



400 Commonwealth Drive, Warrendale, PA 15096-0001

SURFACE VEHICLE RECOMMENDED PRACTICE

SAE J2487

ISSUED APR2000

Issued 2000-04

Submitted for recognition as an American National Standard

SAE No. 2 Friction Test Machine 3600 r/min Stepped Power Test

1. Scope—This SAE Recommended Practice is intended as the definition of a standard test, but may be subject to frequent change to keep pace with experience and technical advances. This should be kept in mind when considering its use.

The SAE No. 2 Friction Test Machine is used to evaluate the friction characteristics of automatic transmission plate clutches with automotive transmission fluids. It can also be used to conduct durability tests on wet friction systems.

The specific purpose of this document is to define a 3600 r/min Stepped Power Test for the evaluation of wet friction system performance variation as a function of power level. This procedure uses an initial engagement speed of 3600 r/min and is intended as a standard procedure for common use by both suppliers and end users.

The only variables selected by the supplier or user of the friction system are:

- a. Friction Material
- b. Fluid
- c. Reaction Plates

These three variables must be clearly identified when reporting the results of using this test. If any of the test parameters or system hardware as described in this document are changed, other than the friction material, test fluid, or reaction plates, the data may not be reported as having been obtained using this document.

This procedure is not intended to evaluate the initial coefficient or break-in characteristics. For this information, refer to SAE J2490 SAE No. 2 Friction Test Machine μ PVT Test.

2. References

2.1 Applicable Publications—The following publications form a part of this specification to the extent specified herein. Unless otherwise indicated, the latest version of SAE publications shall apply.

2.1.1 SAE PUBLICATIONS—Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

SAE J286—SAE No. 2 Clutch Friction Test Machine Guidelines
SAE J1646—Glossary of Terms—Lubricated Friction Systems
SAE J2490—SAE No. 2 Friction Test Machine μ PVT Test

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

2.2 Related Publications—The following publications are for information purposes only and are not a required part of this specification.

2.2.1 SAE PUBLICATIONS—Available from SAE, 400 Commonwealth Drive, Warrendale PA 15096-0001.

SAE J1499—SAE Band Friction Test Machine (SAE) Test Machine Guidelines

SAE Paper 670051—New Fixture for Testing Friction Materials for Automatic Transmission Clutch

SAE J2488—SAE No. 2 Friction Test Machine 6000 r/min Stepped Power Test

SAE J2489—SAE No. 2 Friction Test Machine Durability Test

2.2.2 FORD MOTOR COMPANY PUBLICATION—Available from Ford Motor Company, FSATF Committee, 35500 Plymouth Road, Box 215, Livonia, MI 48150.

Ford MERCON® V Specification

2.2.3 GENERAL MOTOR PUBLICATION—Available from GM Research & Development Center, General Motors Corporation, Technology Licensing, 30500 Mound Road, M/C 480-106-160, Warren MI 48090-9055.

GM DEXRON®-III Specification, GM6417M

2.2.4 DAIMLER CHRYSLER PUBLICATION—Available from Daimler Chrysler Corporation, Engineering Standards Group, 800 Chrysler Drive East, Auburn Hills MI 48326-2757.

Daimler Chrysler Specification MS9602

3. Test Equipment

3.1 SAE No. 2 Friction Test Machine with breakaway accessory.

3.2 Flywheels to deliver desired kinetic energy. The flywheels required to provide the specified step changes in total system inertia are shown in Tables 1A and 1B.

3.3 Data Acquisition—At not less than 1000 samples per second and storage system with at least four channels with response as follows:

a. Torque Channel, Bandwidth - 500 Hz.

b. Apply Pressure Channel, Bandwidth - 500 Hz.

c. Speed Channel, Bandwidth - 500 Hz.

d. Test Fluid Temperature Channel, Bandwidth - 3 Hz.

(All channels are to be calibrated to maintain $\pm 2\%$ accuracy throughout the range of 10% of full scale to full scale).

3.4 Instrumentation

a. Torque Transducer—Full bridge, strain gage type, with combined nonlinearity and hysteresis effects not to exceed 0.5% of full scale, such as Lebow Load Cell, Model 3397.

b. Apply Pressure Transducer—Full bridge, strain gage type, with combined nonlinearity and hysteresis effects not to exceed 0.5% of full scale, such as Sensotech, Model TJU708-12.

c. Speed Transducer—Optical Encoder for drive motor, such as BEI Model 924-01002-4839.

d. Thermocouple(s)—Type J with high-impedance amplifier and cold junction compensator.

**TABLE 1A—REQUIRED INERTIA
3600 R/MIN INITIAL SPEED**

Step Level	Total Inertia (kg·m ²)	Incremental Flywheel Inertia (kg·m ²)	Possible Flywheels	Energy
1	0.213	Motor+A	A	15.13
2	0.254	0.041	A+B	18.02
3	0.294	0.040	A+2B	20.91
4	0.335	0.041	A+C	23.80
5	0.376	0.041	A+B+C	26.69
6	0.416	0.040	A+2B+C	29.58
7	0.457	0.041	A+D	32.47
8	0.498	0.041	A+B+D	35.36
9	0.538	0.040	A+2B+D	38.25
10	0.579	0.041	A+C+D	41.15
11	0.620	0.041	A+B+C+D	44.04
12	0.660	0.040	A+2B+C+D	46.89

TABLE 1B—POSSIBLE FLYWHEELS REQUIRED FOR THE TEST:

Code	Quantity	Inertia (kg·m ²)
A	1	As required to achieve Level 1 inertia of 0.213
B	2	0.0405
C	1	0.1215
D	2	0.2430

3.5 Test Fluid System—(Figure 1C in SAE J286) Heated sump including immersion or jacket heater with sufficient watt density for test fluid temperature control and the associated hardware for external fluid flow control. Care should be taken that the fluid is not altered or modified by contact with the immersion heater by ensuring that the heater does not exceed a power density of 2 W/cm².

3.6 Adapters and Reaction Plates—The required friction, reaction plates, hub, retainer and pressure plates and spacers are all described in Appendix A.

3.7 Apply Piston Seal

- VITON®
- Teflon®—Recommended for use in high temperature fluid tests.

3.8 Lubrication System Flow Configuration

3.8.1 EXTERNAL FLOW—(Figure 1C in SAE J1646). This represents the configuration wherein an external pump supplies fluid at a specific flow rate through a line to the centerline of the shaft. A flow meter must be installed in the line to the cover to measure the flow supplied to the head. The drain to the sump is located at the 5, 6, and 7 o'clock positions.

4. Typical Operating Conditions and Test Parameters

4.1 **Piston Area**—15 110 mm².

4.2 **Piston Available Travel**—4.57 mm.

4.3 **Piston Apply Pressure**—As required to produce the required stop time of 0.5 s for each engagement. Allowable variation in stop time is $\pm 0.5\%$ or ± 3.0 ms (see Reference SAE J1646 for definitions).

- Start Threshold – Torque
- Stop Threshold – Torque

4.4 **Piston Apply Pressure Rise**—The apply pressure must be stable at the required level within 50 ms. (Highest pressure level) The maximum overshoot must not exceed 2% of the required pressure level.

4.5 **Piston Release Pressure**—30 to 100 kPa and must be 0 kPa during the apply period.

4.6 **Effective Inertia Range**—The inertia range is from the effective base Inertia, which is the minimum inertia for the test, to some maximum as determined in the test. A flywheel specific to an individual dynamometer may be required to attain the Level 1 inertia of 0.213 kg-rn². See Tables 1A and 1B.

