

REV. G
AS27647™

FEDERAL SUPPLY CLASS
3110

RATIONALE

ADD AISI 1050 MATERIAL OPTION FOR BALL RETAINER. AISI 1050 MATERIAL HAS BEEN HISTORICALLY USED FOR BALL RETAINER MATERIAL. ADDITION OF THIS MATERIAL WAS MISSED DURING REVISION F WHEN AISI 1045 MATERIAL WAS ADDED. IN REVISION E, THE BALL RETAINER MATERIALS WERE MADE MORE SPECIFIC AND AISI 1045/AISI 1050 WERE NOT INCLUDED.

NOTICE

THE INITIAL SAE PUBLICATION OF THIS DOCUMENT WAS TAKEN DIRECTLY FROM U.S. MILITARY STANDARD MS27647E. THIS SAE STANDARD MAY RETAIN THE SAME PART NUMBERS ESTABLISHED BY THE ORIGINAL MILITARY DOCUMENT.

THE COMPLETE REQUIREMENTS FOR PROCURING THE PRODUCT DESCRIBED HEREIN SHALL CONSIST OF THIS DOCUMENT AND THE LATEST ISSUE OF AS7949.

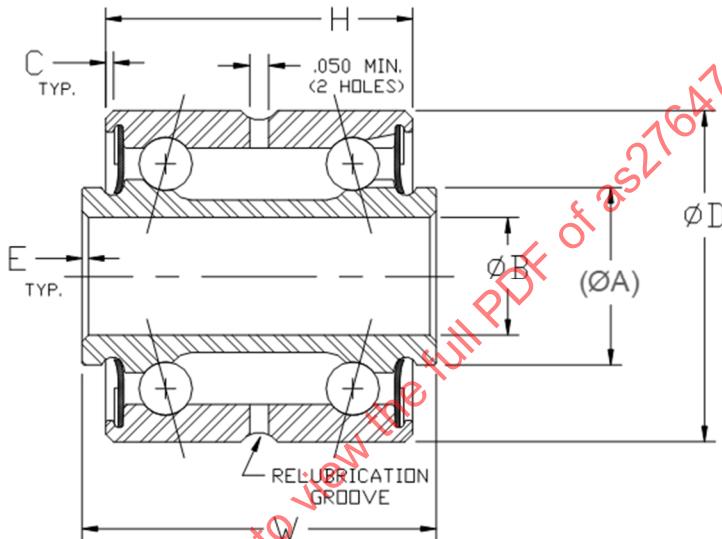
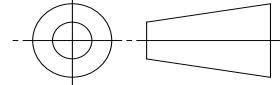


FIGURE 1 - PART CONFIGURATION

SHOWN WITH RELUBRICATION GROOVE
FOR WITHOUT RELUBRICATION GROOVE, OMIT "G" IN PART NUMBER

THIRD ANGLE PROJECTION



CUSTODIAN: ACBG

PROCUREMENT SPECIFICATION: AS7949



AEROSPACE STANDARD

BEARING, BALL, AIRFRAME
ANTI-FRICTION, EXTRA WIDE
DOUBLE ROW, INTERMEDIATE DUTY

AS27647™
SHEET 1 OF 3

REV.
G

TABLE 1 - DIMENSIONS AND LOADS

MS DASH NO. 8/ -4	øB BORE +.0000 -.0005 2/	øD OUTSIDE DIAMETER +.0000 -.0005 1/ 2/	W WIDTH INNER RING +.000 -.005 1/	H WIDTH OUTER RING +.000 -.005 1/	(øA) SHOULDER DIAMETER INNER RING	E 4/ CORNER CHAMFER X 45°	C 3/	RADIAL LIMIT LOAD RATING (LB) OUTER RING OD +.015 -.000	THRUST LIMIT LOAD RATING (LB) INNER BORE +.015 -.000	5/ RADIAL LOAD RATING (LB) FOR AVERAGE LIFE OF 10000 COMPLETE 90° CYCLES	6/ RADIAL LOAD RATING (LB) FOR AVERAGE LIFE OF 10000 COMPLETE 90° CYCLES	WEIGHT POUNDS (APPROX) LB/EA	7/ MAXIMUM STARTING TORQUE (IN_OZ)
						INNER RING BORE +.015 -.000	OUTER RING OD +.015 -.000			CASE I	CASE II		
						1400	500			1050	960		
-4A	.2500	.6250	.562	.500	.338	.005	.016	1400	500	1050	960	.02	1.0
-4	.2500	.7500	.875	.750	.372	.005	.016	2700	900	2070	1850	.04	1.0
-5	.3125	.8750	.938	.813	.466	.005	.016	5140	1600	2600	2320	.07	1.5
-6	.3750	1.0625	1.188	1.063	.570	.005	.016	8440	2600	4220	3740	.12	2.5
-8	.5000	1.4375	1.500	1.375	.709	.005	.032	15520	4700	7610	6520	.29	2.5

1/ ALL DIMENSIONS TO BE MET AFTER PLATING.

