

US ARMY AVIATION AND MISSILE COMMAND

SPARES TECHNICAL DATA PACKAGE

<p>PACKAGE NUMBER 204-010-765</p> <p>TITLE CONTROL NUT, Pitch - Tail Rotor, Assembly of</p>
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APPLICABLE TO: P/N 204-010-765-1
 END ITEM: UH-1
 FEDERAL SUPPLY CODE: 81996

CONTROLLED

DISTRIBUTION STATEMENT A
 APPROVED FOR PUBLIC RELEASE
 DISTRIBUTION IS UNLIMITED

PREPARED BY <i>Walter F. Tidwell</i>	DATE <i>19 July 74</i>
APPROVAL <i>Walter F. Tidwell</i>	DATE <i>19 July 74</i>
PRODUCT ASSURANCE DIR <i>Paul Noltensmeyer</i>	DATE <i>22 July '74</i>

REVISIONS

SYM	DESCRIPTION	DATE	APPROVED
A	Changed package to latest format and added Bell Helicopter as source.	14 Feb 75	<i>E. Bergman</i>
B	Added new Source of Supply to Appendix B	2 Aug 76	<i>E. Bergman</i>
C	Added new Source of Supply to Appendix B	3 Nov 76	<i>J. Williams</i>
D	Removed Murdock Machine & Engr. Co from Appendix B and corrected Command Title.	18 Jan 79	<i>W. Tidwell</i>
E	Corrected vendor name.	12 Dec 79	<i>W. Tidwell</i>
F	Revised to new format. Established criteria for approving sources.	27 Apr 84	<i>Samuel W. Coffman</i>

PROCUREMENT PACKAGE REVISIONS (CONTINUATION)

PROCUREMENT PACKAGE NO

204-010-765

SYM	DESCRIPTION	DATE	APPROVED
G	Added Conover Company as an approved source and corrected Chromalloy FSCM. Re-coded Sector 28 to show First Article Test Requirement. Also added B&M Machine.	13 Feb 85	<i>Sam J.W.</i>
H	completely rewritten to new format.	5 Feb. 96	<i>[Signature]</i>
J	Revised to comply with the current S.O.P.	4/19/02	<i>[Signature]</i>

204-010-765 81086 PP J 0002 0001 LU LN
November 5, 2002 8:32 AM

**SPARES TECHNICAL DATA PACKAGE
204-010-765**

TITLE: Control Nut, Pitch - Tail Rotor, Assembly of

1. SCOPE

This technical data package covers technical requirements for manufacture of the item(s) specified by the solicitation or contract. The document listed in paragraph 2, with revisions as noted in the accompanying Tech Data Package List (identified by procurement package "PP" number and date) are part of this package to the extent specified herein. All military, federal, and commercial or industry specifications appearing hereon or on referenced documents, are part of this procurement package to the extent specified, and shall be the issue in effect on the date of the solicitation, unless otherwise specified. In the event of conflict between drawings, specifications, and package requirements, the order of precedence is as follows: (a) The requirements of the remainder of this package (paragraphs 3 and following). (b) Drawings. (c) Specs or standards appearing hereon or on referenced documents. (d) Other referenced documents.

2. ACCOMPANYING DOCUMENTS

a.	Bell Helicopter Company	CAGE 97499	DWG 204-010-765
b.	U S Army ATCOM	CAGE 81996	DWG SS204-010-765
c.	Bell Helicopter Company	CAGE 97499	SPEC BPS4089
d.	Bell Helicopter Company	CAGE 97499	SPEC BPS4138
e.	Bell Helicopter Company	CAGE 97499	SPEC BPS4389

3. INTERPRETATION OF CODES, SPECIFICATIONS AND NOTES

a. For drawing 204-010-765:

- (1) Disregard Finish Spec. 204-947-002 and Finish Code 299-099-031.
- (2) Disregard drawing notes 8, 10 and 11.
- (3) Replace MIL-I-6866 with MIL-STD-6866.
- (4) Machine surfaces per ANSI B46.1.
- (5) Replace MIL-B-6946, QQ-B-663 and QQ-C-465 with ASTM B150, copper alloy UNS number C63000.
- (6) Disregard drawing note 1. Mark parts per AS478-30 on either the .750 outside diameter or the .9835/.9840 outside diameter.
- (7) In the List of Materials, replace T-T-V-119 with TT-V-119.

