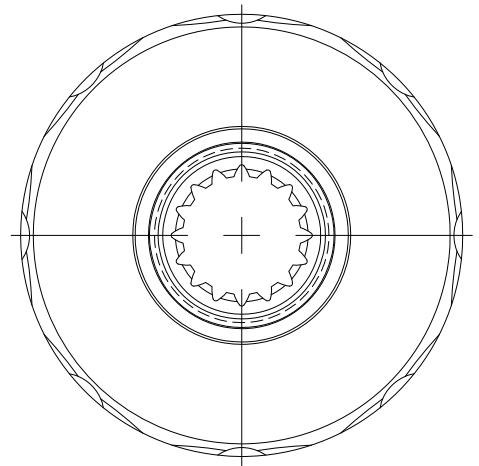
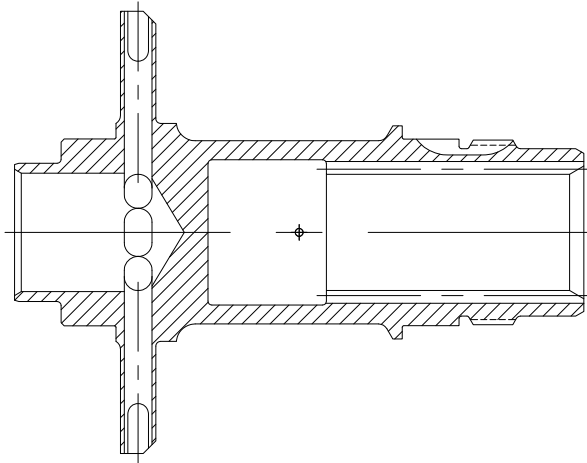


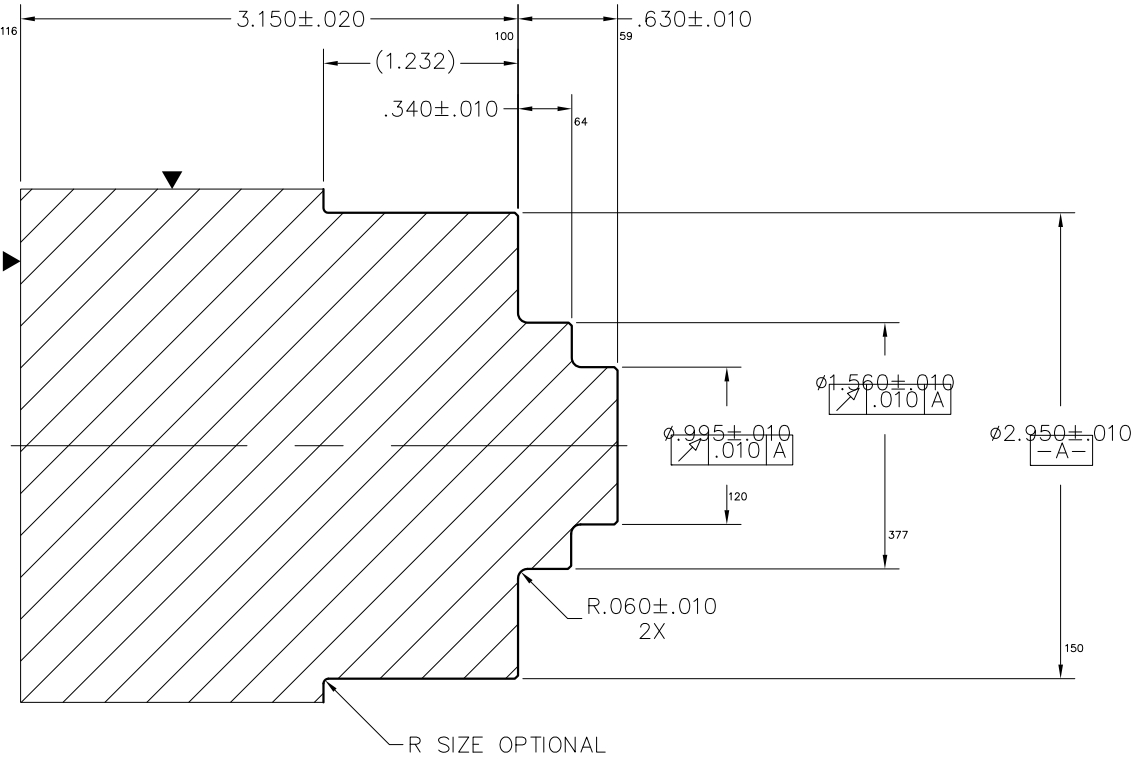


OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK

G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		-
	WORK CENTER		OPER REV
	REFERENCE		-
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1

- DRAWING NOTES:**
- 1. DRAWING SCALE: 1:1
 - 2. MATL: 9310 IAW AMS 6265
 - 3. HRC: 20 MAX
 - 4. SURFACE FINISH: 250u
 - 5. BREAK ALL SHARP EDGES: .030 MAX

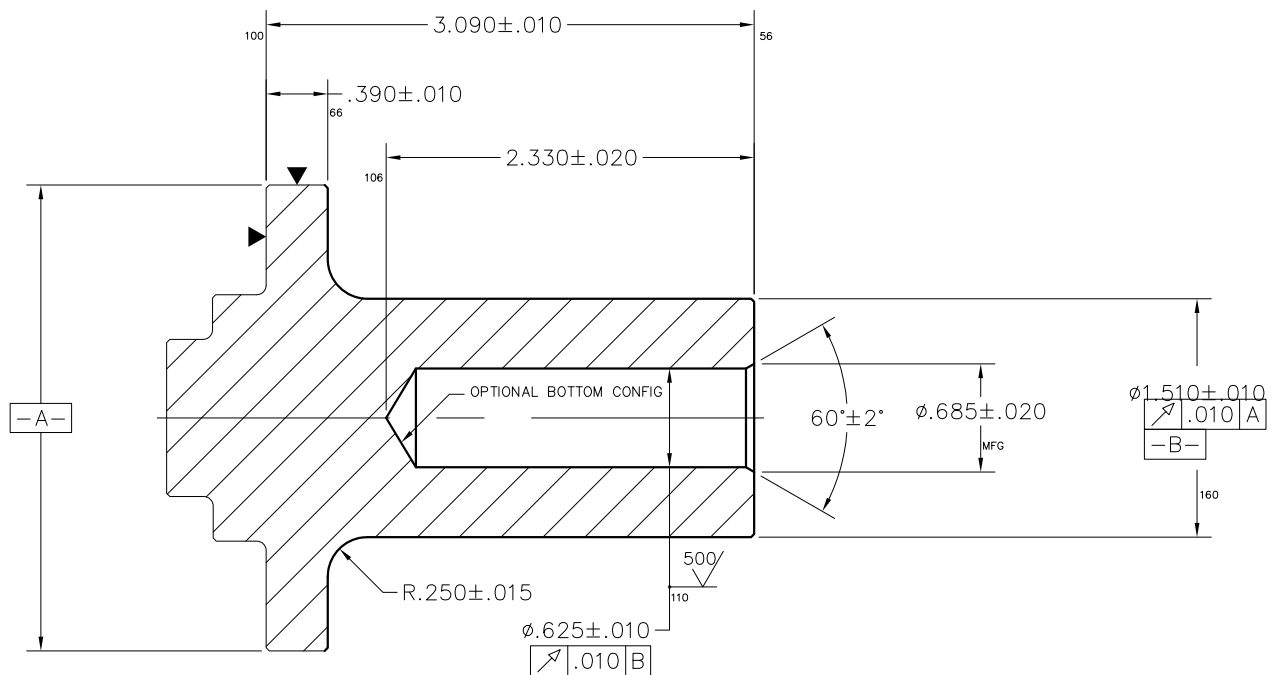
OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK



G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		020
	WORK CENTER		OPER REV
	LATHE		-
DWN	CHK		SHEET
	SK 12-31-09 SJK 01-15-10		1 OF 1

