA	CFG	07/08/21	JOB QTY			E=MACH. PROBLEM	J=OTHER

OPERATOR (clock number)	DATE/TIME	COMMENTS	ITEM	1	2	3	4	5	6	7
			DIMENSION (NOMINAL)	0.888	0.552	EQUAL TO ENDS W/N 0.003	0.145	0.878	0.380	0.253
			DIMENSION (MODIFIED)			EQUAL TO ENDS W/N 0.003				
			+ TOL	0.001	0.001		0.005	0.005	0.005	0.005
			- TOL	-0.001	-0.001		-0.005	-0.005	-0.005	-0.005
			UPPER LIMIT	0.889	0.553		0.150	0.883	0.385	0.258
			LOWER LIMIT	0.887	0.551		0.140	0.873	0.375	0.248
			INSPECTION METHOD	Micrometer	Go and NoGo Plug Gage	Calipers	Calipers	Calipers	Calipers	Calipers
			FREQ. INSP.							
			MEASUREMENT	Reading	Pass/Fail	Pass/Fail	Reading	Reading	Reading	Reading
			SAMPLE 1							
			SAMPLE 2							
			SAMPLE 3							
			SAMPLE 4							
			SAMPLE 5							
			SAMPLE 6							
			SAMPLE 7							
			SAMPLE 8							
			SAMPLE 9							
			SAMPLE 10							
			NUMBER OF PARTS RUN							

INSPECTION SHEET

PART NUMBER	FL08		MATL		COMMENT CODES	A=CHANGE TOOL	F=WRONG PAPERWORK
PART DESCRIPTION	SIMPLICITY PLAIN BEARING		MATL DESC			B=WORK HOLDER PROB.	G=GAGE PROBLEM
OPERATION	TURN BLANK		JOB NUMBER			C=CHG SPEED	H=PROGRAM PROBLEM
DRAW REV-BY-DATE	CA	CFG 07/08/21	JOB DATE			D=CHG. FEED	I=MAT'L PROB.
INSP REV-BY-DATE	CA	CFG 07/08/21	JOB QTY			E=MACH. PROBLEM	J=OTHER

OPERATOR (clock number)	DATE/TIME	COMMENTS	ITEM	8	9	10	11	12	13	14
			DIMENSION (NOMINAL)	0.010	⌖Ø0.002A	NO BURRS ALLOWED ON ID	0.048	0.125	0.015	0.018
			DIMENSION (MODIFIED)							
			+ TOL	0.001			0.002	0.002	0.001	0.003
			- TOL	-0.001			-0.002	-0.002	-0.001	-0.003
			UPPER LIMIT	0.011			0.049	0.127	0.016	0.020
			LOWER LIMIT	0.009			0.046	0.123	0.014	0.015
			INSPECTION METHOD	Radius Gage	Concentricity Gage	Visual	Go NoGo	Go NoGo	Comparator	Comparator
			FREQ. INSP.							
			MEASUREMENT	Reading	Reading	Pass/Fail	Pass/Fail	Pass/Fail	Reading	Reading
			SAMPLE 1							
			SAMPLE 2							
			SAMPLE 3							
			SAMPLE 4							
			SAMPLE 5							
			SAMPLE 6							
			SAMPLE 7							
			SAMPLE 8							
			SAMPLE 9							
			SAMPLE 10							
			NUMBER OF PARTS RUN							

INSPECTION SHEET

PART NUMBER	FL08			MATL		COMMENT CODES	A=CHANGE TOOL	F=WRONG PAPERWORK
PART DESCRIPTION	SIMPLICITY PLAIN BEARING			MATL DESC			B=WORK HOLDER PROB.	G=GAGE PROBLEM
OPERATION	TURN BLANK			JOB NUMBER			C=CHG SPEED	H=PROGRAM PROBLEM
DRAW REV-BY-DATE	CA	CFG	07/08/21	JOB DATE			D=CHG. FEED	I=MAT'L PROB.
INSP REV-BY-DATE	CA	CFG	07/08/21	JOB QTY			E=MACH. PROBLEM	J=OTHER