4.7 **Initial Engagement Speed**—3600 r/min $+0/-20$ r/min.

4.8 **Kinetic Energy**—As shown in Tables 1A and 1B and Appendix B. These kinetic energy values must be as required for the specific level. The allowable variation in kinetic energy is $\pm 5\%$.

4.9 **Breakaway Speed**—4.37 r/min.

4.10 **Test Fluid**

- Quantity—18 L minimum, and must be replaced with new fluid at the beginning of the procedure.
- Temperature—115 °C ± 5 °C. Measured in the inlet line as shown in Appendix A.
- Test Fluid Flow—The test fluid flow rate is 0.5 L/min ± 0.05 L/min.
- Fluid Flow Configuration—The flow configuration is External Flow as described in SAE J1646 and 3.8.

4.11 **Pack Clearance**—1.143 mm ± 0.127 mm

4.12 **Test Periods**—Refer to SAE J1646 for the definitions of the test periods. The total period for one dynamic engagement cycle is 30 s ± 1 s.

- T₁, Stabilization Period—15 s ± 0.5 s
- T₂, Coast Period—0
- T₃, Apply Period—12 s ± 0.1 s
- T₄, Dwell Period—3 s ± 0.5 s
- T₅, Soak Period—2.5 s ± 2.5 s
- T₆, Breakaway Period—2 s ± 0.5 s
- T₇, Cooling period—0

4.13 **Test Description**—The procedure, as described in detail in Appendix A, consists of increasing steps of power, each level consisting of 200 engagements and one breakaway. Inspections are made of the reaction plates and friction assemblies at the end of each level. The different power levels are achieved by increasing the effective inertia while the stop time and initial engagement speed are kept constant at 0.5 s and 3600 r/min, respectively. The test is run at increasing power steps until the friction system has completely failed.

5. General Test Information

5.1 Clean—Prior to each test, the fixture and sump must be cleaned thoroughly and fixture and sump washed with solvent. The sump is then filled with the new test fluid.

5.2 Inspect—Inspect rotating shaft seal for deterioration and replace, if necessary. If this seal is replaced, also replace the nonrotating lip seals.

5.3 Soak—Soak friction elements in the test fluid for at least 10 min at room temperature,

5.4 Measure and Record—Measure and record the thickness of each friction element, after 5.3 before test and again after each test level at the same predetermined locations. A minimum of three locations, 120 degrees apart, at the approximate mean radius are to be identified by a durable mark and used for all measurements. The measurements from the various locations for each element are averaged and also averaged for the elements. These average changes in thickness from the original thickness are reported as the average cumulative loss of thickness.

Measurements are made with a flat anvil meter with a 3.175 mm minimum diameter and ± 0.0127 mm accuracy.

5.5 Mark Surfaces—Mark mating surfaces on the tab face of splines in sequence of assembly for orientation of the friction assemblies and reaction plates. The clutch pack must be disassembled and reassembled with the exact same orientation of the component with respect to each other and to the stationary splines in the housing. All markings should be visible from the cover end of the housing.

5.6 Install Clutch Pack—Install a reaction plate to contact the pressure plate. Follow with a friction assembly, reaction plate, and so on until all the required components have been installed. The last plate to be installed must be a reaction plate. Its thickness (spacer) must be selected to ensure that the pack clearance is as defined in 4.11. The pack configuration is PRFRFRFRSC, where P is the Piston, R is a Reaction plate, F is a Friction assembly, S the Spacer plate (as required), and C the Cover. Reaction plates may be used as the spacer.

Verify axial alignment of Hub oil holes and friction plates (see Appendix A).

5.7 Install Housing Cover—Start the circulation pump and the temperature controller to heat the fluid and internal elements to the required control temperature, as given in 4.10.

5.8 Install Flywheels—Install the flywheels required to achieve the effective inertia required for the power level to be evaluated.

5.9 Check Fluid Flow and Temperature—With the motor off, check that the fluid control temperature and the flow rate are as given in 4.10.

5.10 Start Test—Initiate the testing for the required level as defined in Appendix B. Determine pressure level to achieve the required 0.5 s stop time, as defined in 4.3.

- Always set the pressure to the low side of the estimated value as the test is to be aborted if the stop time EVER falls below 0.45 s as uncontrolled friction system damage may occur.
- Initiate the testing for the required level as defined in Appendix B.
- The stop time MUST be set, per 4.3, by the 20th engagement and maintained during the remaining 180 engagements.

5.11 End of Level Inspection—Shut down test stand. At the completion of the required dynamic engagements and the breakaway measurement, the housing is opened and the clutch pack carefully removed with special attention to ensure that the plates can be reinstalled in the exact same location and order relative to adjoining plates and fixed locations in the housing. Measurements are made of the friction element thickness as noted in 5.4. Observations of the conditions of the reaction plates and friction elements and the fluid are recorded. Photographs may be taken to show the condition of the plates and assemblies.

6. Data Acquisition

6.1 Data Acquisition Rate—For digital data acquisition systems the data is to be recorded at 1000 samples per second per channel using a 15 ms time constant RC filter. (Filtering will slew data. Preferred method is to record all raw data and manipulate later.)

6.2 Coefficient Calculations—Coefficients are calculated for the following dynamic coefficient¹ at every 25th engagement. (Reference SAE J1646)

- a. Midpoint dynamic – $50\% \mu_d$
- b. Endpoint dynamic – $\leq 100 \text{ ms} \mu_d \text{ Max}$ (Based on raw data single point value)

The breakaway coefficients, obtained every 200 dynamic engagements, is defined as:

$$\text{Breakaway coefficient} = 1.0 \mu_s 4.37$$

6.3 Data Averaging and Filtering—Data is to be averaged at the specified location in either the time or speed domain as specified in 6.1 with midpoint coefficient average values calculated using data points ± 80 ms on both sides of the required calculation point. Endpoint coefficient average values are calculated from non-filtered peak torque data measured in the last 100 ms of the engagement. For the 1000 Hz-sampling rate, the averages are based on 161 data points.

7. Data Reporting

7.1 Data Tables—A data table showing the friction material, spacer plate, and fluid along with the system performance at each level in terms of the coefficients given in 6.2 along with the average wear values and calculated E/M ratio are to be included in the test table. An example Table is given in Appendix B.

7.2 Figures—There are two figures required in reporting the results of this test. Examples of the two figures are given in Appendix C.

- a. Figure of the midpoint dynamic coefficient and the cumulative average plate wear versus the level number.
- b. Figure of the E/M ratio and breakaway coefficient versus level number.

If the system does not successfully complete both the 200 dynamic engagement and the breakaway test, there is no data reported for that level. Alternatively, only data for the successful completion of a level are to be reported. Failure is defined as complete destruction of the friction material/system. (Report number of cycles into level at which failure occurred.)

7.3 Optional Data—Instantaneous plots of the 50th and 200th dynamic engagements at each level may be provided. Additionally, comments and photographs on the condition of the plates at the end of each level may also be included. Examples of such optional data are shown in Appendix B.

APPENDIX A

A.1 This appendix contains the following prints describing the friction assembly, reaction plates, adapters, hub and pressure plates required for this test procedure.

