

NOTE

1. THIS DIAMETER MAY BE PLATED TO $\frac{.03}{.001}$ MAX.
MASK 2 diameters

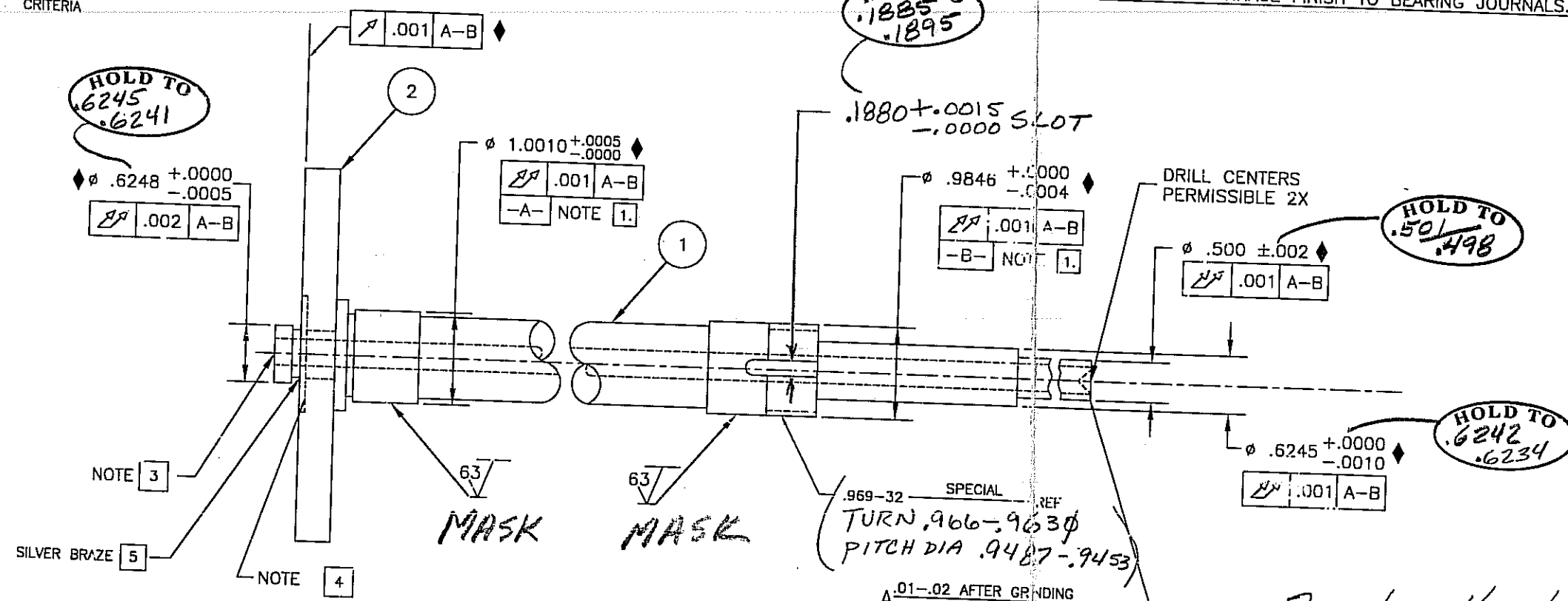
2. PLATING TO BE ELECTROLESS NICKEL - PHOSPHORUS
0.001-.0003 (0.3000-0.9076) BAKE 250°F for 1 hr. .0001-.00015 thick per side.
DLE 11/21/01

3. HOLE TO BE PLATED THROUGH

4. THIS SURFACE TO BE FREE OF BRAZE.

5. THIS MANUFACTURING PROCESS MAY INCLUDE HAZARDOUS OPERATIONS AND REQUIRE SPECIAL HEALTH AND SAFETY PRECAUTIONS.

6. ♦'S INDICATE INSPECTION CRITERIA



REV	REVISION DESCRIPTION	BY	DATE	ECO #
C	CONVERT TO CAD, ADD DIAMONDS	VLF	09/19/91	57109
D	REMOVED DATUM DU, CHANGED DATUM DUI TO DU, .0006 TRUE POSITION WAS .0003, ADDED CENTERS PERMISSIBLE	VLF	04/24/92	59355
E	ALLOWED NOTE 1 DIAMETERS TO BE PLATED. ADDED SURFACE FINISH TO NOTE 1. CORRECTED C&D REV HISTORY	DT	08/10/97	BCT 002748
F	REMOVED DIAMOND FROM NOTE 1	DT	10/04/97	BCT 003093
G	RUNOUT TOLERANCES WERE TRUE POSITION CALLOUTS, ADDED GRINDING SPECIFICATION TO NOTE 1, REMOVED METRIC DIMS, ADDED BOM.	TB	05/13/98	BCT 004254
H	DATUM -A- WAS ASSOCIATED WITH Ø .500 DIM, ADDED GD&T TOL AND ♦'S TO .500 AND .6245 Ø ADDED SURFACE FINISH TO BEARING JOURNALS.	TJB	7/22/98	BCT 004571

Break all sharp corners

Ref. mat 12214

DATED PRINT 11/21/01

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AUTOCAD DWG
ORIG DISK: BCT-MDC
FILE: 647615H.DWG

ALLOW
FOR PLATING
.00015 PER
FACE

2	1	EA	772647-617	GEAR, CENTRIFUGE DRIVE
1	1	EA	772647-616	SHAFT, CENTRIFUGE DRIVE
ITEM	QTY	U/M	PART NUMBER	DESCRIPTION
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TOLERANCES AND SYMBOLS PER AMS Y14.5M-1982 DIMENSIONS SPECIFIED ARE AFTER ADDITIVE FINISH.		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		
X±N/A		MATERIAL		
XX±N/A		N/A		
XXX±N/A		ORIGINATOR		
XXXX±N/A		SCANNED		
SIZE		DATE		
SCALE		XX/XX/XX		
DO NOT SCALE DWG		DATE		
THIRD ANGLE PROJECTION		XX/XX/XX		
C		SCANNED		
1:1		DATE		
PART NO.		772647-615		
REV		H		
SHEET		1/2		

COBE BCT

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SHAFT ASSY
CENTRIFUGE DRIVE