AS81934/1

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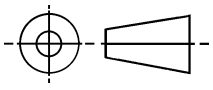
THIRD ANGLE PROJECTION



ISSUED 1998-04

PREPARED BY AIRFRAME CONTROL BEARINGS GROUP

SAE The Engineering Society For Advancing Mobility Land Sea Air and Space®
INTERNATIONAL
400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE STANDARD

BEARING, SLEEVE, PLAIN,
SELF-LUBRICATING, 325° F

AS81934/1
SHEET 1 OF 5

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 AS81934.

NOTE:
CONCENTRICITY TOLERANCE
BETWEEN ⌀B AND ⌀D DIA SHALL
NOT EXCEED .003 TIR

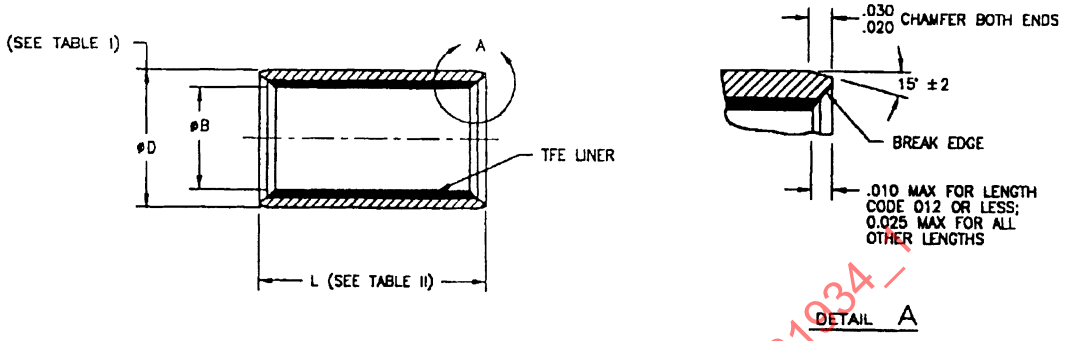


TABLE I. DIMENSIONS AND WEIGHTS

DASH NO.	NOMINAL SIZE	⌀B (BORE DIA) +.0000 −.0010	⌀D 1/	WEIGHT LB/IN (REF) L = 1.000	
				AL	CRES
−04	.2500	.2515	.3760	.006	.016
−05	.3125	.3140	.4386	.007	.019
−06	.3750	.3765	.5012	.008	.022
−07	.4375	.4390	.5638	.009	.025
−08	.5000	.5015	.6265	.011	.028
−09	.5625	.5640	.6892	.012	.031
−10	.6250	.6265	.8142	.021	.056
−11	.6875	.6890	.8767	.022	.060
−12	.7500	.7515	.9393	.024	.065
−14	.8750	.8765	1.0645	.028	.075
−16	1.0000	1.0015	1.1898	.031	.084
−18	1.1250	1.1265	1.3148	.035	.094
−20	1.2500	1.2515	1.4398	.038	.103
−22	1.3750	1.3765	1.5648	.041	.113
−24	1.5000	1.5015	1.7523	.062	.171
−26	1.6250	1.6265	1.8773	.067	.183
−28	1.7500	1.7515	2.0023	.071	.196
−32	2.0000	2.0015	2.2523	.081	.222

1/ ⌀D TOLERANCE: ALUMINUM ±.0005; CORROSION RESISTANT STEEL +.0000, −.0005.

EXAMPLE OF WEIGHT CALCULATION:
M81934/1−16A008 SLEEVE WEIGHT = (0.031 LB/IN) x .250 INCH = 0.008 LB.

TABLE II. SLEEVE BEARING LENGTH

DASH NO.	NOMINAL SIZE	LENGTH L +.000 −.010														
		.156	.187	.218	.250	.281	.312	.343	.375	.437	.500	.562	.625	.687	.750	.875
−04	1/4	005	006	007	008	009	010	011	012	014						
−05	5/16	005	006	007	008	009	010	011	012	014	016	018				
−06	3/8	005	006	007	008	009	010	011	012	014	016	018	020	022		
−07	7/16	005	006	007	008	009	010	011	012	014	016	018	020	022	024	028
−08	1/2	005	006	007	008	009	010	011	012	014	016	018	020	022	024	028
−09	9/16	005	006	007	008	009	010	011	012	014	016	018	020	022	024	028
−10	5/8	005	006	007	008	009	010	011	012	014	016	018	020	022	024	028
−11	11/16				008	009	010	011	012	014	016	018	020	022	024	028
−12	3/4				008	009	010	011	012	014	016	018	020	022	024	028
−14	7/8				008	009	010	011	012	014	016	018	020	022	024	028
−16	1				008	009	010	011	012	014	016	018	020	022	024	028
−18	1 1/8						010	011	012	014	016	018	020	022	024	028
−20	1 1/4								012	014	016	018	020	022	024	028
−22	1 3/8								012	014	016	018	020	022	024	028
−24	1 1/2								012	014	016	018	020	022	024	028
−26	1 5/8										016	018	020	022	024	028
−28	1 3/4										016	018	020	022	024	028
−32	2										016	018	020	022	024	028