1. DRAWING SCALE: 1:1
2. MATL: 9310 IAW AMS 6265
3. HRC: 20 MAX
4. SURFACE FINISH: 250u
5. BREAK ALL SHARP EDGES: .030 MAX

OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK



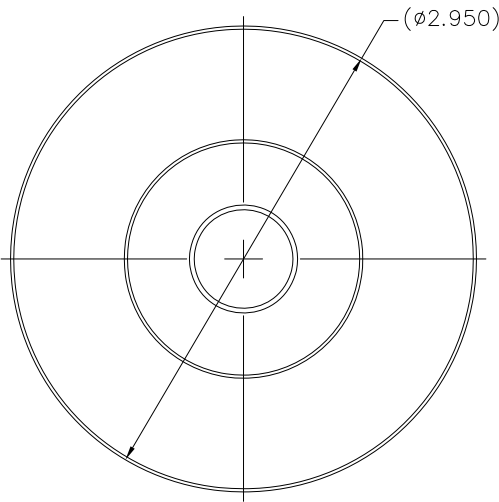
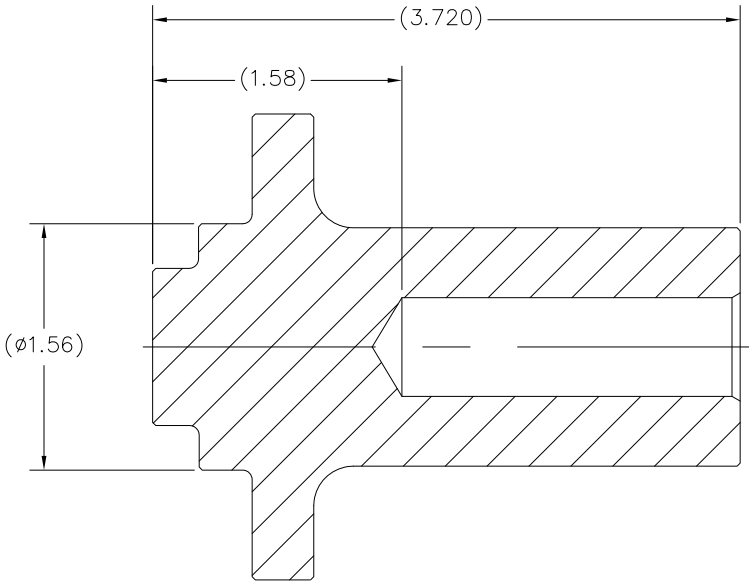
G&N RUBICON
High Performance Gear Solutions
1550 E. McFadden
Santa Ana, CA. 92705
714.835.0326
www.gnrubicon.com

PART NUMBER		OPER NO
70220027-001		030
WORK CENTER		OPER REV
LATHE		-
DWN	CHK	SHEET
SK 12-31-09	SJK 01-15-10	1 OF 1

DRAWING NOTES:

- 1. DRAWING SCALE: 1:1
- 2. MATL: 9310 IAW AMS 6265
- 3. HEAT TREAT IAW:
 - a. PROCESS SPECIFICATION: AMS 2759
 - b. NORMALIZE, HARDEN AND TEMPER
 - c. HARDNESS: HRC 30-34
- 4. .030 MIN MATERIAL TO BE REMOVED ALL OVER
- 5. CERTIFICATION REQUIRED

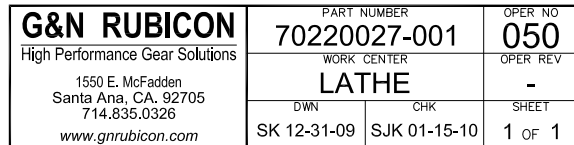
OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK



G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		040
	WORK CENTER		OPER REV
	HEAT TREAT		-
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1

1. DRAWING SCALE: 1:1
2. MATL: 9310 IAW AMS 6265
3. HRC: 30-34
4. SURFACE FINISH: 125u
5. BREAK ALL SHARP EDGES: .010±.005

DETAIL A



1. DRAWING SCALE: 1:1
2. MATL: 9310 IAW AMS 6265
3. HRC: 30-34
4. SURFACE FINISH: 125u
5. BREAK ALL SHARP EDGES: .010±.005
6.

CENTERS	-A-
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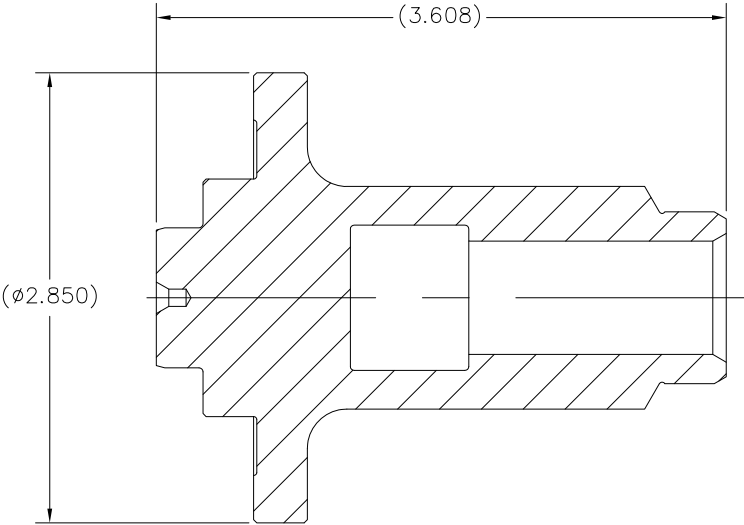
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G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER 70220027-001		OPER NO 060
	WORK CENTER LATHE		OPER REV -
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1

DRAWING NOTES:

- 1. DRAWING SCALE: 1:1
- 2. MATL: 9310 IAW AMS 6265
- 3. HRC: 30-34
- 4. COPPER PLATE (FOR HEAT TREAT STOP-OFF): ALL OVER
 - a. PROCESS SPECIFICATION: AMS 2418
 - b. THICKNESS PER SURFACE: .001-.002
 - i. INCOMPLETE COVERAGE IN BORE AREA PERMITTED
 - c. PRE-PLATE / POST PLATE BAKE: NOT REQUIRED
- 5. CERTIFICATION REQUIRED

OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK



G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		070
	WORK CENTER		OPER REV
	COPPER PLT		-
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1

1. DRAWING SCALE: 1:1
2. MATL: 9310 IAW AMS 6265
3. HRC: 30-34
4. SURFACE FINISH: 125u
5. MACHINE COPPER PLATE TO SPECIFIED DIMENSIONS
 - a. PROTECT ALL OTHER SURFACES FROM DAMAGE

Technical drawing of a mechanical part showing a cross-section with various dimensions and tolerances.

Dimensions and Tolerances:

- Top horizontal dimension: $.3245 \pm .0015$
- Top vertical dimension: $3 + 1.5C_u$
- Internal vertical dimension: $.006 \text{ MAX}$
- Internal vertical dimension: $.005 \text{ MAX}$
- Internal vertical dimension: MFG
- Horizontal dimension: $\phi .8830 \pm .0005$
- Horizontal dimension: $\phi 1.5000 \pm .0001$
- Horizontal dimension: $.001 \text{ A}$
- Horizontal dimension: $.0002 \text{ A}$
- Horizontal dimension: 8
- Horizontal dimension: 318
- Radius dimension: $R.015 \pm .005$
- Radius dimension: $2X$

OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK

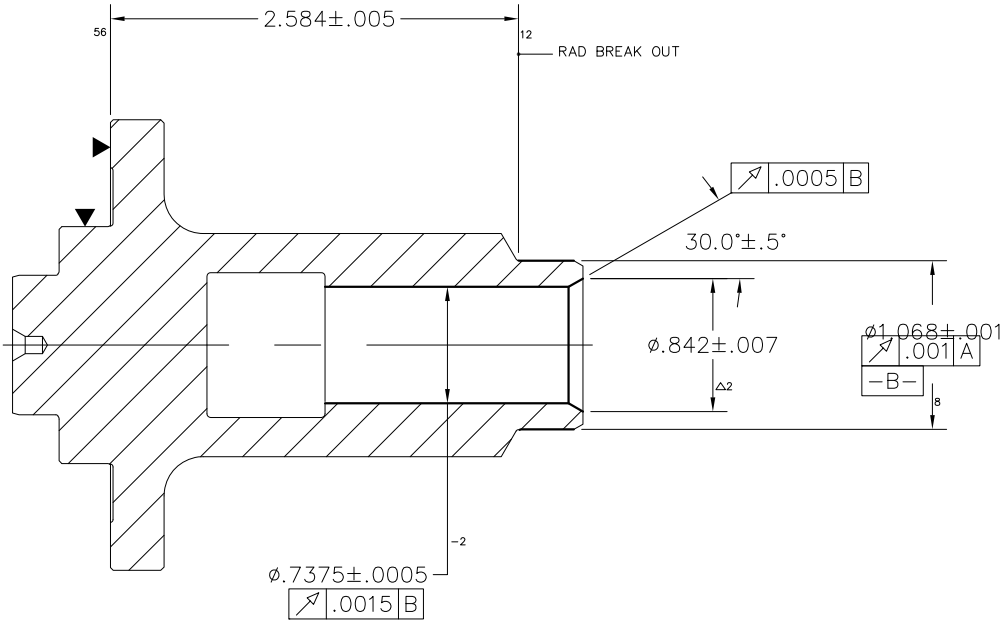
G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER 70220027-001		OPER NO 090
	WORK CENTER OD GRIND		OPER REV -
	DWN SK 12-31-09	CHK SJK 01-15-10	SHEET 1 OF 1

DRAWING NOTES:

- 1. DRAWING SCALE: 1:1
- 2. MATL: 9310 IAW AMS 6265
- 3. HRC: 30-34
- 4. SURFACE FINISH: 125u
- 5. MACHINE COPPER PLATE TO SPECIFIED DIMENSIONS
 - a. PROTECT ALL OTHER SURFACES FROM DAMAGE

6. CENTERS -A-

OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK



G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		100
	WORK CENTER		OPER REV
	LATHE		-
DWN	CHK		SHEET
	SK 12-31-09 SJK 01-15-10		1 OF 1

BASIC SPLINE DATA

NUMBER OF TEETH 16
 DIAMETRAL PITCH 20/30
 PRESSURE ANGLE 30°
 PITCH DIAMETER .8000
 BASE RADIUS .3464
 FORM DIAMETER .8730
 MINOR DIAMETER (.7375±.0005)

TOOTH TOLERANCES

MEASURING PIN DIA .072
 MEAS BTWN (2) PINS .7244±.0006 $\triangle 4 \triangle 5$
 ROOT DIAMETER .899±.004
 ROOT FILLET RADIUS .015 MIN

SPLINE ACCURACY

SPLINE STD: P6809
 FILLET ROOT-SIDE FIT

TOOTH PARALLELISM .0005 $\triangle 6$
 PROFILE FINISH 63u
 ROOT FINISH 63u
 TOTAL INDEX VAR .0013 $\triangle 6$

ENGINEERING REF

CSW - MAX .0815
 CSW - MIN .0808
 CSW - MIN EFF .0800 (PRE-HT)
 STK ON CSW - MAX -.0005
 STK ON CSW - MIN -.0008

GENERAL NOTES

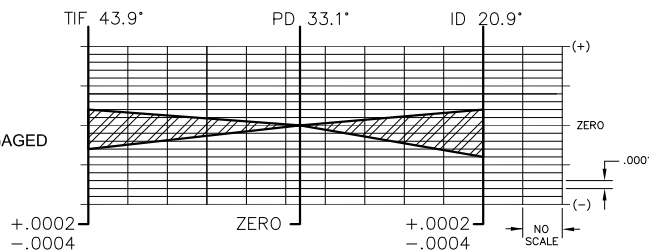
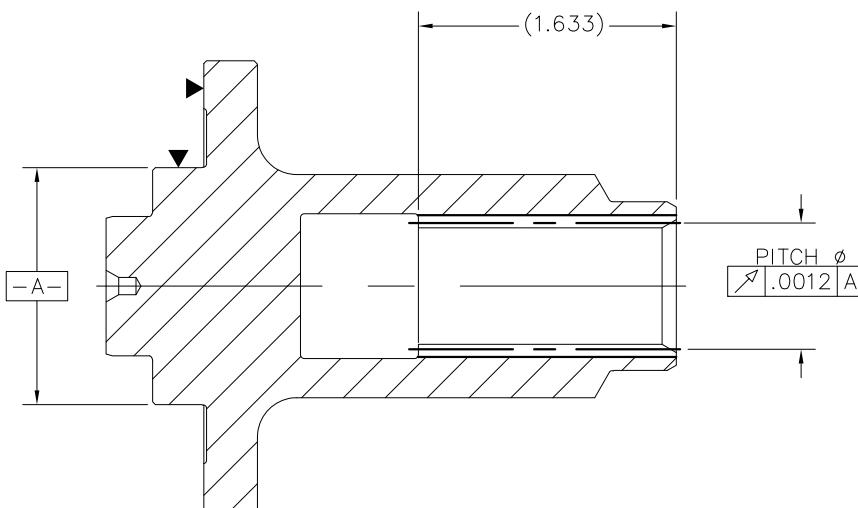
1. DRAWING SCALE: 1:1
 2. MATL: 9310 IAW AMS 6265
 3. HRC: 30-34
- $\triangle 4$ MIN MBW REF IF GAGED
 $\triangle 5$ MAINTAIN MAX MBW - DO NOT GAGE
 $\triangle 6$ ELEMENT CHECK REQUIRED - EVEN IF GAGED

TOOLING

FIXTURE: GN01789
 CUTTER: GNC00409
 GAGES: SG-0209 (PRE-HT GO)

OPERATION REVISION CHANGE HISTORY

REV	DESCRIPTION	REVISED	CHK
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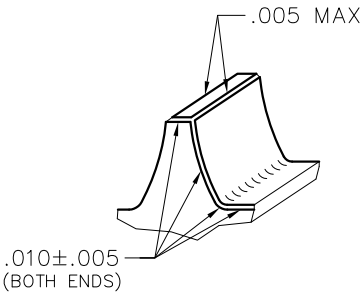
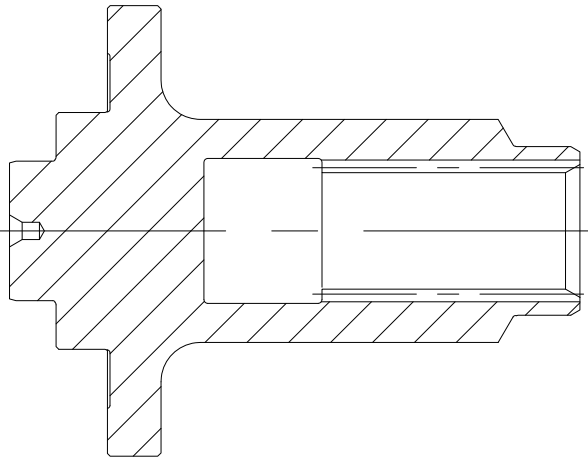
$\triangle 6$ INVOLUTE TOLERANCE

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PART NUMBER		OPER NO
70220027-001		110
WORK CENTER		OPER REV
SHAPER		-
DWN	CHK	SHEET
SK 12-31-09	SJK 01-15-10	1 OF 1

- DRAWING NOTES:**
1. DRAWING SCALE: 1:1
 2. MATL: 9310 IAW AMS 6265
 3. HRC: 30-34
 4. SURFACE FINISH: 125u
 5. BREAK SHARP EDGES: .010±.005
 6. PROTECT COPPER PLATE FROM DAMAGE

OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK



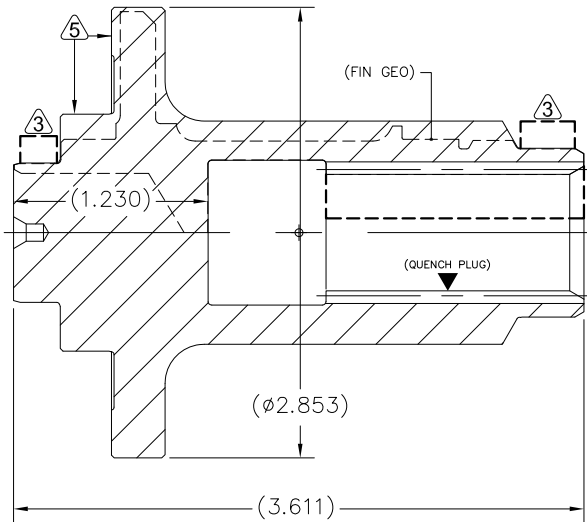
INTERNAL TOOTH

G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		130
	WORK CENTER		OPER REV
	DEBURR		-
DWN		CHK	SHEET
SK 12-31-09		SJK 01-15-10	1 OF 1

DRAWING NOTES:

- 1. DRAWING SCALE: 1:1
- 2. MATL: 9310 IAW AMS 6265
- 3 CARBURIZE AND HARDEN NOTED AREAS:
 - a. PROCESS SPECIFICATION: HT 5042 TY II
 - b. EFFECTIVE CASE DEPTH: .022-.027
 - i. INT TOOTH: .016 MIN
 - c. CASE HARDNESS AT .0055 DEPTH: HRC 60 MIN
 - ii. INT TOOTH: .001 DEPTH: HRC 58 MIN
 - d. CORE HARDNESS: 33-43
- 4. STOCK REMOVAL SCHEDULE:
 - a. INT TOOTH - ALL SURFACES: .000
 - b. BEARING SURFACES: .0045
- 5 CASE PROPERTIES DO NOT APPLY TO NOTED SURFACES
- 6. PART IS COPPER PLATE TO PROTECT ALL OTHER SURFACES
- 7. CERTIFICATION REQUIRED
- 8. TOOLING SUPPLIED: QUENCH PLUG SET GN01790

OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK

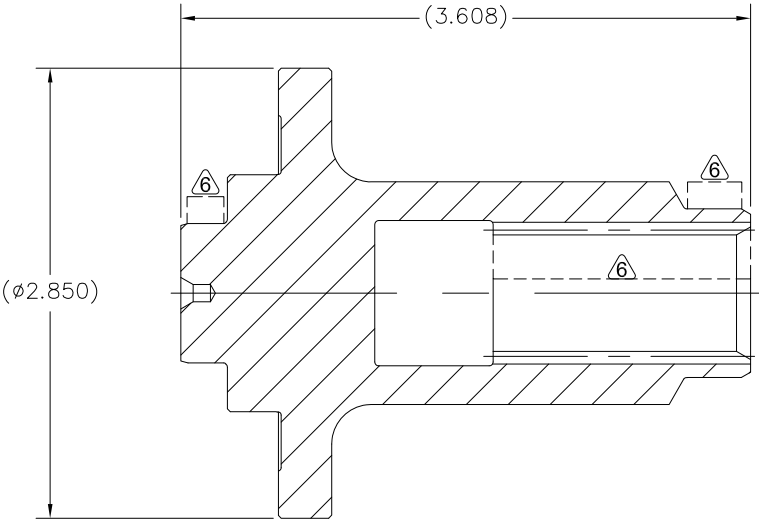


G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		140
	WORK CENTER		OPER REV
	HEAT TREAT		-
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1

DRAWING NOTES:

- 1. DRAWING SCALE: 1:1
- 2. MATL: 9310 IAW AMS 6265
- 3. HRC: 33-43 EXCEPT AS NOTED
- 4. COPPER STRIP
 - a. APPROXIMATE THICKNESS PER SURFACE: .001-.002
 - b. PROCESS TO PROTECT BASE MATERIAL FROM PITTING AND DAMAGE
- 5. CERTIFICATION REQUIRED
- ⚠ CAUTION: CARBURIZED AREA - DO NOT DAMAGE

OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK

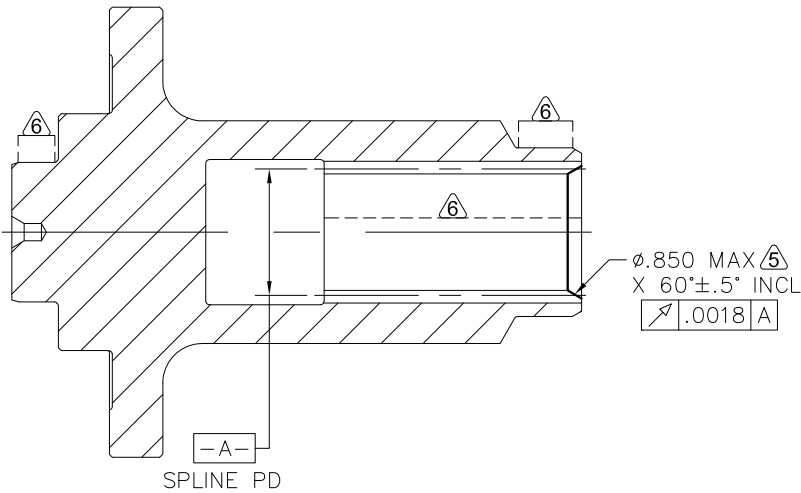


G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		150
	WORK CENTER		OPER REV
	COPPER STRIP		-
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1

DRAWING NOTES:

- 1. DRAWING SCALE: 1:1
- 2. MATL: 9310 IAW AMS 6265
- 3. HRC: 33-43 EXCEPT AS NOTED
- 4. SURFACE FINISH: 63u
- 5 INDICATE EXISTING CENTER
 - a. USE GAGE SG-0195 / SG-0196 TO CHECK PD RUNOUT
 - b. BALANCE AND MOVE CENTER IF NECESSARY
- 6 CAUTION: CARBURIZED AREA - DO NOT DAMAGE

OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK

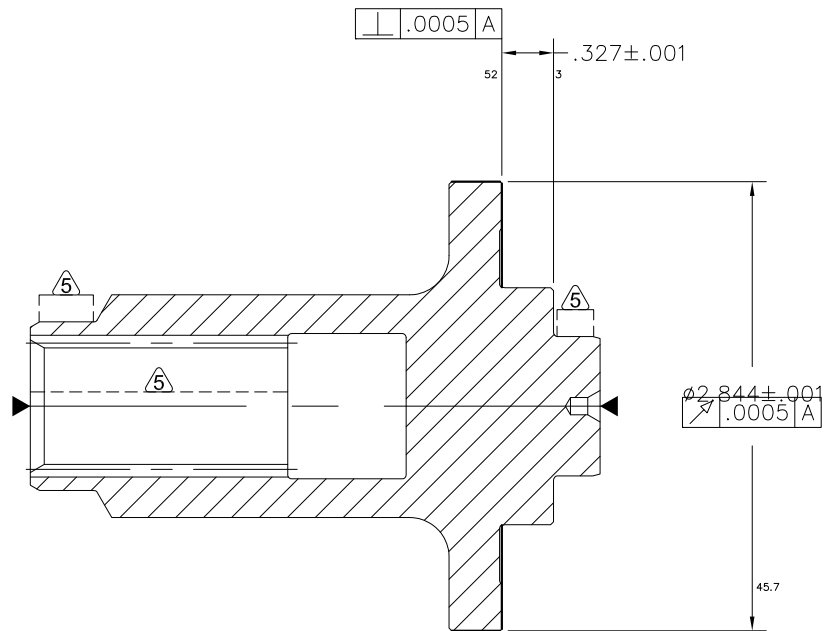


G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		180
	WORK CENTER		OPER REV
	ID GRIND		-
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1

1. DRAWING SCALE: 1:1
2. MATL: 9310 IAW AMS 6265
3. HRC: 33-43 EXCEPT AS NOTED
4. SURFACE FINISH: 125u
5. CAUTION: CARBURIZED AREA - DO NOT DAMAGE
6.

