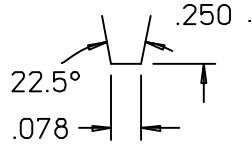
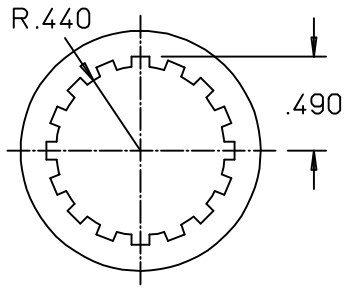
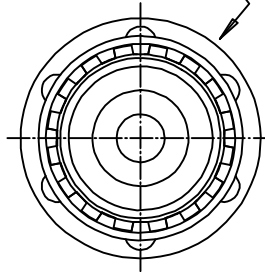


B	11/10/96	ADDED FLANGE AND SHAFT DIMENSIONS
C	08/15/06	CHANGED LENGTH, ADDED ALTERNATE SPLINE

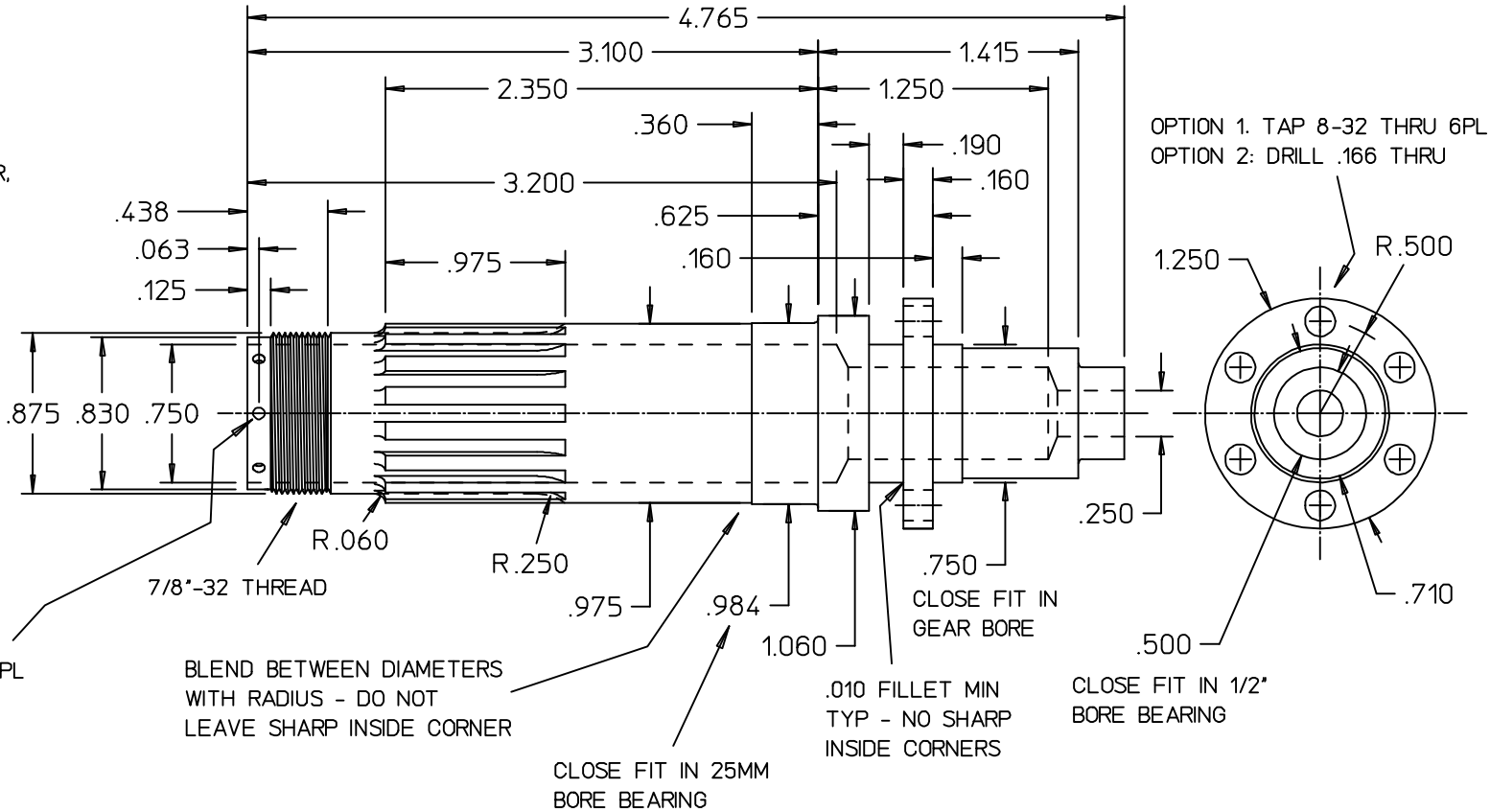


ALTERNATE SPLINE: MAKE TEST HUB USING 3/32" KEYWAY BROACH AS SHOWN. MAKE 22.5° 1/2" DIAM. CUTTER WITH .078" TIP AS SHOWN. CAN BE MADE FROM 1/8" TOOL BIT HELD IN 3/8" DIAM ROD (1/2" CUTTING DIAM NOT CRITICAL) CUT GROOVES IN PROPSHAFT GRADUALLY DEEPER UNTIL HUB JUST SLIDES ON.

EASY SPLINE METHOD USING 3/32" X 1/2" DIA WOODRUFF KEY CUTTER, CUT 16 SPLINES AT 22.5° INTERVALS



DRILL 1/16" THRU 8PL AT 45° INTERVALS



OPTION 1. TAP 8-32 THRU 6PL
OPTION 2. DRILL .166 THRU

FABRICATION NOTES:

1. DRILL ROD UNDERSIZE, EXCEPT FOR 1/4" DRILL THRU. FINISH INSIDE WITH BORING BAR WITH SLIGHTLY RADIUSSED TIP - NEVER LEAVE SHARP INSIDE CORNERS ON A PART SUBJECT TO CYCLICAL STRESSES!

MATERIAL: 1 1/4" 4130 ROD

SCALE PROPSHAFT

1200 C

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