BEARING RETAINER HAS
LEFT HAND THREADS

1 3/8

13 9/64

A A

.958

SEE NOTEE 5 & 6 FOR
TAPPERED PIN
LOCKING ASSEMBLY
TOGETHER

1/2

1.812

.150

5/16

2.750

.969

SEE NOTE 1

SEE NOTE 2

.969

#5 CENTER
DEPTH 1/4

Ø1 3/8

Ø.9841 +.0000 / -.0002 FIN.

Ø.999 MACH.
BEARING SURFACE

CHAMFER 45° X 1/16
2-PLACES

THREAD 15/16-16 UN
P.D. = .893 - .896

R1/32 GRIND RELIEF

R1/16 THREAD RELIEF
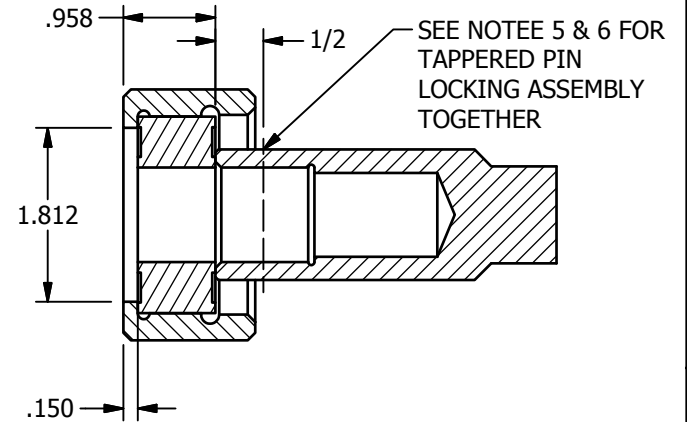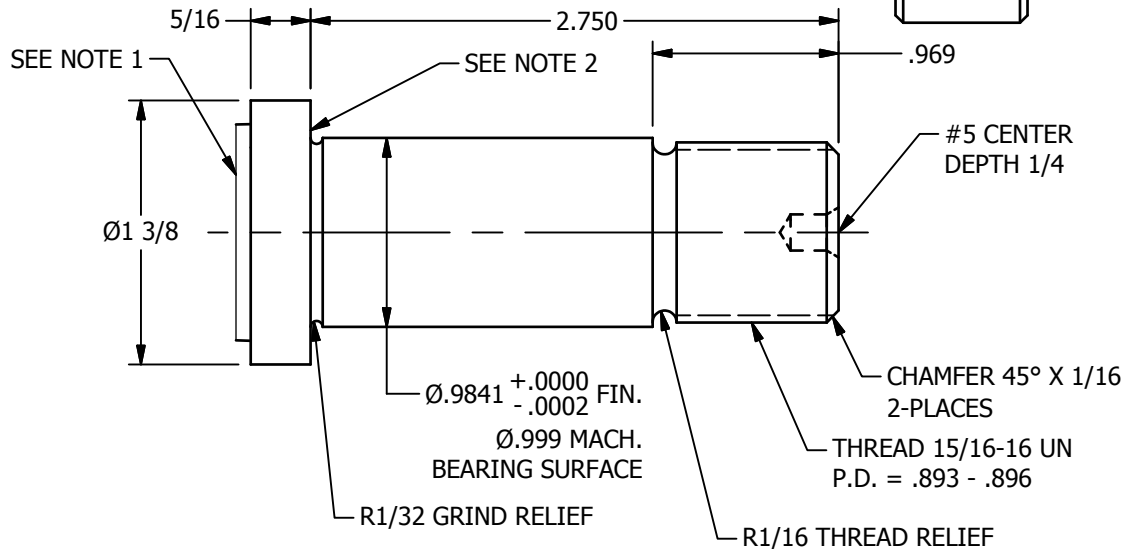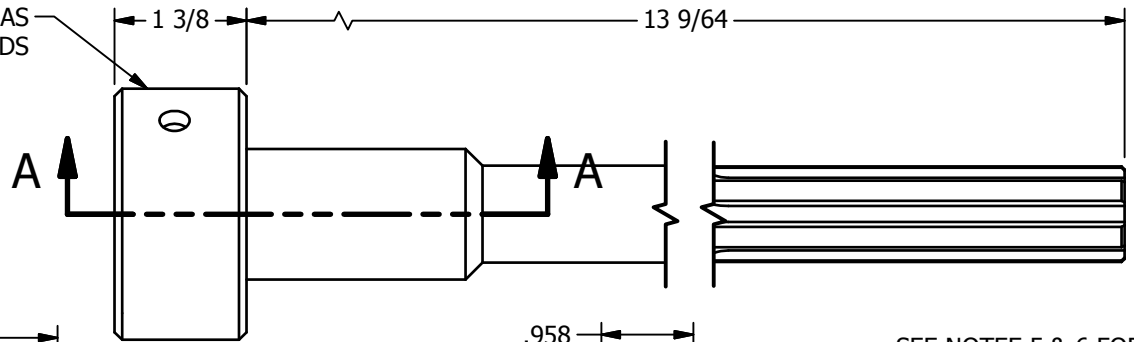
SECTION A-A
SCALE 1/2

MALE PORTION OF SPINDLE
W/STANDARD BEARING

NOTES:
1) DESIGN CUSTOM SPINDLE FRONT TO CUSTOMER SPECIFICATION.
2) SHOULDER MUST BE 90° TO BEARING SURFACE WITHIN 0°1'16" (.021°).
3) WHERE TWO DIMENSIONS ARE GIVEN, MACH. DENOTES ROUGH MACHINING
CONDITION PRIOR GRINDING, AND FIN. DENOTES FINAL CONDITION AFTER GRINDING.
4) BREAK EDGES 1/32 UNLESS OTHERWISE STATED.
5) ASSEMBLE SPINDLE AND DRIVE SHAFT USING ANTI-SIEZE LUBRICATION.
6) DRILL Ø5/16, THROUGH ASSEMBLY. TAPER REAM #6. AFTER DRIVING IN TAPER PIN,
LATHE SURFACE SMOOTH. MARK PIN REMOVAL SIDE WITH X-X.

AAA PRODUCTS
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PRODUCTS
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TITLE:
DRIVE SHAFT & SPINDLE ASSEMBLY,
CUSTOMER SUPPLIED SPINDLE,
JIFFY DRILL

DRAWING NO.:

DIM_3DS0