CENTERS	-A-
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OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK



G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		190
	WORK CENTER		OPER REV
	OD GRIND		-
	DWN	CHK	SHEET
SK 12-31-09	SJK 01-15-10		1 OF 1

1. DRAWING SCALE: 1:1
2. MATL: 9310 IAW AMS 6265
3. HRC: 33-43 EXCEPT AS NOTED
4. SURFACE FINISH: 125u
5. BREAK SHARP EDGES: .010±.005
6. CAUTION: CARBURIZED AREA - DO NOT DAMAGE
7.

CENTERS	-A-
---------	-----

PAINTED AREA - DO NOT DAMAGE

52

1.839 $\pm$.001

3

50

1.513 $\pm$.005

1.433 $\pm$.005

.063 $\pm$.005

.357 $\pm$.005

.090 $\pm$.005

30 $\pm$ 2°

R.010 MAX

6

6

6

30 $\pm$ 2°

R.060 $\pm$.010

R.120 $\pm$.010

R.030 $\pm$.010

7.3

20

01.400 $\pm$.005
A
.003

01.160 $\pm$.008
A
.003

01.169 $\pm$.002
A
.002

01.060 $\pm$.004

2X R.015 $\pm$.005

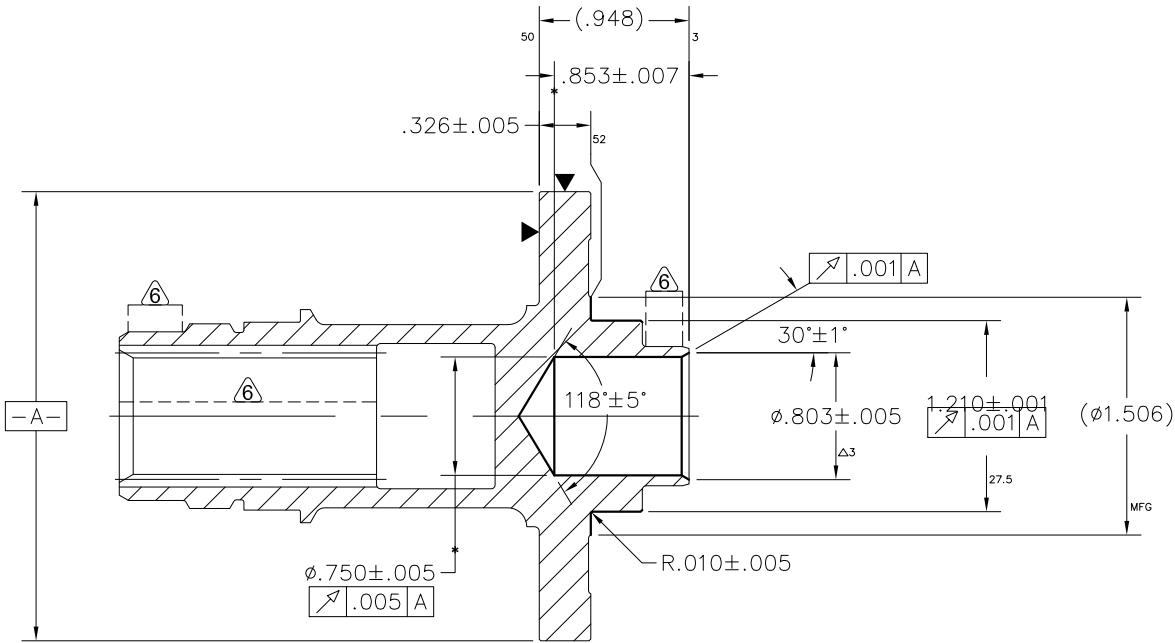
01.189 $\pm$.001
A
.002

01.350 $\pm$.008
A
.003

G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER 70220027-001		OPER NO 210
	WORK CENTER LATHE		OPER REV -
	DWN SK 12-31-09	CHK SJK 01-15-10	SHEET 1 OF 1

- DRAWING NOTES:**
- 1. DRAWING SCALE: 1:1
 - 2. MATL: 9310 IAW AMS 6265
 - 3. HRC: 33-43 EXCEPT AS NOTED
 - 4. SURFACE FINISH: 125u
 - 5. BREAK SHARP EDGES: .010±.005
 - 6 CAUTION: CARBURIZED AREA - DO NOT DAMAGE

OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK

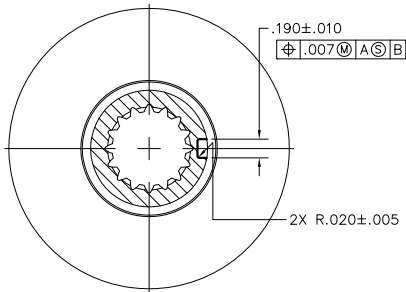


G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		220
	WORK CENTER		OPER REV
	LATHE		-
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1

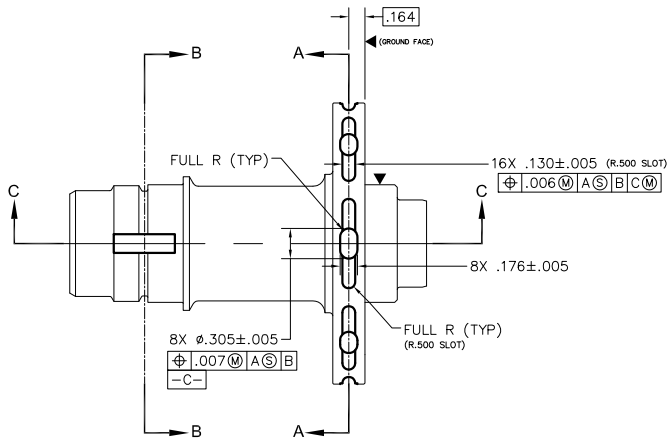
DRAWING NOTES:

1. DRAWING SCALE: 1:1
 2. MATL: 9310 IAW AMS 6265
 3. HRC: 33-43 EXCEPT AS NOTED
 4. SURFACE FINISH: 125u
 5. BREAK SHARP EDGES: .010±.005
- ⚠ CAUTION: CARBURIZED AREA - DO NOT DAMAGE

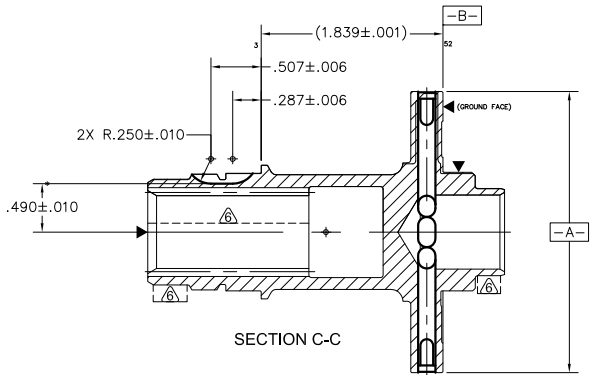
OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK



