Form Approved OMB No. 0704-0188

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AGENCIES

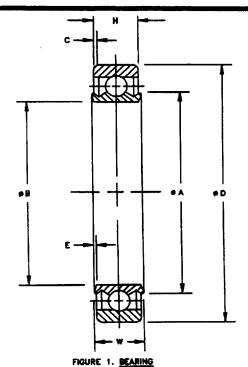


TABLE I.

ØĐ w н ØA ERC ØB OUTSIDE DIAME SHOULDER DIAMETER NOVER CORNER CHAMFER X 45 MAXIMUM 1/ RADIAL LIMIT LOAD RATING LIPS THRUST LIMIT LOAD RATING LIFS MS DASH NO. WEIGHT WIDTH INNER RING WIDTH BORE 3/ +.0007 +.0000 CASE I CASE II 3280 1500 1990 1820 .03 .777 1.0625 .6250 1700 1900 -39 3750 .7500 .8750 1.0625 .895 1.1875 1.3125 2110 1970 <u>:05</u> 30. 1.216 3000 2200 2170 -41 .015 5050 .09 1.7500 .281 .250 1.451 2700 2220 2130 1.3125 .10 6880 2180 3200 2260 -43 1.5825 2.0000 1.702 -44 1.8125 3/ 2.2500 2/ -45 2.0625 3/ 2.6250 2/ -46 2.3125 3/ 2.8750 2/ 1.970 2.286 \$220 4000 2340 22/30 .15 2.527 10150

- DIMENSIONS TO BE MET AFTER PLATING.
- A RADIUS GIVING APPROXIMATELY THE SAME GRIP FOR STAKING THE BEARING IN THE HOUSING WILL BE ACCEPTABLE. <u>2</u>/
- A RADIUS GIVING APPROXIMATELY THE SAME FILLET CLEARANCE WILL BE ACCEPTABLE.
- CASE I = LOAD FIXED WITH RESPECT TO OUTER RING. CASE II = LOAD FIXED WITH RESPECT TO THE INNER RING.
- THESE RATINGS ARE FOR OPERATION UP TO 250°F. WHEN SUBJECT TO OPERATION UP TO 350°F, THE RATINGS SHALL BE REDUCED BY 20 PERCENT. 5/
- OUT-OF-ROUND TOLERANCES: BORE: -38 THRU -43 ±.0010; -44 THRU -46: ±.0016 6/ OUTSIDE DIAMETER: -38 THRU -43 +.0005, -.0015; -44 THRU -46: +.0008, -.0023
- FOR DASH NUMBER SIZES -44, -45, AND -46, THE OUTSIDE DIAMETER TOLERANCE SHALL BE +.0000 TO -.0015 7/ INCHES.
- FOR DASH NUMBER SIZES -44, -45, AND -46 THE BORE TOLERANCE SHALL BE +.0010 TO -.0010 INCHES.

FDENOTES CHANGES		INCH-POUND	
PREPARING ACTIVITY: NAVY-AS CUSTODIANS: ARMY- AV NAVY- AS AIR FORCE-99 DLA- REVIEW: ARMY-AR,ME, AF-84 DLA-IS USER: PROJECT NUMBER: 3110-0930	MILITARY SPECIFICATION SHEET TITLE BEARING, BALL, AIRFRAME, ANTI-FRICTION, EXTRA LIGHT DUTY	SPECIFICATION SHEET IN S27646 SUPERSEDING MS27646 E AMSC- N/A	
DISTRIBUTION STATEMENT A Approved for public release; distribution is unlimited.			Page _1_ of _2_

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REQUIREMENTS:

- 1. MATERIAL: RINGS: 52100 STEEL PER AMS8440, OR E52100 STEEL PER FED-STD-66.

 BALLS: 52100 STEEL PER AMS8440 OR 51100 STEEL PER AMS8440, OR E51100 OR E52100 STEEL PER FED-STD-66.

 SELLS: POLYTETRAFLUGROETHYLENE PER AMS 3682 OR POLYTETRAFLUGROETHYLENE SHEET, GLASS FABRIC REINFORCED PER
- 2. Lubricant: Mil-G-81322 or Mil-G-23827. All Bearings shall be packed with grease conforming to Mil-G-81322 unless otherwise specified. If Mil-G-23827 is required, and the letter "G" after the MS27846 dash number.

 Mil-G-23827 shall not be used for operation where temperatures exceed 250° f.
- 3. HARDNESS: HEAT TREAT RINGS AND BALLS TO ROCKWELL "C" GO TO 66 AND STABILIZE FOR OPERATION AT 250°F.
- . SURFACE ROUGHNESS: RACEWAYS AND BALLS SHALL HAVE A SURFACE ROUGHNESS OF 8 Re PER ANSI/ASME B44.1.
- (F) 5. PLATING: ALL EXTERNAL SURFACES EXCEPT BORE, SEALS AND SEAL RETAINERS SHALL BE ZINC-NICKEL IN ACCORDANCE WITH AMS 2417.

 TYPE 2, OR CADMIUM PLATED IN ACCORDANCE WITH QQ-P-416, TYPE 1, CLASS 2, THICKNESS .0003 TO .0006 INCHES.
 - 8. RADIAL INTERNAL CLEARANCE SHALL BE .0008 TO .0018 INCHES.
 - 7. RADIAL AND LATERAL ECCENTRICITY SHALL BE: FOR THE HINER RING .0020 INCHES MAX. FOR THE OUTER RING .0016 INCHES MAX.
 - 8. PART NUMBER: THE PART NUMBER SHALL BE SEQUENCED LEFT RO RIGHT WITH DESIGNATIONS IN THE FOLLOWING SEQUENCE:

MS27846-380 = BEARING, BALL, AMFRAME, ANTIFRICTIONS, EXTRA LIGHT DUTY, .6250 INCH NOMINAL BORE, FILLED BOX MINNAUM WITH INL-G-23827 LUBRICANT

LUBRICANT DESIGNATOR (SEE LUBRICANT REQUIREMENTS)

OASH NUMBER (SEE TABLE I)

MILITARY SPECIFICATION SHEET NUMBER

9. REMOVABLE SEALS ARE OPTIONAL.

NOTES:

- 1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.
- 2. IN THE EVENT OF A CONFLICT BETWEEN THE TEXT OF THIS SPECIFICATION AND REFERENCES CITED HEREIN, THE TEXT OF THIS STANDARD SHALL TAKE PRECEDENCE.
- 3. REFERENCED GOVERNMENT (OR NON-GOVERNMENT) DOCUMENTS OF THIS ISSUE LISTED IN THAT ISSUE OF THE DEPARTMENT OF DEFENSE INDEX OF SPECIFICATIONS AND STANDARDS (D-DISS) SPECIFIED IN THE SOLICITATION FORM A PART OF THIS STANDARD TO THE EXTENT SPECIFIED HEREIN.

PREPARING ACTIVITY: NAVY-AS CUSTODIANS. ARMY- AV NAVY- AS	MILITARY SPECIFICATION SHEET	MS276	SHEET NUMBER 21 JUNE 95
AIR FORCE- 99 DLA- REVIEW: ARMY-AR.ME. DLA-15	BEARING, BALL, AIRFRAME, ANTI-FRICTION, EXTRA LIGHT DUTY	SUPERSEDING MS28915 E	05 DEC 94
USER: PROJECT NUMBER: 3110-0930		AMSC- N/	/A FSC 3110
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