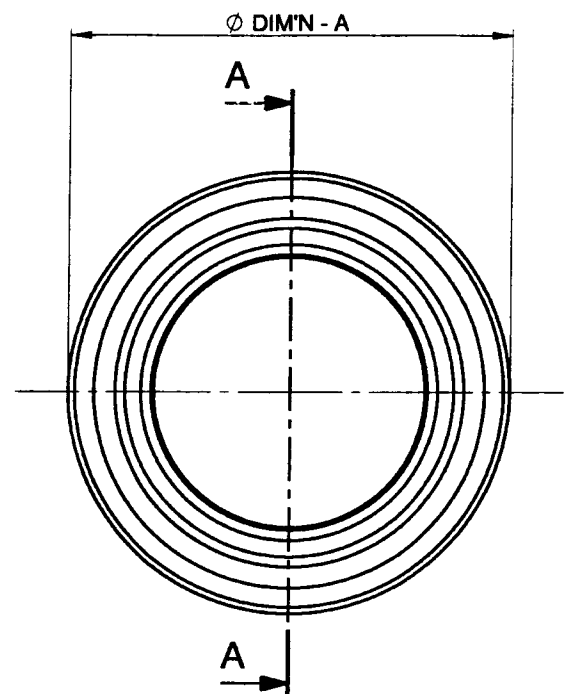
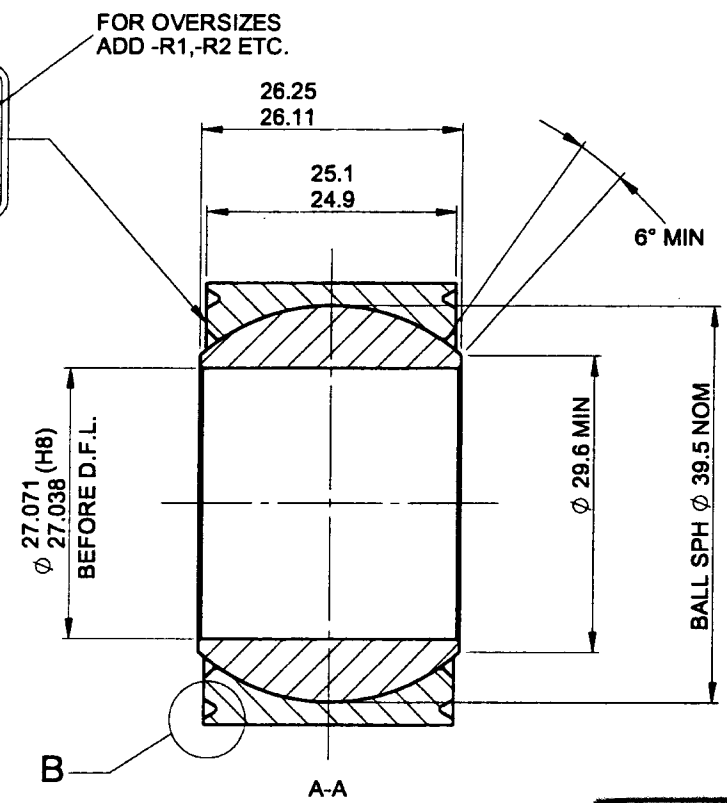


SHEET No **1** DATE 21/10/2004
 PART No **MSTLG27DE** SIG. RJM
 CODE **Z** SHT SIZE **A3**
 NMB-Minebea UK Ltd. Doddington Road, Lincoln, England, LN6 3RA A Minebea Company.
 DESCRIPTION
 NAME CHANGED TO NMB UK IN PART MARKING, DRAWING SHEET UPDATED.
 ISSUE **12**

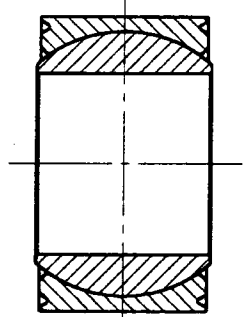
DIMN - A	NMB UK P/N
44.0 k6	MSTLG27DE
44.1 k6	MSTLG27DE-R1
44.2 k6	MSTLG27DE-R2
44.3 k6	MSTLG27DE-R3
44.4 k6	MSTLG27DE-R4