SECTION B-B



SECTION A-A

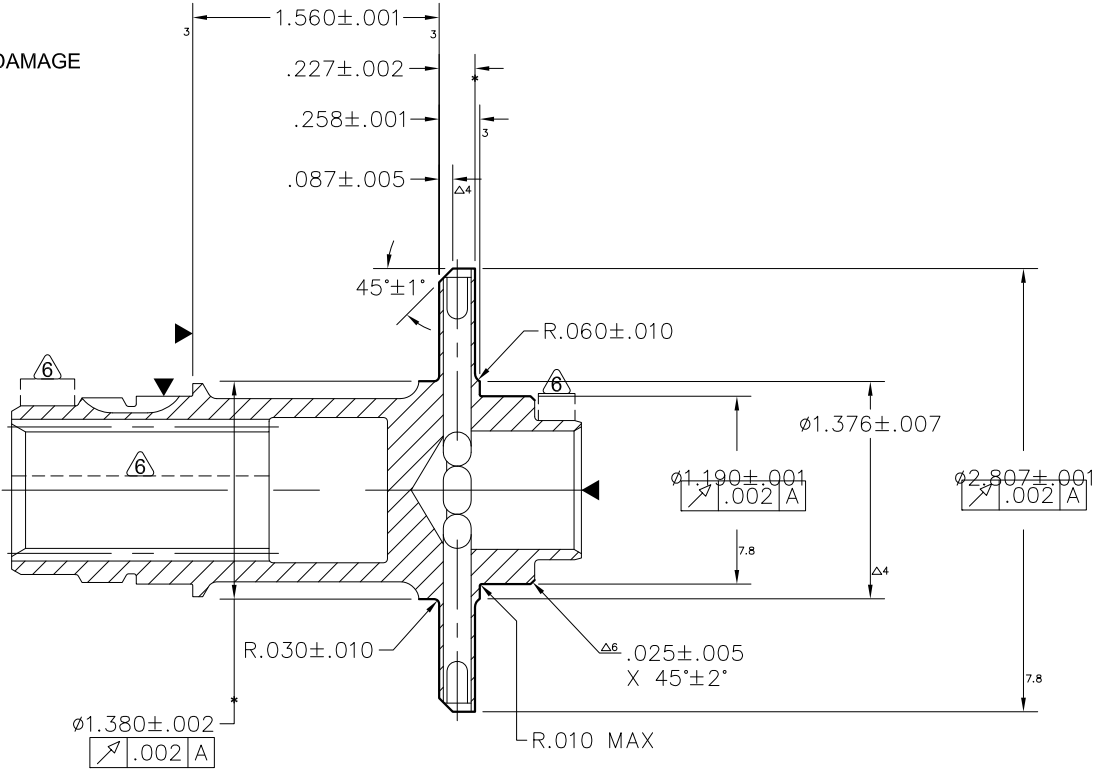


SECTION C-C

G&N RUBICON		PART NUMBER	OPER NO
High Performance Gear Solutions		70220027-001	230
1550 E. McFadden Santa Ana, CA 92705 714.835.0326 www.gnrubicon.com		WORK CENTER	OPER REV
		MILL	-
		DWN	CHK
		SK 12-31-09	SJK 01-15-10
			SHEET
			1 OF 1

DRAWING NOTES:

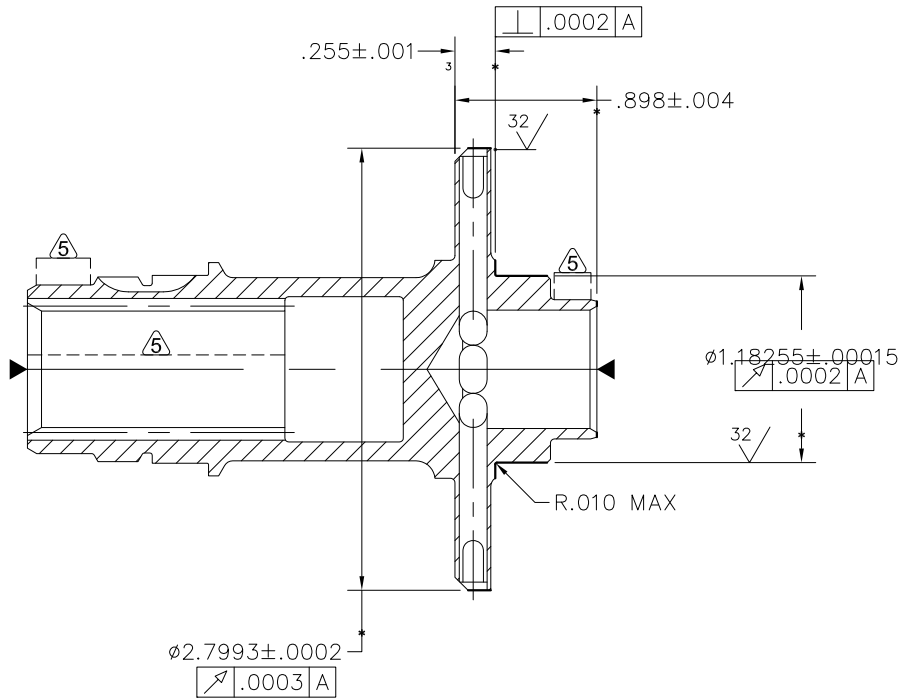
- 1. DRAWING SCALE: 1:1
- 2. MATL: 9310 IAW AMS 6265
- 3. HRC: 33-43 EXCEPT AS NOTED
- 4. SURFACE FINISH: 125u
- 5. BREAK SHARP EDGES: .010±.005
- 6. CAUTION: CARBURIZED AREA - DO NOT DAMAGE
- 7. CENTERS - A -



G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		235
	WORK CENTER		OPER REV
	LATHE		-
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1

1. DRAWING SCALE: 1:1
2. MATL: 9310 IAW AMS 6265
3. HRC: 33-43 EXCEPT AS NOTED
4. SURFACE FINISH: 125u
5. CAUTION: CARBURIZED AREA - DO NOT DAMAGE
6. CENTERS - A -

OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK

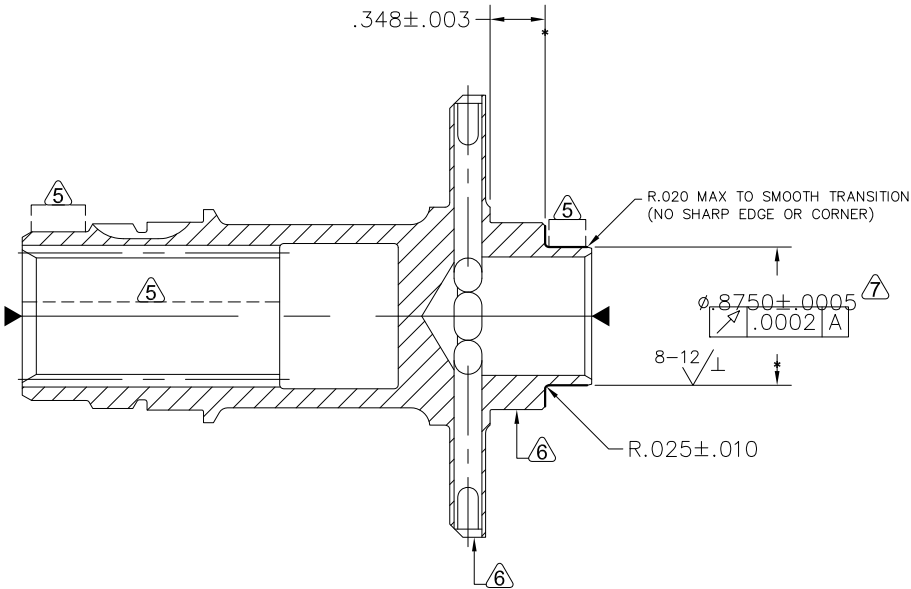


G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		240
	WORK CENTER		OPER REV
	OD GRIND		-
	DWN	CHK	SHEET
SK 12-31-09	SJK 01-15-10		1 OF 1

DRAWING NOTES:

- 1. DRAWING SCALE: 1:1
- 2. MATL: 9310 IAW AMS 6265
- 3. HRC: 33-43 EXCEPT AS NOTED
- 4. SURFACE FINISH: 63u
- 5 CAUTION: CARBURIZED AREA - DO NOT DAMAGE
- 6 CAUTION: GROUND SURFACE FINISH - DO NOT DAMAGE
- 7 SEAL SURFACE
 - a. PLUNGE GRIND TO PREVENT SPIRAL LEAD INDICATIONS
 - b. APPLY PROTECTIVE NETTING FOR HANDLING AND SHIPMENT
- 8. CENTERS - A -

OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK

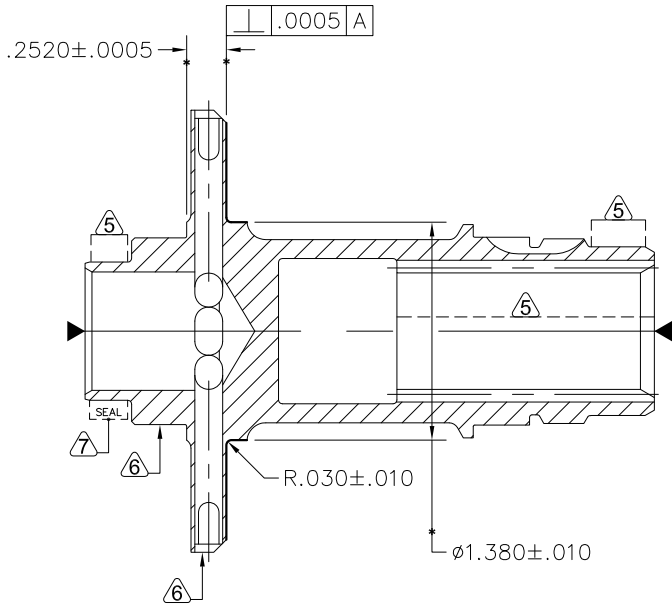


G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		250
	WORK CENTER		OPER REV
	OD GRIND		-
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1

DRAWING NOTES:

- 1. DRAWING SCALE: 1:1
 - 2. MATL: 9310 IAW AMS 6265
 - 3. HRC: 33-43 EXCEPT AS NOTED
 - 4. SURFACE FINISH: 125u
 - 5 CAUTION: CARBURIZED AREA - DO NOT DAMAGE
 - 6 CAUTION: GROUND SURFACE FINISH - DO NOT DAMAGE
 - 7 CAUTION: 12u SEAL SURFACE - DO NOT SCRATCH
 - a. APPLY PROTECTIVE NETTING FOR HANDLING AND SHIPMENT
8. CENTERS - A -

OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK

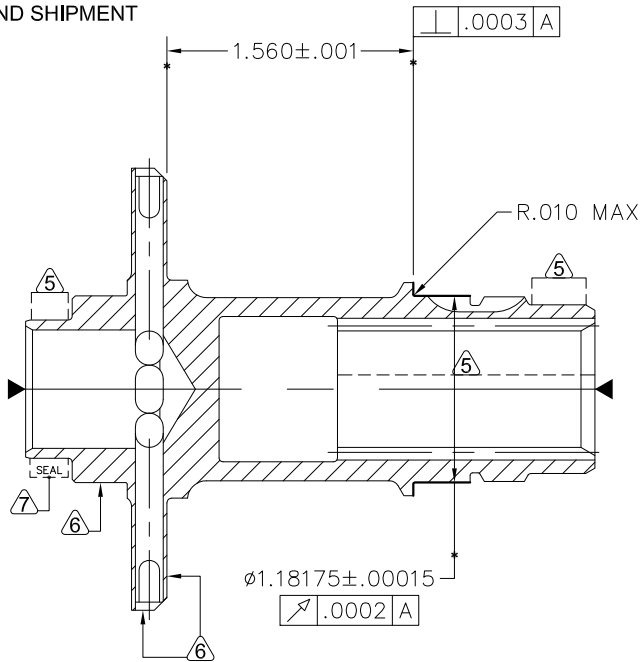


G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		260
	WORK CENTER		OPER REV
	OD GRIND		-
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1

DRAWING NOTES:

- 1. DRAWING SCALE: 1:1
 - 2. MATL: 9310 IAW AMS 6265
 - 3. HRC: 33-43 EXCEPT AS NOTED
 - 4. SURFACE FINISH: 32u
 - 5. CAUTION: CARBURIZED AREA - DO NOT DAMAGE
 - 6. CAUTION: GROUND SURFACE FINISH - DO NOT DAMAGE
 - 7. CAUTION: 12u SEAL SURFACE - DO NOT SCRATCH
 - a. APPLY PROTECTIVE NETTING FOR HANDLING AND SHIPMENT
8. CENTERS - A -

OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK



G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		270
	WORK CENTER		OPER REV
	OD GRIND		-
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1

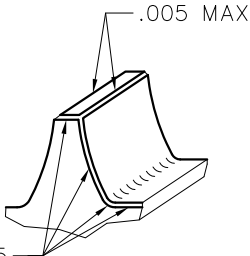
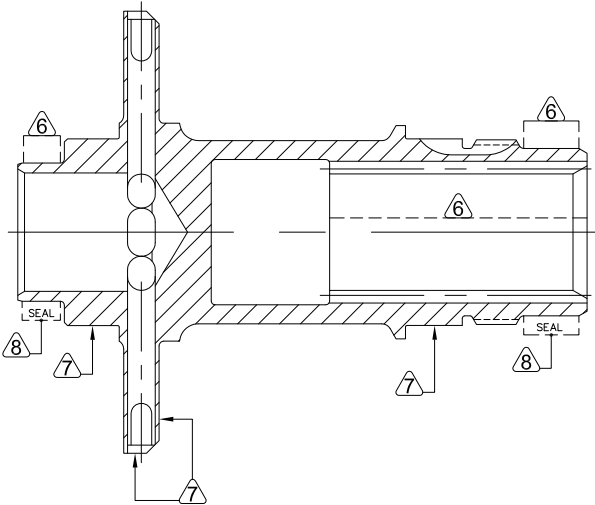
8. CENTERS —A—

G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		280
	WORK CENTER		OPER REV
	OD GRIND		-
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1

DRAWING NOTES:

- 1. DRAWING SCALE: 1:1
- 2. MATL: 9310 IAW AMS 6265
- 3. HRC: 33-43 EXCEPT AS NOTED
- 4. SURFACE FINISH: 125u
- 5. BREAK ALL SHARP EDGES: .010±.005
- 6 CAUTION: CARBURIZED AREA - DO NOT DAMAGE
- 7 CAUTION: GROUND SURFACE FINISH - DO NOT DAMAGE
- 8 CAUTION: 12u SEAL SURFACE - DO NOT SCRATCH
 - a. APPLY PROTECTIVE NETTING FOR HANDLING AND SHIPMENT

OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK

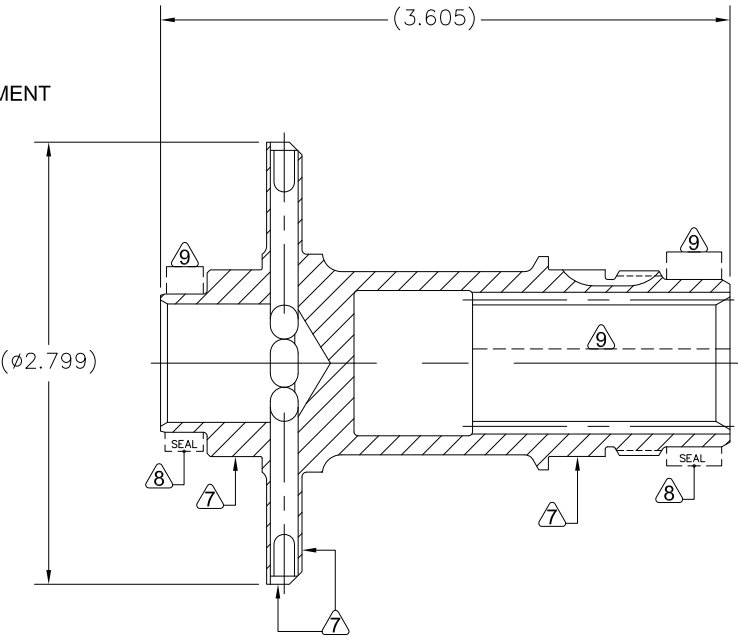


INTERNAL TOOTH

G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		300
	WORK CENTER		OPER REV
	DEBURR		-
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1

DRAWING NOTES:

- 1. DRAWING SCALE: 1:1
- 2. MATL: 9310 IAW AMS 6265
- 3. HEAT TREATMENT: CARBURIZED HRC 60 MIN
- 4. SURFACE TEMPER INSPECT:
 - a. PROCESS IAW HONEYWELL SPECIFICATION: HPS3002
- 5. STRESS RELIEVE WITHIN (4) HRS OF ETCHING:
 - a. TEMPERATURE: 275°±10° F
 - b. TIME: (4) HRS
- 6. CERTIFICATION REQUIRED
- 7 CAUTION: GROUND SURFACE FINISH - DO NOT DAMAGE
- 8 CAUTION: 12u SEAL SURFACE - DO NOT SCRATCH
 - a. APPLY PROTECTIVE NETTING FOR HANDLING AND SHIPMENT
- 9 CAUTION: CARBURIZED AREA - DO NOT DAMAGE



