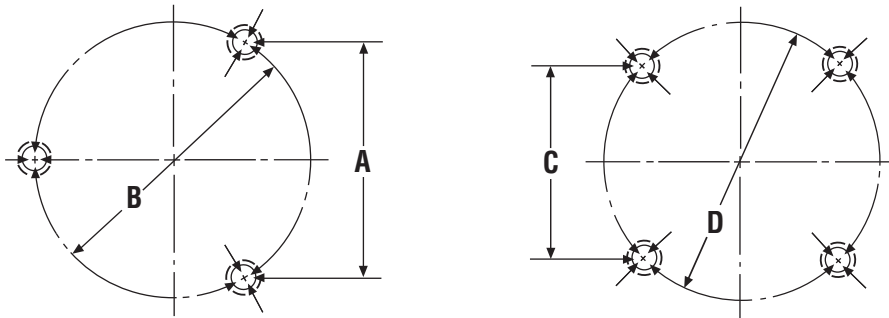


Machining instructions for gear, sprocket or pulley



Unit Size	A	B	C	D
500	3.356 ± .001	3.875 ± .001		
650			3.624 ± .001	5.125 ± .001
825	3.085 ± .001	3.563 ± .001		
1000	4.548 ± .002	5.252 ± .002		
1225			4.155 ± .002	5.877 ± .002
1525			6.010 ± .002	8.500 ± .002

- Chordal dimensions must be held for all chords between pin holes.

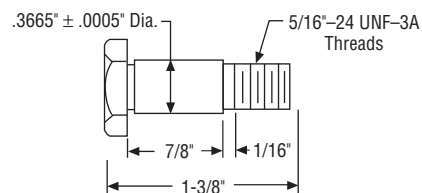
Size 825-1525

- Drill 27/64 inch diameter holes to a sufficient depth and tap for 1/2-13 UNC-3B, one inch minimum full threads. Pin holes must be concentric with mounting shaft within .010 T.I.R. and parallel with mounting shaft within .002 T.I.R., surface that pins seat against to be square with mounting shaft within .004 T.I.R.
- Ream .500/.501 to a 3/8 inch depth and to be concentric with tapped holes.

Size 500 and 650

- Sleeve bearings (oilite bronze) must be provided in the holes of pulley or hub with an I.D. of .376 ± .001 at the chordal and bolt circle dimensions shown above.
- The drive pin holes must be concentric with mounting shaft within .006 T.I.R. and parallel with mounting shaft within .002 T.I.R.

Size 500-650 Drive Pin



Size 825-1525 Drive Pin