OPERATOR (clock number)	DATE/TIME	COMMENTS	ITEM	15	16	17	18			
			DIMENSION (NOMINAL)	0.018	0.820	0.712	1.263			
			DIMENSION (MODIFIED)							
			+ TOL	0.003	0.002	0.002	0.002			
			- TOL	-0.003	-0.002	-0.002	-0.002			
			UPPER LIMIT	0.020	0.822	0.714	1.265			
			LOWER LIMIT	0.015	0.818	0.710	1.260			
			INSPECTION METHOD	Comparator	Blade Mic	Blade Mic	Calipers			
			FREQ. INSP.							
			MEASUREMENT	Reading	Reading	Reading	Reading			
			SAMPLE 1							
			SAMPLE 2							
			SAMPLE 3							
			SAMPLE 4							
			SAMPLE 5							
			SAMPLE 6							
			SAMPLE 7							
			SAMPLE 8							
			SAMPLE 9							
			SAMPLE 10							
			NUMBER OF PARTS RUN							

INSPECTION SHEET

PART NUMBER	FL08			**MATL**		COMMENT CODES	A=CHANGE TOOL	F=WRONG PAPERWORK
PART DESCRIPTION	SIMPLICITY PLAIN BEARING			**MATL DESC**			B=WORK HOLDER PROB.	G=GAGE PROBLEM
OPERATION	FINISH FACE			**JOB NUMBER**			C=CHG SPEED	H=PROGRAM PROBLEM
DRAW REV-BY-DATE	CA	CFG	07/08/21	**JOB DATE**			D=CHG. FEED	I=MAT'L PROB.
INSP REV-BY-DATE	CA	CFG	07/08/21	**JOB QTY**			E=MACH. PROBLEM	J=OTHER

OPERATOR (clock number)	DATE/TIME	COMMENTS	ITEM	19	20	21	22	23	24	25
			DIMENSION (NOMINAL)	GROOVES MUST BE LOCATED EQUAL ON BOTH ENDS TO W/N 0.010	0.030	0.030	1.243	0.100	0.879	0.494
			DIMENSION (MODIFIED)	EQUAL TO ENDS W/N 0.010						
			+ TOL		0.005	0.005	0.005		0.001	0.002
			- TOL		-0.005	-0.005	-0.002		-0.001	-0.002
			UPPER LIMIT		0.035	0.035	1.248		0.880	0.496
			LOWER LIMIT		0.025	0.025	1.241		0.878	0.492
			INSPECTION METHOD	Visual	Visual	Visual	Calipers	Calipers	Micrometer	Tri-Mic
			FREQ. INSP.							
			MEASUREMENT	Pass/Fail	Reading	Reading	Reading	Reading	Reading	Reading
			SAMPLE 1							
			SAMPLE 2							
			SAMPLE 3							
			SAMPLE 4							
			SAMPLE 5							
			SAMPLE 6							
			SAMPLE 7							
			SAMPLE 8							
			SAMPLE 9							
			SAMPLE 10							
			NUMBER OF PARTS RUN							

INSPECTION SHEET

PART NUMBER	FL08		**MATL**		**COMMENT CODES**	A=CHANGE TOOL	F=WRONG PAPERWORK
PART DESCRIPTION	SIMPLICITY PLAIN BEARING		**MATL DESC**			B=WORK HOLDER PROB.	G=GAGE PROBLEM
OPERATION	FINISH FACE		**JOB NUMBER**			C=CHG SPEED	H=PROGRAM PROBLEM
DRAW REV-BY-DATE	CA	CFG 07/08/21	**JOB DATE**			D=CHG. FEED	I=MAT'L PROB.
INSP REV-BY-DATE	CA	CFG 07/08/21	**JOB QTY**			E=MACH. PROBLEM	J=OTHER