TABLE II. SLEEVE BEARING LENGTH (CONTINUED)

DASH NO.	NOMINAL SIZE	LENGTH L +.000 −.010														
		1.000	1.125	1.250	1.375	1.500	1.625	1.750	1.875	2.000	2.125	2.250	2.375	2.500	2.750	3.000
−04	1/4															
−05	5/16															
−06	3/8															
−07	7/16															
−08	1/2															
−09	9/16	032	036													
−10	5/8	032	036	040	044											
−11	11/16	032	036	040	044	048	052									
−12	3/4	032	036	040	044	048	052									
−14	7/8	032	036	040	044	048	052									
−16	1	032	036	040	044	048	052	056	060							
−18	1 1/8	032	036	040	044	048	052	056	060							
−20	1 1/4	032	036	040	044	048	052	056	060	064	068					
−22	1 3/8	032	036	040	044	048	052	056	060	064	068					
−24	1 1/2	032	036	040	044	048	052	056	060	064	068	072	076	080	088	
−26	1 5/8	032	036	040	044	048	052	056	060	064	068	072	076	080	088	096
−28	1 3/4	032	036	040	044	048	052	056	060	064	068	072	076	080	088	096
−32	2	032	036	040	044	048	052	056	060	064	068	072	076	080	088	096

TABLE III. OVERSIZE BEARING DIMENSIONS 2/

RESTRICTED USAGE FOR REPAIR WORK ONLY

.010 AND .020 OVERSIZE OUTSIDE DIAMETER FOR
REPLACEMENT OF BEARINGS SHOWN ON SHEET 2

DASH NO.	NOMINAL SIZE	1st OVERSIZE (.010) ØD 1/
−04	.2500	.3860
−05	.3125	.4486
−06	.3750	.5112
−07	.4375	.5738
−08	.5000	.6365
−09	.5625	.6992
−10	.6250	.8242
−11	.6875	.8867
−12	.7500	.9493
−14	.8750	1.0745
−16	1.0000	1.1998
−18	1 1250	1.3248
−20	1 2500	1.4498
−22	1 3750	1.5748
−24	1.5000	1.7623
−26	1 6250	1.8873
−28	1.7500	2.0123
−32	2.0000	2.2623

DASH NO	NOMINAL SIZE	2nd OVERSIZE (.010) ØD 1/
−04	.2500	.3960
−05	.3125	.4586
−06	.3750	.5212
−07	.4375	.5838
−08	.5000	.6465
−09	.5625	.7092
−10	.6250	.8342
−11	.6875	.8967
−12	.7500	.9593
−14	.8750	1.0845
−16	1.0000	1.2098
−18	1.1250	1.3348
−20	1.2500	1.4598
−22	1.3750	1.5848
−24	1.5000	1.7723
−26	1.6250	1.8973
−28	1.7500	2.0223
−32	2.0000	2.2723

1/ ØD TOLERANCE ALUMINUM ±.0005, CORROSION RESISTANT STEEL +.0000, −.0005.

2/ BEFORE INITIATING A REPAIR PROCEDURE TO USE AN OVERSIZE BEARING, APPROVAL FOR MODIFYING AND REIDENTIFYING THE BEARING HOUSING MUST BE OBTAINED FROM THE COGNIZANT ENGINEERING AUTHORITY.

REQUIREMENTS:

1. MATERIAL: BEARING: "A" INDICATES ALUMINUM ALLOY QQ-A-200/3 OR QQ-A-225/6 (2024T851 OR 2024T8511). NOTE: THE MANUFACTURER MAY SUBSTITUTE ALLOY 2024T351 OR 2024T3511 FOR 2024T851 OR 2024T8511, RESPECTIVELY, PROVIDED THE PROCESSING PROCEDURES EMPLOYED IN MANUFACTURING THE BEARING RESULT IN A CONVERSION OF ALLOY TO 2024T851 OR 2024T8511.

   "C" INDICATES CORROSION RESISTANT STEEL, AMS-5643 (17-4PH) CONDITION H1150 PER MIL-H-6875.

   LINER: SEE PROCUREMENT SPECIFICATION

2. SURFACE TEXTURE: SMOOTH MACHINE FINISH 63 MICRO-INCH Ra ON O.D., 125 MICRO-INCH Ra ON ALL OTHER METALLIC SURFACES PER ASME-B46.1. LINER SURFACES ARE EXEMPT FROM SURFACE TEXTURE MEASUREMENTS.

3. BREAK SHARP EDGES AND CORNERS AND REMOVE ALL BURRS AND SLIVERS.

4. DIMENSIONS ARE IN INCHES. UNLESS OTHERWISE SPECIFIED, TOLERANCES ARE, DECIMALS ±.010 AND ANGLES ±0.5°.

5. MARKING: FOR DASH NO. 08 AND LARGER THE MILITARY PART NUMBER SHALL BE MARKED ON THE PART.

6. INTERCHANGEABILITY RELATIONSHIP: USE ONLY ASSIGNED PART NUMBERS FOR LENGTH AS LISTED IN LENGTH COLUMN OF TABLE II.