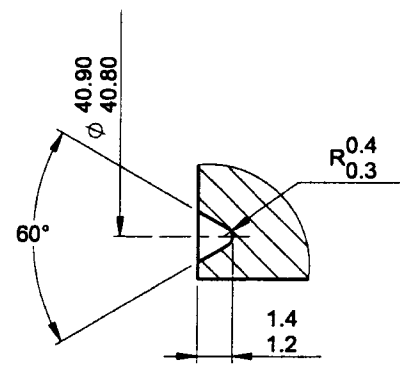
DOT PEEN TO R-R SPEC JES 131-2
 NMB UK
 MSTLG27DE
 BATCH No.



UNCONTROLLED DOCUMENT



ACTUAL SIZE (1 : 1)



B (4 : 1)

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- NOTES:-**
1. FIT: DIAMETRAL CLEARANCE = 0.020 mm MAX. BALL TO BE FREE TO ROTATE BY HAND AT 20° C
 2. OPERATING TEMPERATURE RANGE -54°C to 398°C
 3. PARTS TO BE MARKED IN ACCORDANCE WITH R-R SPECIFICATION JES 131.
 4. PACKAGING IN ACCORDANCE WITH R-R SPECIFICATION SQM 016.
 5. PROCUREMENT IN ACCORDANCE WITH R-R SPECIFICATION ACS 9106.
 6. QUALITY CONTROL IN ACCORDANCE WITH R-R SPECIFICATION ACS 9106.
 7. THIS UNIT WILL MEET THE REQUIREMENTS STATED ON R-R SOURCE CONTROL DRAWING.
 8. BEARING RACE AND BALL TO BE M.I.P BEFORE SWAGING TO NMB UK SPEC NDT 2. AFTER ASSEMBLY TO RPS700.
 9. SURFACE TEXTURE: BALL SPH. DIA Ra 0.2 MAX / BALL BORE, FACES AND RACE O.D. Ra 0.8 ALL OTHER SURFACES Ra 3.2 MAX.
 10. METHOD OF ASSEMBLY: BALL INTO RACE BY NMB UK MANUFACTURING METHOD OF SWAGING OUTER RACE AROUND BALL. BEARING INTO INTERCASE BY STAKING LIP OVER ON BOTH SIDES OF RACE. (REF NMB UK PROCEDURE PP05)
 11. FIRE PRECAUTIONS: THIS BEARING IS NON-FLAMMABLE IN THE INSTALLED CONDITION.

OFFICE REF. Volvo Aero Corp. Enq No U020405	TOLERANCE UNLESS OTHERWISE STATED GENERAL TOLERANCE XXX ±0.25 XX ±0.75 X ±0.25 DRILLED HOLES ±0.25 -0.05 ANGULAR TOLERANCE ±0.5°	NMB - Minebea UK Ltd.	
WEIGHT MAXIMUM 162 g	SHEET SIZE A3	DRAWN RJM 24/04/2002	DESCRIPTION SPHERICAL BEARING
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN MILLIMETRES.	SCALE 3:2	CHKD. SP 24/04/2002	CODE PART. No Z MSTLG27DE
		APPRV GAR 06/09/2002	SHEET No 1
DO NOT SCALE DRAWING		CAD GENERATED DRAWING DO NOT MANUALLY UPDATE	CAD FILE 020030
		DOC. TYPE MA	ISSUE 12

SPECIFICATION
 RACE : CRES STEEL, AMS 5643 H1150 TO R-R PROCUREMENT SPEC RPS905, COATED ON TRACK WITH DRY FILM LUB. PL239 TO R-R SPEC. RPS661/10
 BALL : CRES STEEL, AMS 5643 H925 TO R-R PROCUREMENT SPEC RPS905, HEAT TREAT TO THE REQUIREMENTS OF R-R SPEC RPS953 (BY APPROVED SUPPLIER), COATED IN BORE WITH DRY FILM LUB. PL239 TO R-R SPEC. RPS661/10
Re Issue 12 10/4/06