TABLE A1—TEST COMPONENTS AND ASSEMBLY LAYOUT

File Name	Description
ITEM 1	Adapter Ring
ITEM 2	Separator Retainer
ITEM 3	Pressure Plate
ITEM 4	Friction Plate Hub
ITEM 5	Separator Plate
ITEM 6	Friction Plate Assembly
ITEM 7	Retaining Ring (External)
ITEM 8	Retaining Ring (Internal)
ITEM 9	3 Plate Spacer (10.18 Thick)
ITEM 10	4 Plate Spacer (6.45 Thick)
ITEM 11	Splined Hub Spacer
ITEM 12	Spiro-Lock Retaining Ring 3 Plate Assembly Cross Section 4 Plate Assembly Cross Section

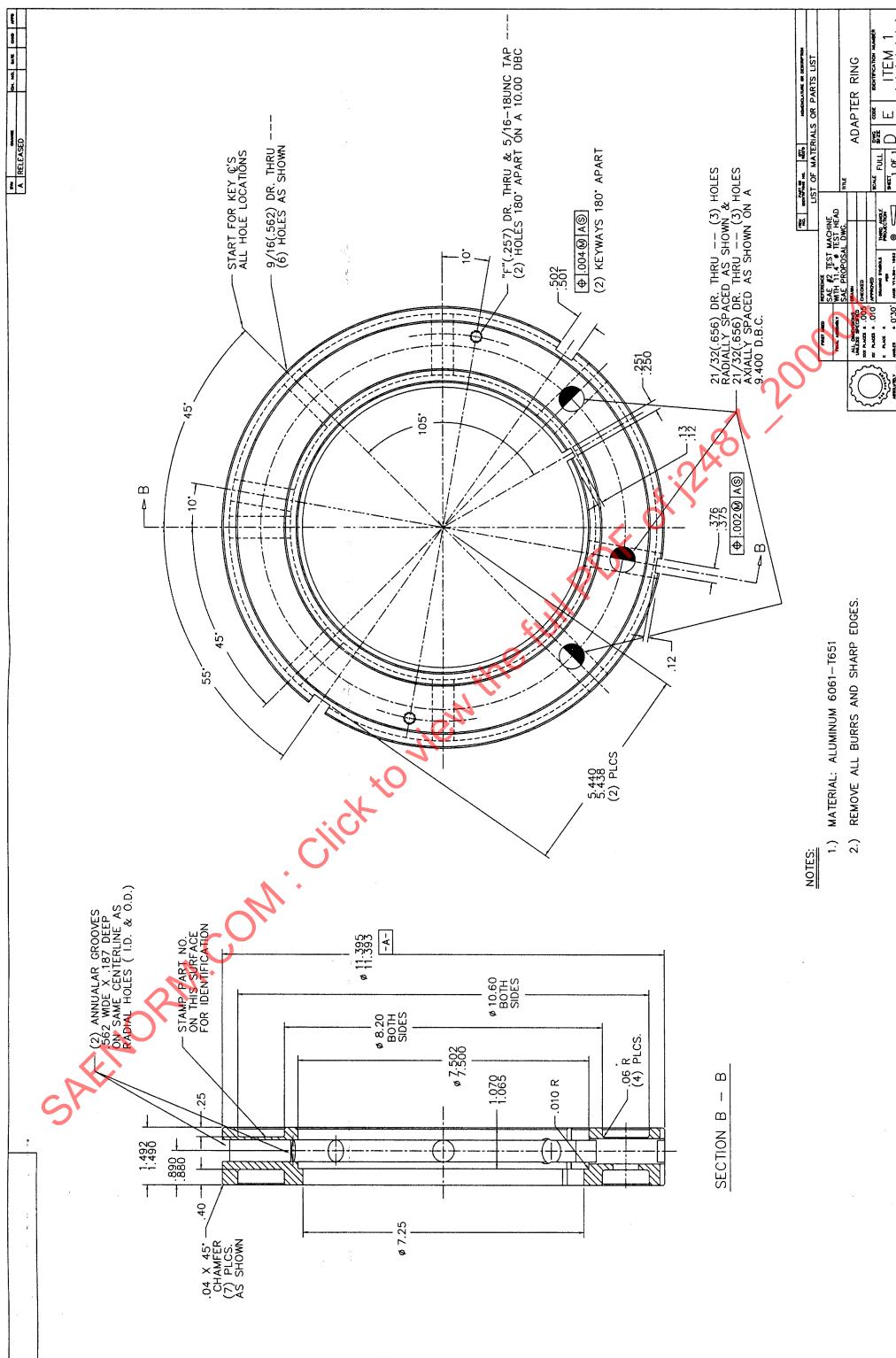


FIGURE A1—ITEM 1—ADAPTER RING

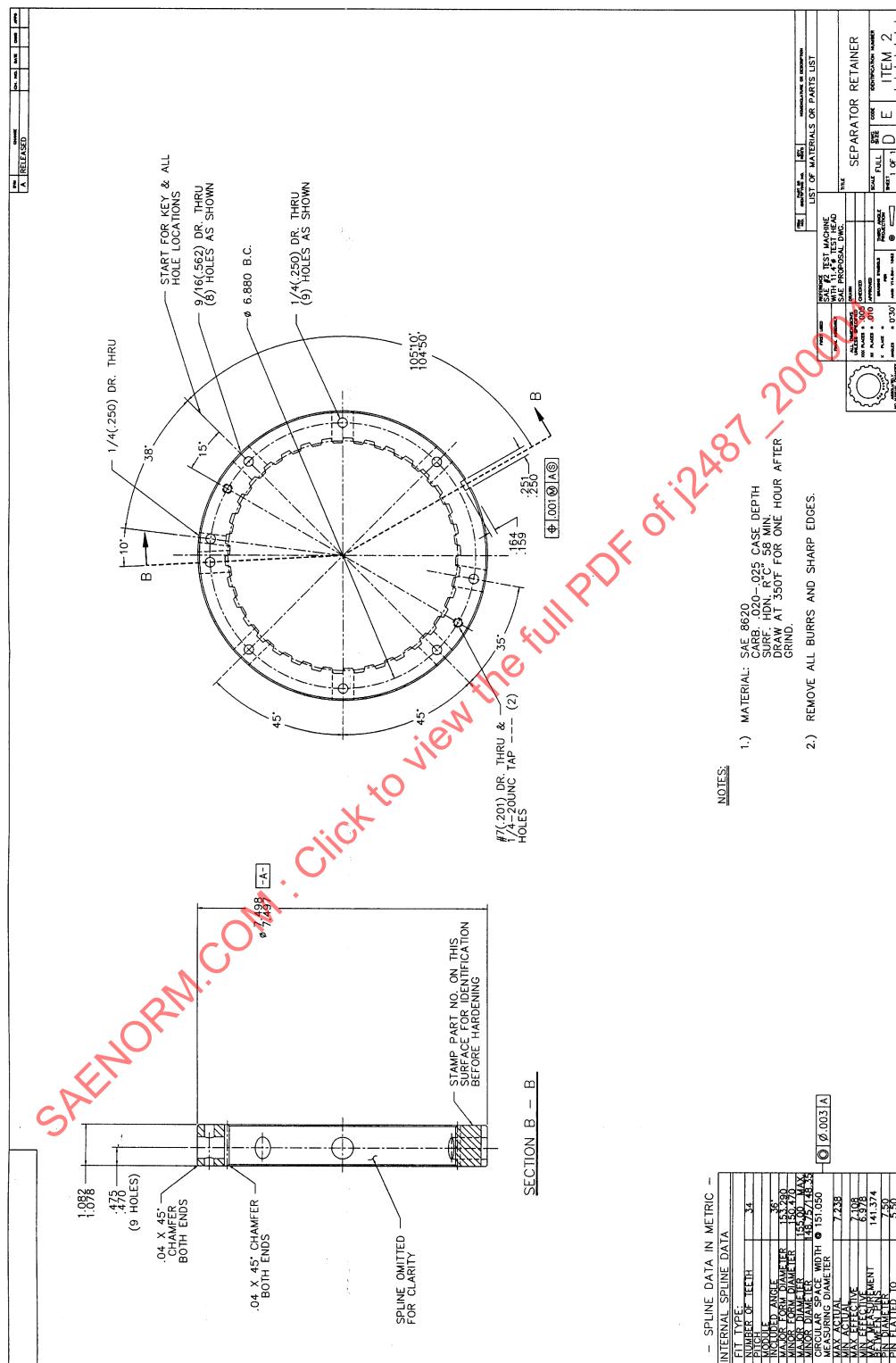


FIGURE A2—ITEM 2—SEPARATOR RETAINER

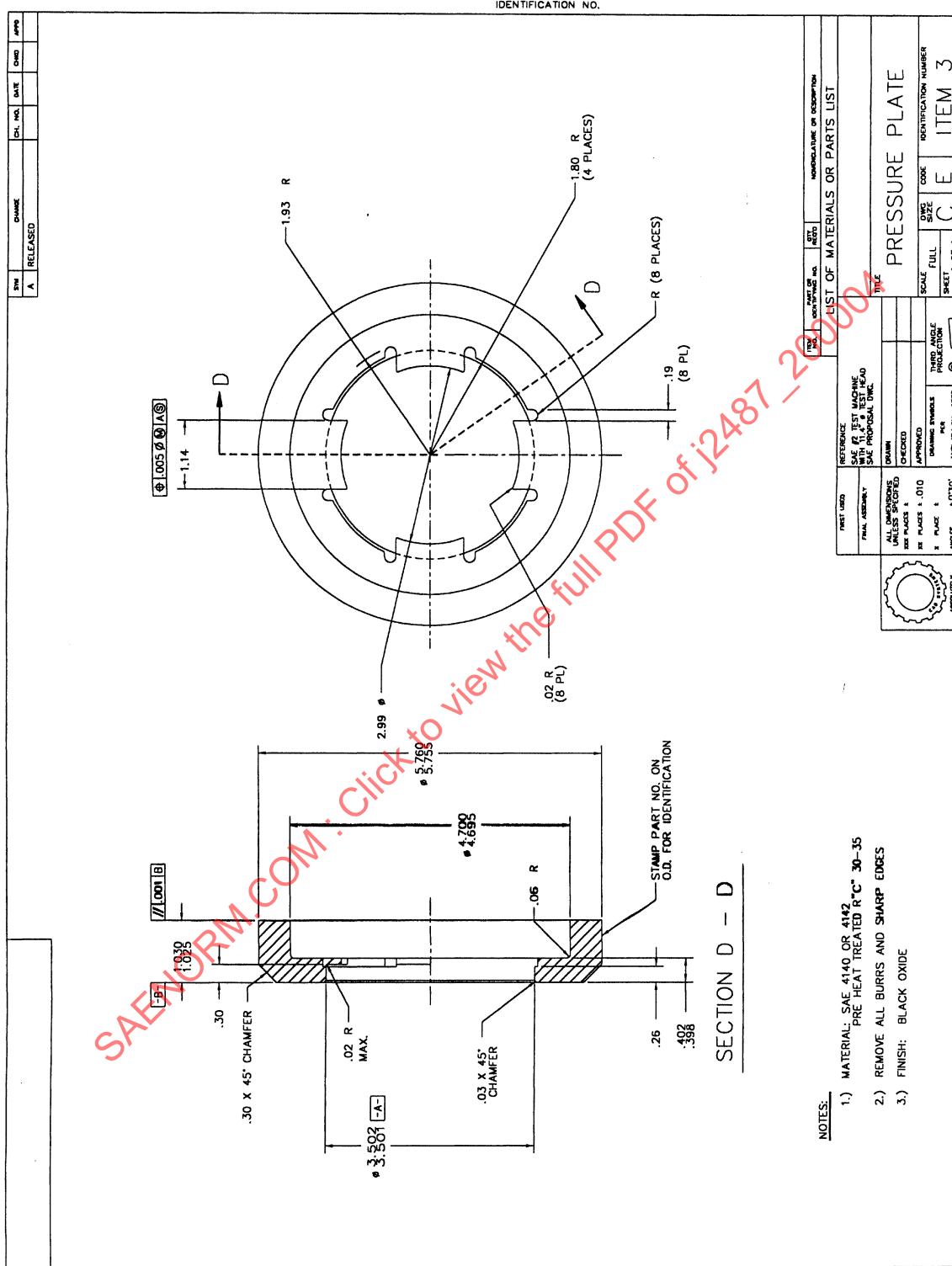


FIGURE A3—ITEM 3—PRESSURE PLATE

FIGURE A4—ITEM 4—FRICTION PLATE HUB

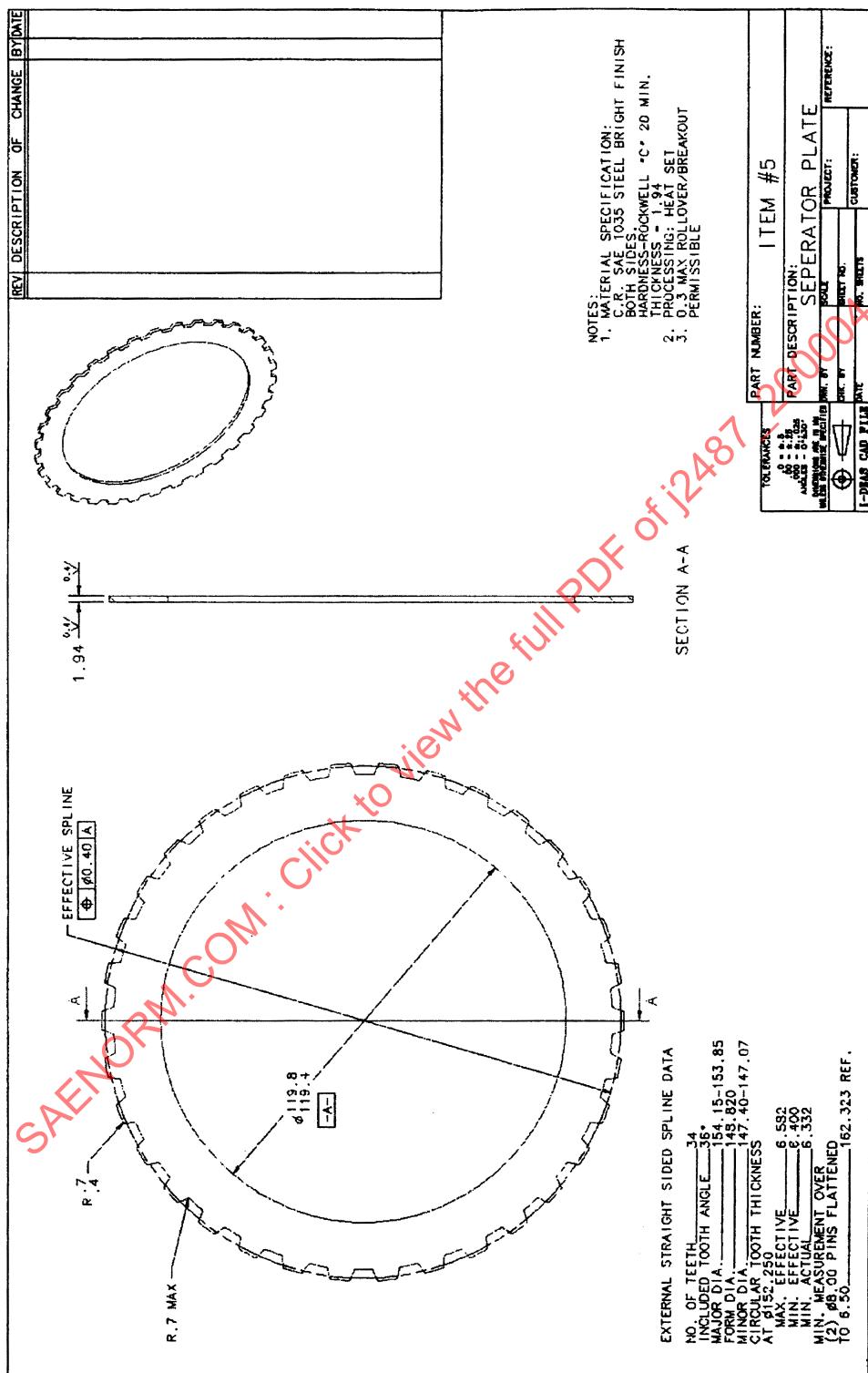


FIGURE A5—ITEM 5—SEPARATOR PLATE

METRIC
DIMENSIONS ARE IN MILLIMETERS
UNLESS OTHERWISE SPECIFIED

25 PARALLEL GROOVES
1 PASS(E_S)

120.55 DIA NOM.

146.15 DIA

1.70

0.50 MAX.

SECTION A-A
4 X SCALE

0.76 REF.

0.25

0.08

1.17

5.68 PITCH

GROOVE
CROSS-SECTION
4 X SCALE

NOTES:

1. PLATES MUST FALL FREELY BETWEEN FLAT STEEL PLATES SPACED AT THE MAX. PLATE THICKNESS, PLUS 0.18 (1.88 FOR STANDARD THICKNESS) APART AND AT AN ANGLE OF 70 DEGREES FROM THE HORIZONTAL.
2. FACING MUST NOT EXTEND INSIDE MAJOR DIAMETER OF SPLINE.
3. USE PRODUCTION GLUED CORE, ITEM 2, 1020, REF. A) CORE PLATE MATERIAL: SAE 1020, REF. B) CORE PLATE HARDNESS: R_B 90 MIN, REF.
4. FRICTION MATERIAL: AS SPECIFIED ON LAB. ORDER
5. APPLY LOT NUMBER, (IF APPLICABLE) AND LAB. ORDER NUMBER ON BOTH SIDES.
6. THICKNESS VARIATION NOT TO EXCEED 0.076.
7. REMOVE ALL BURRS, LOOSE PARTICLES AND SHARP EDGES.