SPARES TECHNICAL DATA PACKAGE

204-010-765

APPENDIX A

QUALIFICATION REQUIREMENTS

PART NUMBER: 204-010-765-1

TITLE: CONTROL UNIT, PITCH – TAIL ROTOR ASSEMBLY OF

NSN: 1615-00-691-2141

1. All new sources shall meet the following requirements prior to being approved as a source for these parts:

(a). It is required that all-prospective new sources submit a Source Approval Request (SAR) for the parts covered by this Spares Technical Data Package (STDP). The SAR must be submitted in accordance with AMCOM Competition Advocates Shopping List Instructions. For a copy of these instructions, contact the AMCOM Source Development Officer at (256) 313-4924.

IDENTIFICATION OF PRODUCT:

Each part shall be clearly marked with the AMCOM CAGE code (81996), part number as specified on the contract; the vendor's CAGE code; and serial number if required by this STDP. Part Marking shall conform to BPS4050 and AS478, and as a minimum contain the information shown in the example below. Contract numbers need not be marked on the part unless specified by this STDP. For further marking requirements see paragraph 3.a.6.

Example: 81996/204-010-765-1
MFR (Your CAGE)

The design activity code for AMCOM, 81996, shall only be used on parts submitted to and accepted by the Government under an AMCOM contract. This code shall not appear on any part sold commercially, whether to a Government buyer or a civilian supplies house. Packaging markings may also be required, see the specific requirements on the contract for details.

ACCEPTANCE:

Acceptance of this item shall be based on satisfactory compliance with all requirements of this package.

DEVIATIONS/WAIVERS:

Deviations/waivers from this package and/or referenced specifications by the contractor shall not be permitted without prior written approval from the contracting officer. Deviations or waivers shall be requested per the contract requirements.

DISCREPANCIES:

All discrepancies of this package should be reported to the contracting officer immediately upon discovery.

NOTICE TO ALL PERSONS RECEIVING THIS DATA PACKAGE:

This package is only conditionally issued by the United States Government and neither receipt nor possession thereof confers or transfers any right in, or license to use the subject matter of the drawing, or any design or technical information shown thereon, nor any right to reproduce this nor any information contained therein may be copied, reproduced, or otherwise used, except for the manufacture for the Government of the particular item requested, and in strict accordance with the related and particular Government procurement action under which the package was furnished.

QUALITY ASSURANCE PROVISIONS:

- General: In accordance with the drawings and specifications of this technical data package.
- Additional: In accordance with QE-STD-1.

SPARES TECHNICAL DATA PACKAGE 204-010-765

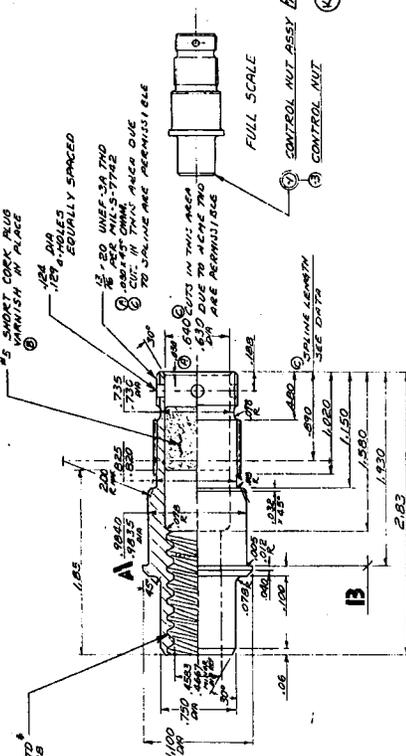
TITLE: Control Nut, Pitch - Tail Rotor, Assembly of

**APPENDIX A
QUALIFICATION REQUIREMENTS**

1. Qualification requirements for new sources for this part follow. All new sources for this part will meet these requirements prior to being approved as a source for this part.