OPERATOR (clock number)	DATE/TIME	COMMENTS							
			ITEM	**26**					
			DIMENSION (NOMINAL)	0.489					
			DIMENSION (MODIFIED)						
			+ TOL	0.001					
			- TOL	-0.001					
			UPPER LIMIT	0.490					
			LOWER LIMIT	0.488					
			INSPECTION METHOD	Go and NoGo Plug Gage					
			FREQ. INSP.						
			MEASUREMENT	Reading					
			SAMPLE 1						
			SAMPLE 2						
			SAMPLE 3						
			SAMPLE 4						
			SAMPLE 5						
			SAMPLE 6						
			SAMPLE 7						
			SAMPLE 8						
			SAMPLE 9						
			SAMPLE 10						
			NUMBER OF PARTS RUN						

INSPECTION SHEET

PART NUMBER	FL08		**MATL**		**COMMENT CODES**	A=CHANGE TOOL	F=WRONG PAPERWORK
PART DESCRIPTION	SIMPLICITY PLAIN BEARING		**MATL DESC**			B=WORK HOLDER PROB.	G=GAGE PROBLEM
OPERATION	FINISH GRIND OD		**JOB NUMBER**			C=CHG SPEED	H=PROGRAM PROBLEM
DRAW REV-BY-DATE	CA	CFG 07/08/21	**JOB DATE**			D=CHG. FEED	I=MAT'L PROB.
INSP REV-BY-DATE	CA	CFG 07/08/21	**JOB QTY**			E=MACH. PROBLEM	J=OTHER

OPERATOR (clock number)	DATE/TIME	COMMENTS	ITEM	27	28	29				
			DIMENSION (NOMINAL)	0.8743	⌖ 0.0001	◎ 0.0001				
			DIMENSION (MODIFIED)							
			+ TOL	0.0002						
			- TOL	-0.0002						
			UPPER LIMIT	0.8744						
			LOWER LIMIT	0.8741						
			INSPECTION METHOD	Micrometer	Vee-Block/Indicator	Vee-Block/Indicator				
			FREQ. INSP.							
			MEASUREMENT	Reading	Reading	Reading				
			SAMPLE 1							
			SAMPLE 2							
			SAMPLE 3							
			SAMPLE 4							
			SAMPLE 5							
			SAMPLE 6							
			SAMPLE 7							
			SAMPLE 8							
			SAMPLE 9							
			SAMPLE 10							
			NUMBER OF PARTS RUN							

INSPECTION SHEET

PART NUMBER	FL08		**MATL**		**COMMENT CODES**	A=CHANGE TOOL	F=WRONG PAPERWORK
PART DESCRIPTION	SIMPLICITY PLAIN BEARING		**MATL DESC**			B=WORK HOLDER PROB.	G=GAGE PROBLEM
OPERATION	FINISH GRIND ID		**JOB NUMBER**			C=CHG SPEED	H=PROGRAM PROBLEM
DRAW REV-BY-DATE	CA	CFG 07/08/21	**JOB DATE**			D=CHG. FEED	I=MAT'L PROB.
INSP REV-BY-DATE	CA	CFG 07/08/21	**JOB QTY**			E=MACH. PROBLEM	J=OTHER

OPERATOR (clock number)	DATE/TIME	COMMENTS	ITEM	30	31					
			DIMENSION (NOMINAL)	0.5010	⌭Ø0.0005A					
			DIMENSION (MODIFIED)							
			+ TOL	0.0003						
			- TOL	-0.0003						
			UPPER LIMIT	0.5012						
			LOWER LIMIT	0.5007						
			INSPECTION METHOD	Go and NoGo Plug Gage	Concentricity Gage					
			FREQ. INSP.							
			MEASUREMENT	Pass/Fail	Pass/Fail					
			SAMPLE 1							
			SAMPLE 2							
			SAMPLE 3							
			SAMPLE 4							
			SAMPLE 5							
			SAMPLE 6							
			SAMPLE 7							
			SAMPLE 8							
			SAMPLE 9							
			SAMPLE 10							
			NUMBER OF PARTS RUN							