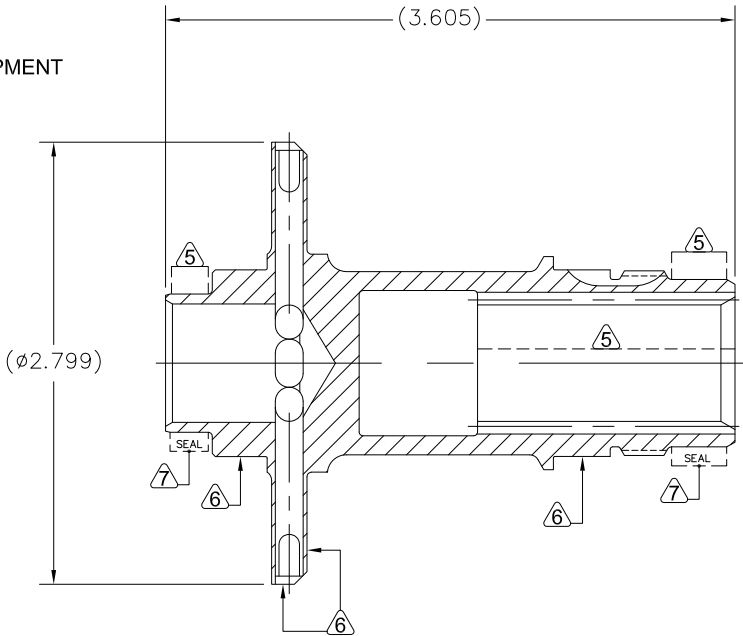
OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK

G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		320
	WORK CENTER		OPER REV
	STI		-
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1

DRAWING NOTES:

- 1. DRAWING SCALE: 1:1
- 2. MATL: 9310 IAW AMS 6265
- 3. MAGNETIC PARTICLE INSPECTION:
 - a. PROCESS SPECIFICATION: EMS 52308
 - b. ACCEPTANCE CRITERIA: EMS 57931 CL 1
 - i. ROTATING COMPONENT
- 4. CERTIFICATION REQUIRED
 - ⚠ CAUTION: CARBURIZED AREA - DO NOT DAMAGE
 - ⚠ CAUTION: GROUND SURFACE FINISH - DO NOT DAMAGE
 - ⚠ CAUTION: 12u SEAL SURFACE - DO NOT SCRATCH
 - a. APPLY PROTECTIVE NETTING FOR HANDLING AND SHIPMENT

OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK

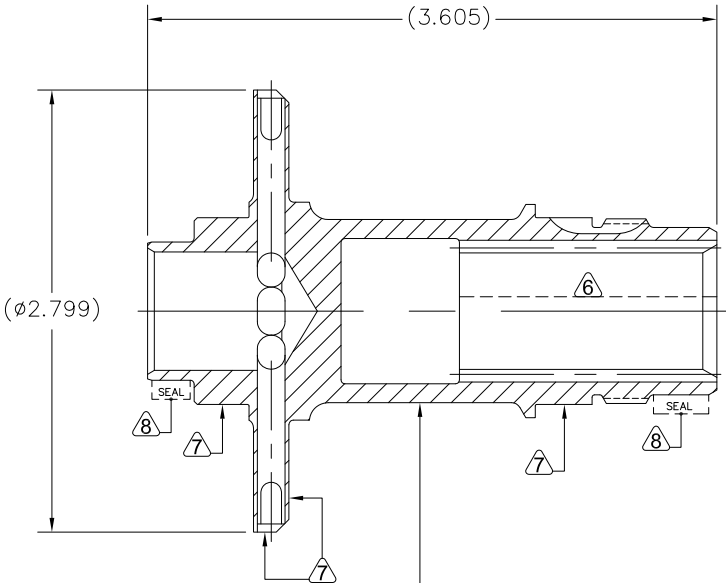


G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		330
	WORK CENTER		OPER REV
	MPI		-
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1

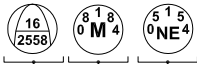
DRAWING NOTES:

- 1. DRAWING SCALE: 1:1
- 2. MATL: 9310 IAW AMS 6265
- 3. HRC: 33-43
- 4. MARKING PARAMETERS:
 - a. SPECIFICATION: OR AS 478-7A
 - b. STYLE: ELECTROCHEMICAL ETCH
 - c. HEIGHT: .050-.100
 - d. DEPTH: .0005-.0010
- 5. ALTERNATE METHOD
 - a. SPECIFICATION: OR AS 478-15B
 - b. STYLE: LASER
 - c. HEIGHT: .050-.100
 - d. DEPTH: .0005-.0010
- 6. CHARACTERS TO BE A .031 MIN FROM CORNERS, EDGES AND FILLETS
- 7 CAUTION: GROUND SURFACE FINISH - DO NOT DAMAGE
- 8 CAUTION: 12u SEAL SURFACE - DO NOT SCRATCH
 - a. APPLY PROTECTIVE NETTING FOR HANDLING AND SHIPMENT

OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK



99193-70220027-001



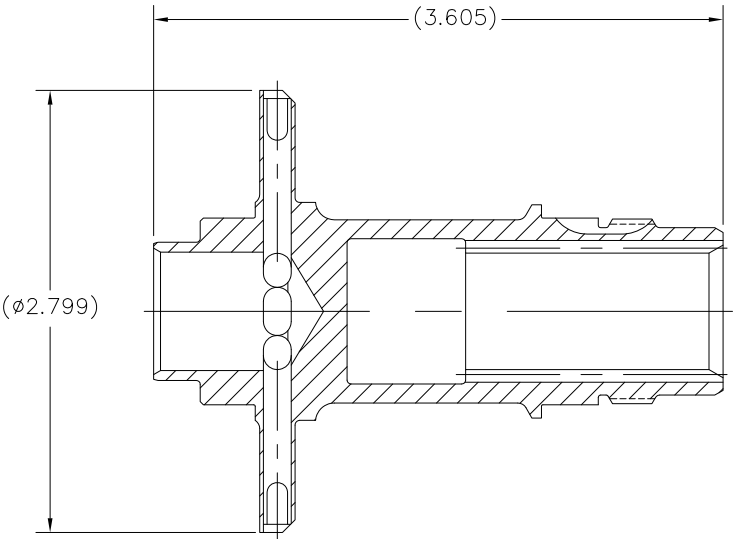
G&N ACCEPTANCE STAMP
HIXSON MPI ACCEPTANCE STAMP
EMBEE STI ACCEPTANCE STAMP

G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		350
	WORK CENTER		OPER REV
	IDENTIFY		-
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1

PACKAGING INSTRUCTION:

- 1. IMMERSE IN OIL (CORTEC VpCI-329D) / DRIP DRY
- 2. HEAT SEAL
 - a. USE BARRIER BAG IAW MIL-PRF-22191 TY 1 CL 1
 - b. EVACUATE MOST OF THE AIR AND SEAL WITH MARGIN FOR (3) RE-SEALINGS
- 3. PACKAGE IN A WHITE CBOARD BOX OR PADDED MAILER
- 4. IDENTIFY OUTSIDE OF BOX AS FOLLOWS:
 - a. TEXT HEIGHT .110-.125
 - b. BAR CODE HEIGHT .375 (DO NOT INCLULDE (P) CHARACTER STRING)

70220027-001 (P)



OPERATION REVISION CHANGE HISTORY			
REV	DESCRIPTION	REVISED	CHK

G&N RUBICON High Performance Gear Solutions 1550 E. McFadden Santa Ana, CA. 92705 714.835.0326 www.gnrubicon.com	PART NUMBER		OPER NO
	70220027-001		370
	WORK CENTER		OPER REV
	PACKAGE		-
	DWN	CHK	SHEET
	SK 12-31-09	SJK 01-15-10	1 OF 1