8. LOCATION OF GROOVES ON ONE SIDE OF PLATE NEED NOT CONINCIDE WITH LOCATION OF GROOVES ON OTHER SIDE.
9. BOND CHECK PER SPECIFICATION S1-02-01.
10. MARK THIS DRAWING AS REQUIRED FOR VARIATIONS FROM STANDARD AND INCLUDE WITH PROTOTYPE LAB ORDER.

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INTERNAL INVOLUTE SPLINE DATA (REF)

FIT TYPE: SAE #2		METRIC	TITLE: SAE #2 TEST MACHINE WITH 11.4" TEST HEAD SAE PROPOSAL DNG.	
REF. SPOT	SIZE, MM	NUMBER OF TEETH	1	2
MODULE	—	63	TEST HEAD	ASSEMBLY
PRESSURE ANGLE	—	—	TEST	FRICITION PLATE
BASE DIAMETER	30.0000	—	PLATE	—
MAJOR DIAMETER	115.682 NOM.	—	SPACED	—
MAJOR DIAMETER	118.262 MAX.	—	OTHERWISE	—
FORM DIAMETER	116.779 NOM.	—	NOTES	—
MINOR DIAMETER	114.960/114.80	—	—	—
CIRCULAR SPACE WIDTH	—	—	—	—
MAX. ACTUAL	3.134	—	—	—
MIN. ACTUAL	—	—	—	—
MAX. EFFECTIVE	3.010	—	—	—
MIN. EFFECTIVE	2.883	—	—	—
MAX. MEASUREMENT	—	—	—	—
BETWEEN PINS	110.383/10.383	—	—	—
PIN DIAMETER	—	—	—	—
TOOLING LAYOUT DNG.	3.551	—	—	—

CAD DRAWING
NO. 100004

REFERENCE	APPROVED	CHIEF ENGINEER	TEST HEAD	TEST PLATE	FRICITION PLATE	ASSEMBLY
ITEM	REV.	NAME	TEST	TEST	TEST	TEST
1	1	—	—	—	—	—
2	1	—	—	—	—	—
3	1	—	—	—	—	—
4	1	—	—	—	—	—
5	1	—	—	—	—	—
6	1	—	—	—	—	—
7	1	—	—	—	—	—
8	1	—	—	—	—	—
9	1	—	—	—	—	—
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89	1	—	—	—	—	—
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105	1	—	—	—	—	—
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109	1	—	—	—	—	—
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113	1	—	—	—	—	—
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116	1	—	—	—	—	—
117	1	—	—	—	—	—
118	1	—	—	—	—	—
119	1	—	—	—	—	—
