

REV.
C

SAE AS28915

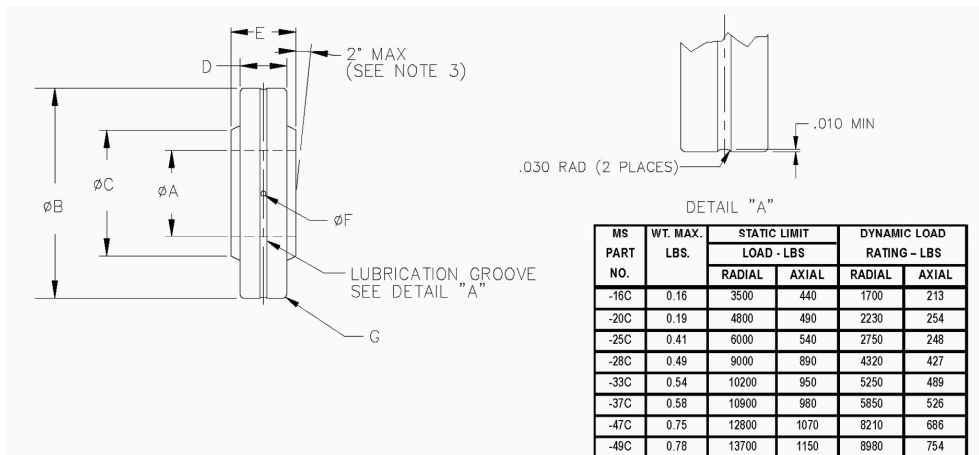
FEDERAL SUPPLY CLASS
3110

RATIONALE

THE REASON FOR UPDATING THIS SPECIFICATION IS TO ADD AN IDENTIFICATION LETTER FOR ZINC NICKEL PLATING (OPTION "E"), AND TO ADD IDENTIFICATION LETTERS FOR MIL-PRF-23827 GREASE, TYPE I OR TYPE II (OPTION "G"), TYPE I (OPTION "H"), AND TYPE II (OPTION "J").

NOTICE

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODISS SPECIFIED IN THE SOLICITATION: SAE AS8914.



MS DASH No.		ØA	ØB	ØC	D	E	ØF	G	NUMBER OF LUBRICATION HOLES		
		+0.0000	+0.0000	+0.005	+0.000	+0.000	LUBRICATION HOLE	+0.020			
		-.0011	-.0011	-.005	-.005	-.005		-.000			
		BORE *1 *2	O.D. *3	DIAMETER	WIDTH OUTER RING *4	WIDTH INNER RING *4		RADIUS			
-16C		1.0000	1.6250	1.120	.450	.500	.060	.020	2		
-20C		1.2500	1.8750	1.390							
-25C		1.5630	2.5000	1.800							
-28C		1.7500	2.6880	1.980							
-33C		2.0630	3.0000	2.300							
-37C		2.3130	3.2500	2.560	.580	.670	.060	.020	3		
-47C		2.9380	3.8750	3.200							
-49C		3.0630	4.0000	3.330							
BASIC (NOMINAL) DIAMETER		BEARING ROUNDNESS LIMITS									
		BORE ACCEPTANCE LIMITS				O.D. ACCEPTANCE LIMITS					
		OVER	INCL	d MIN.	MEAN DIAMETER		d MAX.	D MIN.	MEAN DIAMETER		D MAX.
					LOW	HIGH			LOW	HIGH	
.0000	1.0000	-.0008	-.0005	+0.000	+0.0003	-----	-----	-----	-----		
1.0000	2.0000	-.0011	-.0008	+0.000	+0.0003	-.0020	-.0010	+0.000	+0.0010		
2.0000	4.0000	-.0014	-.0011	+0.000	+0.0003	-.0021	-.0011	+0.000	+0.0010		

*1. TOLERANCE ON -16C BORE IS +0.000 TO -.0005

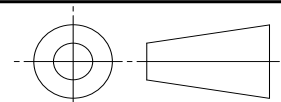
*2. TOLERANCE ON -20C, -25C, AND -28C BORE IS +0.000 TO -.0008

*3. TOLERANCE ON -16C AND -20C O.D. IS +0.000 TO -.0010

*4. TOLERANCE ON -33C, -37C, -47C, AND -49C OUTER RING WIDTH AND INNER RING WIDTH IS +0.000 TO -.008

SAE values your input. To provide feedback on this Technical Report, please visit <http://www.sae.org/technical/standards/AS28915C>