2/ OUT-OF-ROUND TOLERANCES: BORE: +.0002, -.0007; OUTER DIA: +.0005, -.0010.

3/ A RADIUS GIVING APPROXIMATELY THE SAME GRIP FOR STAKING THE BEARING IN THE HOUSING WILL BE ACCEPTABLE.

4/ A RADIUS GIVING APPROXIMATELY THE SAME FILLET CLEARANCE WILL BE ACCEPTABLE.

5/ CASE I - LOAD FIXED WITH RESPECT TO OUTER RING.

CASE II - LOAD FIXED WITH RESPECT TO INNER RING.

6/ THESE RATINGS ARE FOR OPERATION UP TO 250 °F. FOR OPERATION UP TO 350 °F, THE RATINGS SHALL BE REDUCED BY 20%.

7/ SPECIFIED LIMITS ARE FOR BEARINGS LUBRICATED WITH MIL-PRF-81322 GREASE. FOR BEARINGS LUBRICATED WITH MIL-PRF-23827 TYPE I GREASE, THE TORQUE LIMIT SHALL BE THE SPECIFIED VALUE IN THE TABLE Multiplied BY 1.2.

8/ -4A AND -4 BALL RETAINER TYPE.

REQUIREMENTS:

1. MATERIAL: RINGS AND BALLS: 52100 STEEL PER AMS6440 OR AMS6444

BALL RETAINER: 301 CRES PER AMS5519
(-4A AND -4 ONLY) 302 CRES PER AMS5515 OR AMS5516
304 CRES PER AMS5513
305 CRES PER AMS5514
410 CRES PER AMS5504
430 CRES PER AMS5503
1008, 1010, 1012, OR 1015 PER ASTM A109
AISI 1045 OR AISI 1050

SEALS: POLYTETRAFLUOROETHYLENE (PTFE) PER AMS3652

SEAL RETAINERS: 301 CRES PER AMS5519
302 CRES PER AMS5515, AMS5516, AMS5906, OR ASTM A313
304 CRES PER AMS5513, AMS5913, OR ASTM A666
430 CRES PER AMS5503

2. LUBRICANT: MIL-PRF-81322 OR MIL-PRF-23827 TYPE I. ALL BEARINGS SHALL BE PACKED WITH AN 80% MINIMUM GREASE FILL CONFORMING TO MIL-PRF-81322 UNLESS OTHERWISE SPECIFIED. IF MIL-PRF-23827 TYPE I IS REQUIRED, ADD THE LETTER "L" AFTER THE MS27647 DASH NUMBER. MIL-PRF-23827 TYPE I SHALL NOT BE USED FOR OPERATION WHERE TEMPERATURES EXCEED 250 °F.

WITH "G" DESIGNATOR PART NUMBER INDICATES RELUBRICATION GROOVE.

3. HARDNESS: HEAT TREAT RINGS AND BALLS TO 60 TO 66 HRC AND STABILIZE FOR OPERATION AT 250 °F.

4. SURFACE ROUGHNESS: RACEWAYS AND BALL SHALL HAVE A MAXIMUM SURFACE ROUGHNESS OF 8 MICROINCHES Ra PER ANSI/ASME B4.1.

5. PLATING: ALL EXTERNAL SURFACES EXCEPT BORE, SEALS AND SEAL RETAINERS SHALL BE PLATED .0003 TO .0006 THICK WITH:

(NO DESIGNATOR) CADMIUM IN ACCORDANCE WITH AMS-QQ-P-416, TYPE I, CLASS 2.

DESIGNATOR "E" ZINC-NICKEL IN ACCORDANCE WITH AMS2417, TYPE 2, GRADE B.

SAE INTERNATIONAL	AEROSPACE STANDARD	AS27647™ SHEET 2 OF 3	REV. G
	BEARING, BALL, AIRFRAME ANTI-FRICTION, EXTRA WIDE DOUBLE ROW, INTERMEDIATE DUTY		