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121	1	—	—	—	—	—
122	1	—	—	—	—	—
123	1	—	—	—	—	—
124	1	—	—	—	—	—
125	1	—	—	—	—	—
126	1	—	—	—	—	—
127	1	—	—	—	—	—
128	1	—	—	—	—	—
129	1	—	—	—	—	—
130	1	—	—	—	—	—
131	1	—	—	—	—	—
132	1	—	—	—	—	—
133	1	—	—	—	—	—
134	1	—	—	—	—	—
135	1	—	—	—	—	—
136	1	—	—	—	—	—
137	1	—	—	—	—	—
138	1	—	—	—	—	—
139	1	—	—	—	—	—
140	1	—	—	—	—	—
141	1	—	—	—	—	—
142	1	—	—	—	—	—
143	1	—	—	—	—	—
144	1	—	—	—	—	—
145	1	—	—	—	—	—
146	1	—	—	—	—	—
147	1	—	—	—	—	—
148	1	—	—	—	—	—
149	1	—	—	—	—	—
150	1	—	—	—	—	—
151	1	—	—	—	—	—
152	1	—	—	—	—	—
153	1	—	—	—	—	—
154	1	—	—	—	—	—
155	1	—	—	—	—	—
156	1	—	—	—	—	—
157	1	—	—	—	—	—
158	1	—	—	—	—	—
159	1	—	—	—	—	—
160	1	—	—	—	—	—
161	1	—	—	—	—	—
162	1	—	—	—	—	—
163	1	—	—	—	—	—
164	1	—	—	—	—	—
165	1	—	—	—	—	—
166	1	—	—	—	—	—
167	1	—	—	—	—	—
168	1	—	—	—	—	—
169	1	—	—	—	—	—
170	1	—	—	—	—	—
171	1	—	—	—	—	—
172	1	—	—	—	—	—
173	1	—	—	—	—	—
174	1	—	—	—	—	—
175	1	—	—	—	—	—
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178	1	—	—	—	—	—
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180	1	—	—	—	—	—
181	1	—	—	—	—	—
182	1	—	—	—	—	—
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184	1	—	—	—	—	—
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216	1	—	—	—	—	—
217	1	—	—	—	—	—
218	1	—	—	—	—	—
219	1	—	—	—	—	—
220	1	—	—	—	—	—
221	1	—	—	—	—	—
222	1	—	—	—	—	—
223	1	—	—	—	—	—
224	1	—	—</			

FIGURE A6—ITEM 6—FRICTION PLATE ASSEMBLY

SYM	CHANGE	CH. NO.	DATE	CHKD	APPD
A	RELEASED				

RETAINING RING

EXTERNAL, MEDIUM - HEAVY DUTY SERIES RST

SHAFT DIA. : 2.375

FREE DIA. : 2.248 : +.000, -.025

THICKNESS : .078 ± .003

PART NO. : RST-237

MFR. : SPIROLOX RETAINING RINGS
KAYDON RING AND SEAL, INC.