THIRD ANGLE PROJECTION



CUSTODIAN: ACBG

PROCUREMENT SPECIFICATION: NONE

SAE Aerospace
An SAE International Group

AEROSPACE STANDARD

BEARING, ROLLER, SELF-ALIGNING, DOUBLE ROW
TORQUE TUBE, AIRFRAME, ANTI-FRICTION,
SEALED, TYPE IV

SAE AS28915
SHEET 1 OF 2

REV.
C

Documents

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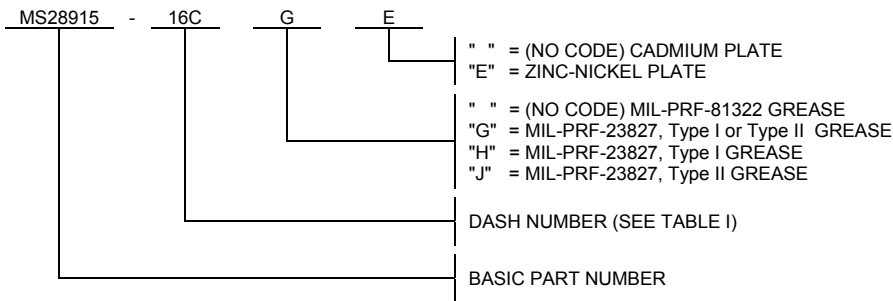
SAE WEB ADDRESS: <http://www.sae.org>

REQUIREMENTS:

NOTICE

THIS DOCUMENT REFERENCES A PART WHICH MAY CONTAIN CADMIUM AS A PLATING MATERIAL. CONSULT LOCAL OFFICIALS IF YOU HAVE QUESTIONS CONCERNING CADMIUM'S USE.

- 1. MATERIAL: RETAINERS: SAE 4140 STEEL PER AMS6382, AMS6349, OR COPPER ALLOY PER AMS4640, QQ-C-390 OR EQUIVALENT. RINGS AND ROLLERS: SAE 52100 STEEL PER AMS6440 OR AMS-S-7420 PER AMS-STD-66
- 2. MIL-PRF-81322 OR MIL-PRF-23827 (TYPE I OR TYPE II). ALL BEARINGS SHALL BE FILLED 80% MINIMUM WITH GREASE. IF MIL-PRF-23827 (TYPE I OR TYPE II) IS REQUIRED, ADD THE LETTER "G" AFTER THE MS28915 DASH NUMBER. FOR TYPE I ONLY, ADD LETTER "H", OR FOR TYPE II ONLY, ADD LETTER "J" AFTER THE MS28915 DASH NUMBER. MIL-PRF-23827 (TYPE I OR TYPE II) SHALL NOT BE USED WHERE TEMPERATURE EXCEEDS 250 °F MAX.
- 3. RADIAL INTERNAL CLEARANCE: .0004 TO .0010.
- 4. FINISH: ZINC-NICKEL PLATED IN ACCORDANCE WITH AMS2417, TYPE 2, GRADE B OR CADMIUM PLATED IN ACCORDANCE WITH AMS-QQ-P-416, TYPE I, CLASS 2, TO A THICKNESS OF .0003 TO .0006 INCHES. IF ZINC-NICKEL PLATING IS REQUIRED, ADD THE LETTER "E" AS SHOWN IN NOTE 9.
- 5. SURFACE ROUGHNESS: RACEWAYS 8 MICROINCHES Ra MAXIMUM, ROLLERS 6 MICROINCHES Ra MAXIMUM. ALL OTHER SURFACES 32 MICROINCHES Ra MAXIMUM IN ACCORDANCE WITH ANSI/ASME B46.1. REMOVE BURRS AND SHARP EDGES.
- 6. DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED.
- 7. TOLERANCES: DECIMALS +.010 TO -.000, UNLESS OTHERWISE SPECIFIED.
- 8. DIMENSIONS TO BE MET AFTER PLATING.
- 9. EXAMPLE OF PART NUMBER



- 10. FOR DESIGN FEATURE PURPOSE, THIS SPECIFICATION TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.
- 11. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BIDS.
- 12. SELF-ALIGNING TO 2 DEGREES MAX IN EITHER DIRECTION.
- 13. A CHANGE BAR (I) LOCATED IN THE LEFT MARGIN IS FOR THE CONVENIENCE OF THE USER IN LOCATING AREAS WHERE TECHNICAL REVISIONS, NOT EDITORIAL CHANGES, HAVE BEEN MADE TO THE PREVIOUS ISSUE OF THIS DOCUMENT. AN (R) SYMBOL TO THE LEFT OF THE DOCUMENT TITLE INDICATES A COMPLETE REVISION OF THE DOCUMENT, INCLUDING TECHNICAL REVISIONS. CHANGE BARS AND (R) ARE NOT USED IN ORIGINAL PUBLICATIONS, NOR IN DOCUMENTS THAT CONTAIN EDITORIAL CHANGES ONLY.