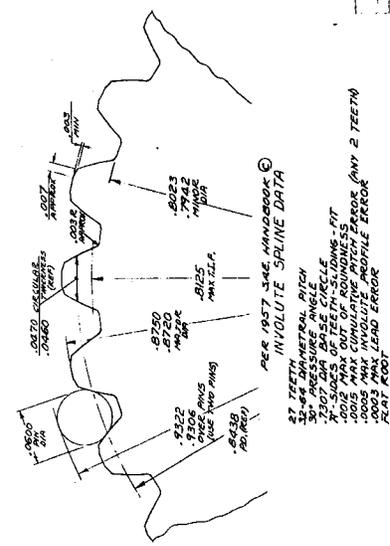
a. It is required that all prospective new sources submit a Source Approval Request (SAR) for the parts covered by this STDP. The SAR must be submitted in accordance with the ATCOM Competition Advocate's Shopping List Instructions. For a copy of these instructions, contact the ATCOM Source Development Officer at (314) 263-3999.

REV	DATE	DESCRIPTION	BY	CHK
1	04-10-765	INITIAL DESIGN
2	04-10-765
3	04-10-765
4	04-10-765
5	04-10-765
6	04-10-765
7	04-10-765
8	04-10-765
9	04-10-765
10	04-10-765



.6 P .3333 LEAD (DOUBLE THD) NO. 46 MM310
 .5417 BASIC PITCH DIA.
 11.5° HELIX ANGLE.
 ALSO MILING ANGLE 20°-40°-74°
 FOLLOWING FOR REF ONLY:
 .5617 BASIC PITCH DIA.
 11.5° MAX PITCH DIA.
 11.5° HELIX ANGLE.
 ALSO MILING ANGLE 20°-40°-74°

1. INTERCHANGEABLE PART REF MIL-8000 DASH 10-1
 2. SOURCE QUALIFICATION REQD PER 2.04-941-113
 3. MATERIAL: AL BRONZE, UNS198-C-465,
 COMP. CO., YANKEES
 4. SUPPLY TO 204-010-765
 5. MACHINING SURFACES TO BE FINISHED BY TURNING, GRINDING,
 OR POLISHING TO A SURFACE FINISH OF 100 μ IN.
 6. DIMENSIONS TO BE CONSIDERED TO 100 μ UNLESS OTHERWISE NOTED
 7. PLACEMENT OF DIMENSIONS TO BE CONSIDERED TO 100 μ UNLESS OTHERWISE NOTED
 8. MARK PER. P.S. 4020



PER 1957 SAE HANDBOOK
 27 TEETH INVOLUTE SPLINE DATA
 30° PRESSURE ANGLE
 1.0000 DIA. BASE CIRCLE
 1.0000 DIA. OUT. OF ROUNDNESS
 1.0000 DIA. MAX. CIRCULAR PITCH ERROR (ANY 2 TEETH)
 1.0000 DIA. MAX. LEAD ERROR
 1.0000 DIA. FLAT ROOT

204-010-765
 CONTROL NUT, PITCH - TAIL ROTOR ASSEMBLY OF
 204-010-765
 97499

CODE BENT. IN. 97499
 DRAWING 472-200406

REVISIONS				
SYM	ZONE	DESCRIPTION	DATE	APPROVED
A		REVISED TO REMOVE 98062, 2B922 & 60078 AS AN APPROVED SRCs. THEY NO EXIST.	4/19/02	<i>C. K. Hahn</i>
DISTRIBUTION STATEMENT A APPROVED FOR PUBLIC RELEASE DISTRIBUTION IS UNLIMITED				
DRAWN		<i>C. K. Hahn</i>	<i>4/19/02</i>	U.S. ARMY AVIATION AND MISSILE COMMAND REDSTONE ARSENAL, AL 35898-5270
CHECKED				
SUBMITTED				
APPROVED		<i>C. K. Hahn</i>	DATE <i>4/19/02</i>	APPROVED SOURCES FOR STDP 204-010-765
CODE IDENT NO		81996	SIZE A	
SCALE: NONE			SHEET 1 of 2	

Drawing Number

SS204-010-765

1. Part Number 204-010-765-1 shall be procured only from the following sources:

- (a). Bell Helicopter Textron
601 E. Hurst Blvd.
Ft. Worth, TX 76101
CAGE 97499

- (b). Duncan Industries Inc.
12110 Clark Street
Santa Fe Springs, CA 90670
CAGE 27604