ITEM NO.	PART OR IDENTIFYING NO.	QTY	REF'D	NOMENCLATURE OR DESCRIPTION	
LIST OF MATERIALS OR PARTS LIST					
TITLE RETAINING RING (EXTERNAL)					
FIRST USED FINAL ASSEMBLY		REFERENCE SAE #2 TEST MACHINE WITH 11.4" Ø TEST HEAD			
ALL DIMENSIONS UNLESS SPECIFIED		DRAWN CHECKED			
<input checked="" type="checkbox"/> PLACES ± <input checked="" type="checkbox"/> PLACES ± <input checked="" type="checkbox"/> PLACE ± <input checked="" type="checkbox"/> ANGLES ±		APPROVED DRAWING SYMBOLS PER ANSI Y14.5M- 1982 			
		SCALE	NONE	DWG SIZE	CODE
		SHEET 1	OF 1	A	P
		ITEM 7			

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J2487

FIGURE A7—ITEM 7—RETAINING RING (EXTERNAL)

SYM	CHANGE	CH. NO.	DATE	CHKD	APPD
A	RELEASED				

RETAINING RING					
<p>BASIC INTERNAL SERIES N5000</p> <p>HOUSING DIA. : 3.125</p> <p>FREE DIA. : 3.488 \pm 0.055</p> <p>THICKNESS : .109 \pm .003</p> <p>PART NO. : N5000-312</p> <p>MFR. : WALDES TRUARC RETAINING RINGS</p>					

ITEM NO.	PART OR IDENTIFYING NO.	QTY REQ'D	NOMENCLATURE OR DESCRIPTION		
LIST OF MATERIALS OR PARTS LIST					

FIRST USED		REFERENCE		TITLE	
FINAL ASSEMBLY		SAE #2 TEST MACHINE WITH 11.4" ϕ TEST HEAD SAE PROPOSAL DWG.		RETAINING RING (INTERNAL)	
ALL DIMENSIONS UNLESS SPECIFIED		DRAWN CHECKED			
XX PLACES \pm	XX PLACES \pm	APPROVED		SCALE	CODE
X PLACE \pm	X PLACE \pm	DRAWING SYMBOLS PER ANSI Y14.5M- 1982	THIRD ANGLE PROJECTION ①	NONE	ITEM
ANGLES \pm				SHEET 1 OF 1	8

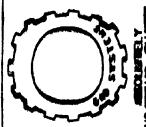


FIGURE A8—ITEM 8—RETAINING RING (INTERNAL)

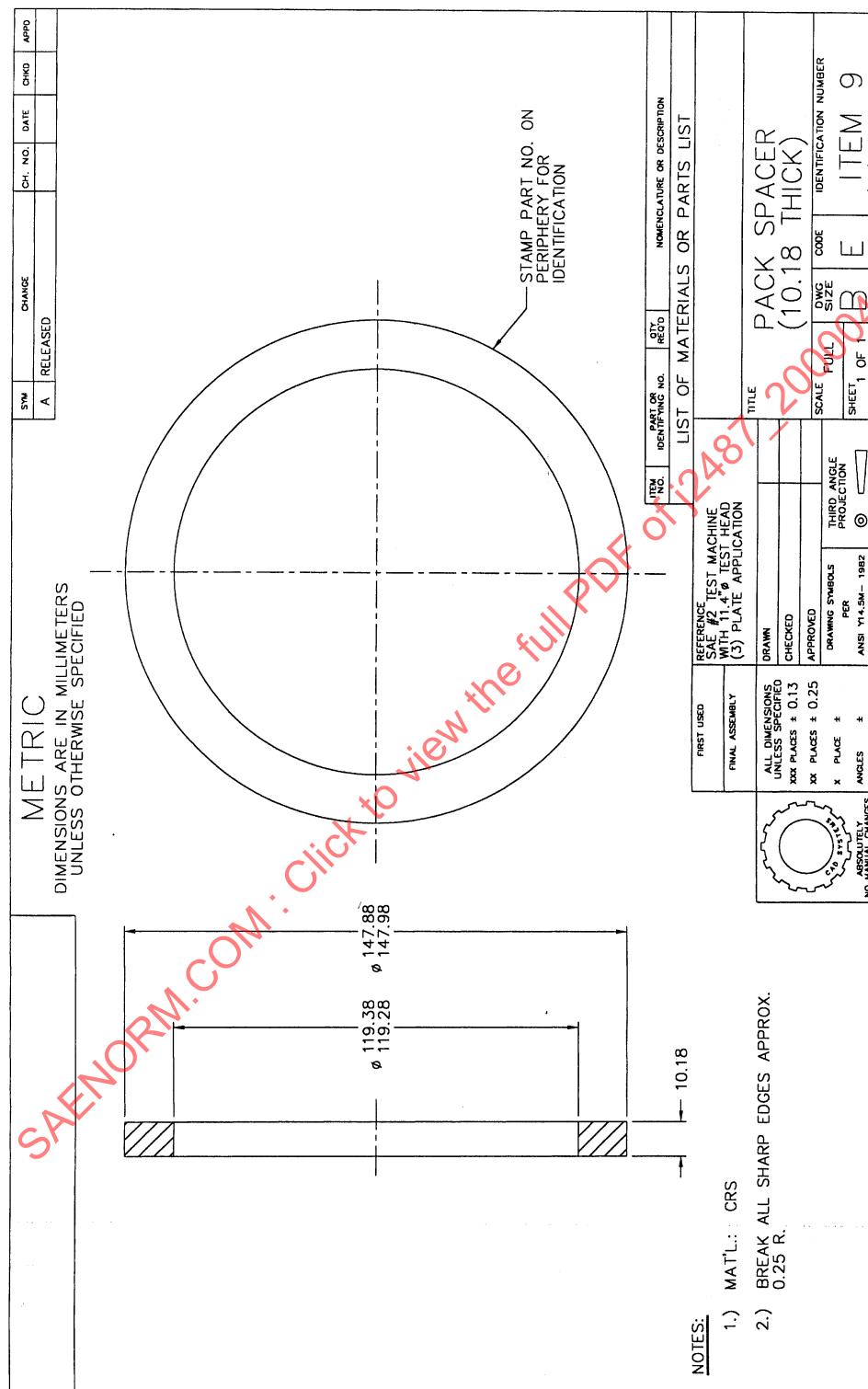


FIGURE A9—ITEM 9—3 PLATE SPACER (10.18 THICK)

