ALLOWABLE VARIATION OF PLUS OR MINUS .010 ON ALL FRACTIONAL FINISHED DIMENSIONS UNLESS OTHERWISE SPECIFIED

210	20	1	1
410	21	2	1
210A	7	10	1
410A	23	6	1

5-BOSSES EQUALLY SPACED

2-BOSSES DIRECTLY OPPOSITE

2-BOSSES DIRECTLY OPPOSITE

CAST 4-SLOTS AS SHOWN

VIEW SHOWING KNOCKOUT SLOTS FOR OUTER AND INNER BEARINGS DOUBLE SIZE

CORE AT THIS DIAMETER MUST RUN TRUE WITH FLANGE TO FACILITATE MACHINING

SECTION A-A CASTING

5/16 DIA. DRILL
3/8-16 N.C.-3 TAP
1/4 DEEP R.D. 1941-3976
6 HOLES EQUALLY SPACED
C'BORE .378-.380 5/16 DEEP

.598
.602 DIA. REAM 5-HOLES EQUALLY SPACED

THESE SLOTS MUST BE FREE FROM FINS AFTER HUB IS FINISHED

THIS DIA. MUST BE CONCENTRIC WITH BOLT CIRCLE WITHIN .004 TOTAL INDICATOR READING

2.906 - 2.908 DIA. TO BE HELD FOR THIS DISTANCE

FACE OF FLANGE MUST BE TRUE WITH BEARING CUP BORES WITHIN .008 TOTAL INDICATOR READING

BREAK CORNER

SECTION A-A FINISHED

VOTE - DP OIL SPRAY WITH M-1713-A BLACK ENAMEL

DEPARTMENTAL COMMUNICATION

To Messrs: R. Brumyle, Purchasing
A. Prentice, Quality Inspection
W. Jones, Dept. 85 - Foundry
H. Hoffslinger, Machining
J. Speegle, Foundry Stock
Ref: Hub & Sub Drums GM-1106 & GM-1125

Engineering

It will be necessary to rout these parts with M-1713-A, Black Enamel.

In order to prevent Hub and Drums from rusting in storage and transit,

Every such lot should be spot checked after coating from the coating operation. The parts must be blown off with compressed air and dipped or sprayed with the M-1713-A.

If Hoffslinger, please change drawings of these parts to cover this application.

Chief Engineer & Mechanical Dept.

RECD. 9-24-42

GRM06