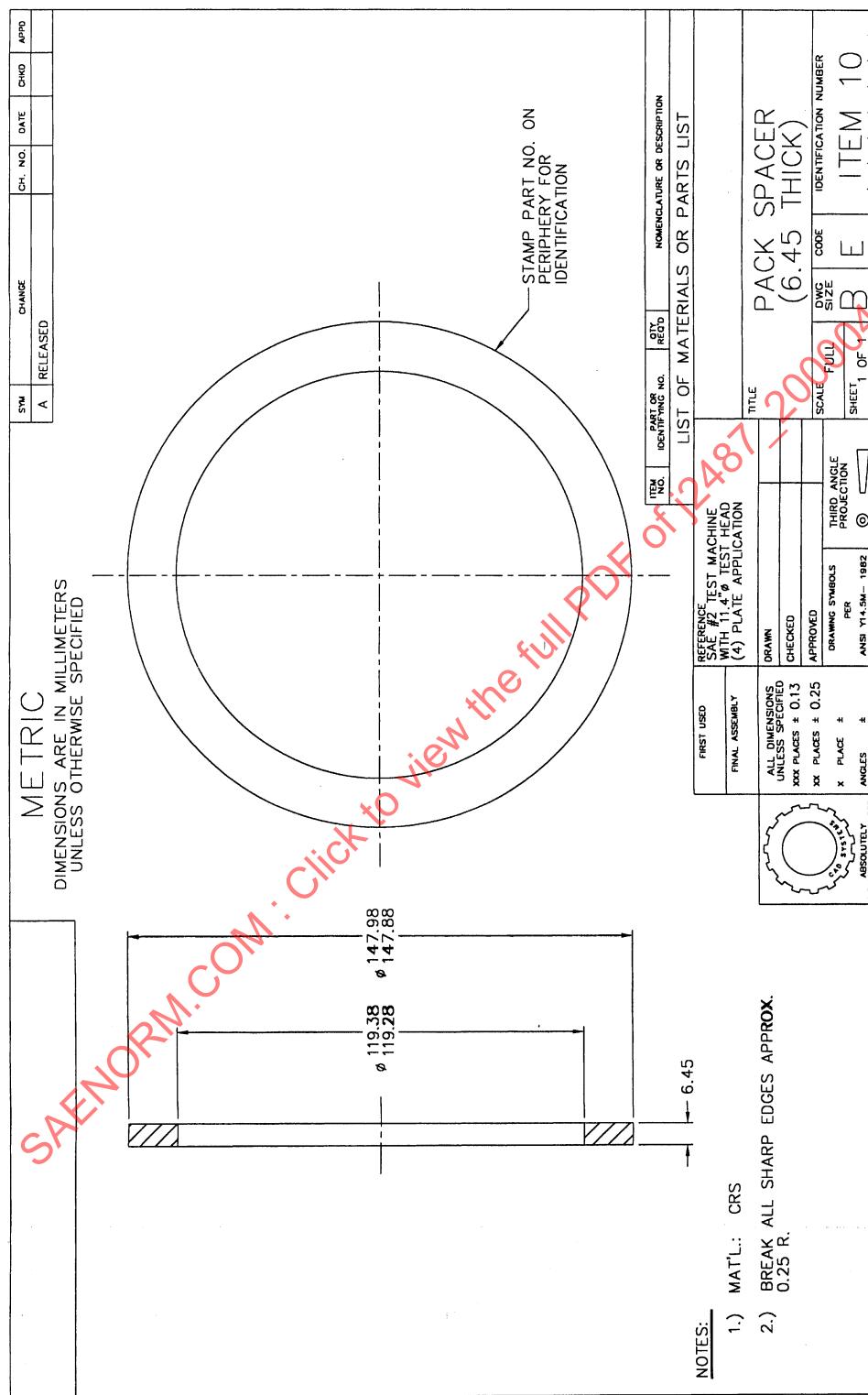


FIGURE A10—ITEM 10—4 PLATE SPACER (6.45 THICK) (ONLY FOR SAE J2490)

STW	CHANGE	CH. NO.	DATE	CHG APPRO																																																																																																										
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<p style="text-align: center;">- SPLINE DATA IN METRIC -</p> <p>INTERNAL INVOLUTE SPLINE DATA</p> <table border="1"> <thead> <tr> <th colspan="2">FIT TYPE:</th> <th colspan="2">NOTES:</th> <th rowspan="2">NONCUTATURE OR DESCRIPTION</th> </tr> <tr> <th>NUMBER OF TEETH</th> <th>56</th> <th>CAD</th> <th>DRAWN</th> </tr> </thead> <tbody> <tr> <td>PITCH</td> <td>1.0583</td> <td>DRAWING</td> <td>ITEM NO.</td> <td>ITEM NO.</td> </tr> <tr> <td>MODULE</td> <td>30*</td> <td>CHECKED</td> <td>QTY</td> <td>QTY</td> </tr> <tr> <td>PRESSURE ANGLE</td> <td></td> <td></td> <td>NOTIFICATION NUMBER</td> <td>NOTIFICATION NUMBER</td> </tr> <tr> <td>BASE DIAMETER (REF)</td> <td>51.326</td> <td></td> <td></td> <td></td> </tr> <tr> <td>PITCH DIAMETER (REF)</td> <td>59.2658</td> <td></td> <td></td> <td></td> </tr> <tr> <td>MAJOR DIAMETER</td> <td>61.194/61.171</td> <td></td> <td></td> <td></td> </tr> <tr> <td>FORM DIAMETER (TIF)</td> <td>60.129</td> <td></td> <td></td> <td></td> </tr> <tr> <td>MINOR DIAMETER</td> <td>58.222/58.209</td> <td></td> <td></td> <td></td> </tr> <tr> <td>CIRCULAR SPACE</td> <td>WIDTH</td> <td></td> <td></td> <td></td> </tr> <tr> <td>MAX ACTUAL</td> <td>1.796</td> <td></td> <td></td> <td></td> </tr> <tr> <td>MIN ACTUAL</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>MAX EFFECTIVE</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>MIN EFFECTIVE</td> <td>1.712</td> <td></td> <td></td> <td></td> </tr> <tr> <td>MEASUREMENT BETWEEN PINS</td> <td>56.92/56.87</td> <td></td> <td></td> <td></td> </tr> <tr> <td>PIN DIAMETER</td> <td>1.83</td> <td></td> <td></td> <td></td> </tr> <tr> <td>PINS FLATTED TO</td> <td>1.73</td> <td></td> <td></td> <td></td> </tr> </tbody> </table>					FIT TYPE:		NOTES:		NONCUTATURE OR DESCRIPTION	NUMBER OF TEETH	56	CAD	DRAWN	PITCH	1.0583	DRAWING	ITEM NO.	ITEM NO.	MODULE	30*	CHECKED	QTY	QTY	PRESSURE ANGLE			NOTIFICATION NUMBER	NOTIFICATION NUMBER	BASE DIAMETER (REF)	51.326				PITCH DIAMETER (REF)	59.2658				MAJOR DIAMETER	61.194/61.171				FORM DIAMETER (TIF)	60.129				MINOR DIAMETER	58.222/58.209				CIRCULAR SPACE	WIDTH				MAX ACTUAL	1.796				MIN ACTUAL					MAX EFFECTIVE					MIN EFFECTIVE	1.712				MEASUREMENT BETWEEN PINS	56.92/56.87				PIN DIAMETER	1.83				PINS FLATTED TO	1.73																				
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FIGURE A11—ITEM 11—SPLINED HUB SPACER

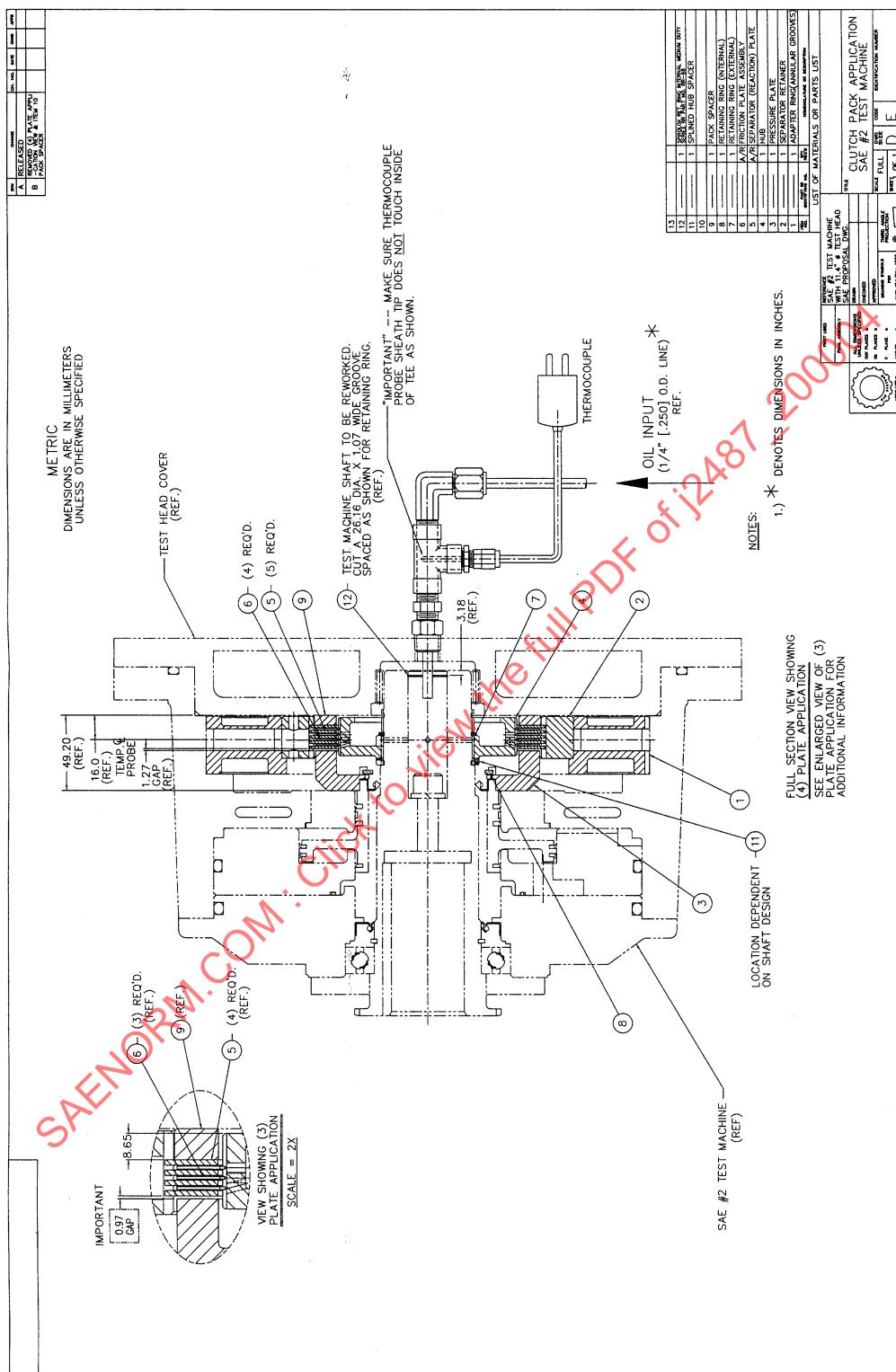


FIGURE A12A—ITEM 12 A—SPIRO-LOCK RETAINING RING
3 PLATE ASSEMBLY CROSS SECTION

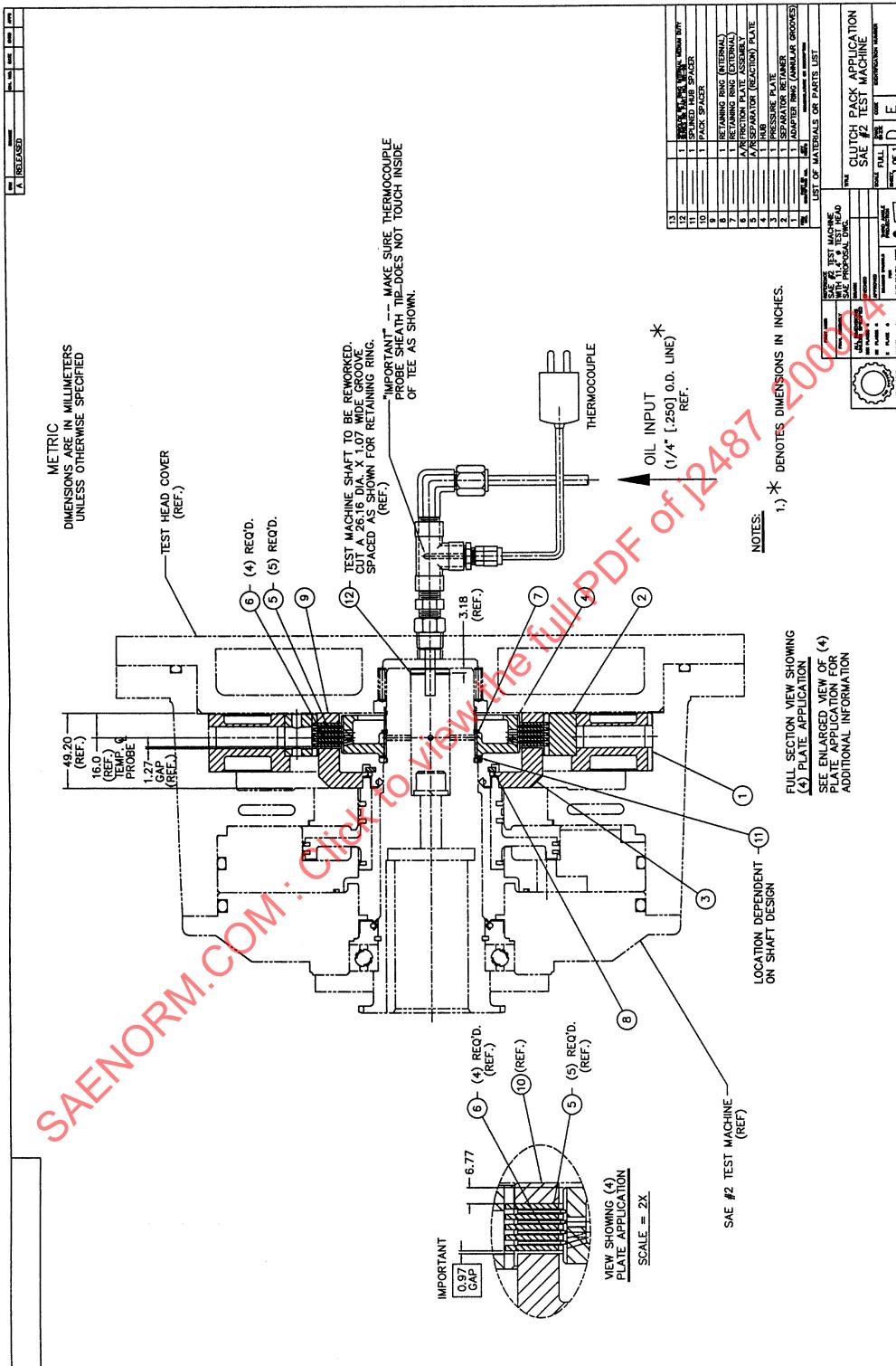


FIGURE A12B—ITEM 12B—SPIRO-LOCK RETAINING RING
4 PLATE ASSEMBLY CROSS SECTION