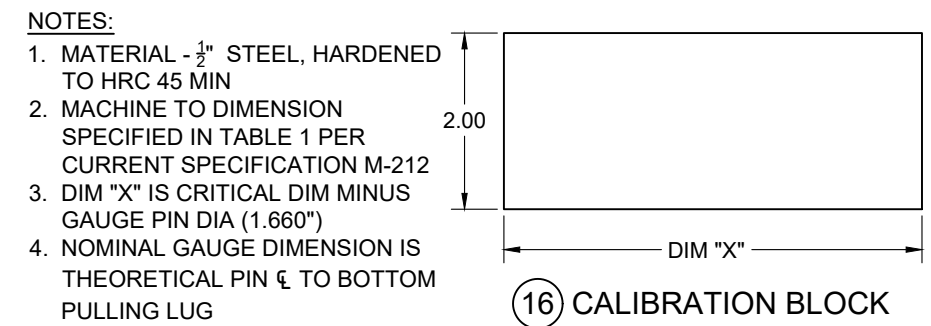


PARTS LIST			
ITEM	DESCRIPTION	QTY	NOTES
1	GAUGE ARM	1	SEE SHEET 2
2	BRACKET, GAUGE ARM	2	SEE SHEET 2 - LOWER SHOWN / UPPER OPPOSITE
3	GAUGE PIN GUIDE	2	SEE SHEET 2
4	SPACER, GAUGE PIN GUIDE	1	SEE SHEET 2
5	GAUGE HANDLE	1	SEE SHEET 2
6	INSERT, GAUGE HANDLE	2	SEE SHEET 2
7	BRACKET, GAUGE HANDLE	2	SEE SHEET 2
8	DOWEL PIN (0.25 DIA X 0.63 LG)	NOTE 4	HARDENED GRND STEEL (GRAINGER 41UX68 OR EQUIV)
9	CAP SCREW, 5/16-18 UNC X 1/2" LG	3	BLACK OXIDE / PLATED (GRAINGER 5MJY7 OR EQUIV)
10	GAUGE PIN	1	SEE SHEET 2
11	TOP INSERT, GAUGE PIN	1	SEE SHEET 2
12	HANDLE, GAUGE PIN	1	SEE SHEET 2
13	CAP SCREW, 1/4-20 UNC X 1/2" LG	20	BLACK OXIDE / PLATED (GRAINGER 5MJX7 OR EQUIV)
14	CAP SCREW, 1/4-20 UNC X 3/4" LG	2	BLACK OXIDE / PLATED (GRAINGER 5MJX9 OR EQUIV)
15	GAUGE INSERT, BOTTOM LUG	1	DRAWING 122159
16	CALIBRATION BLOCK	1	SEE SHEET 1 DETAIL

TABLE 1		
CRITICAL DIM (INCHES)	DIMENSION "X" (INCHES ± 0.005)	NOM. GAUGE DIM (INCHES)
6.361	4.701	5 17/32
6.377	4.717	5 35/64
6.393	4.733	5 9/16
6.408	4.748	5 37/64
6.424	4.764	5 19/32
6.439	4.779	5 39/64
6.455	4.795	5 5/8



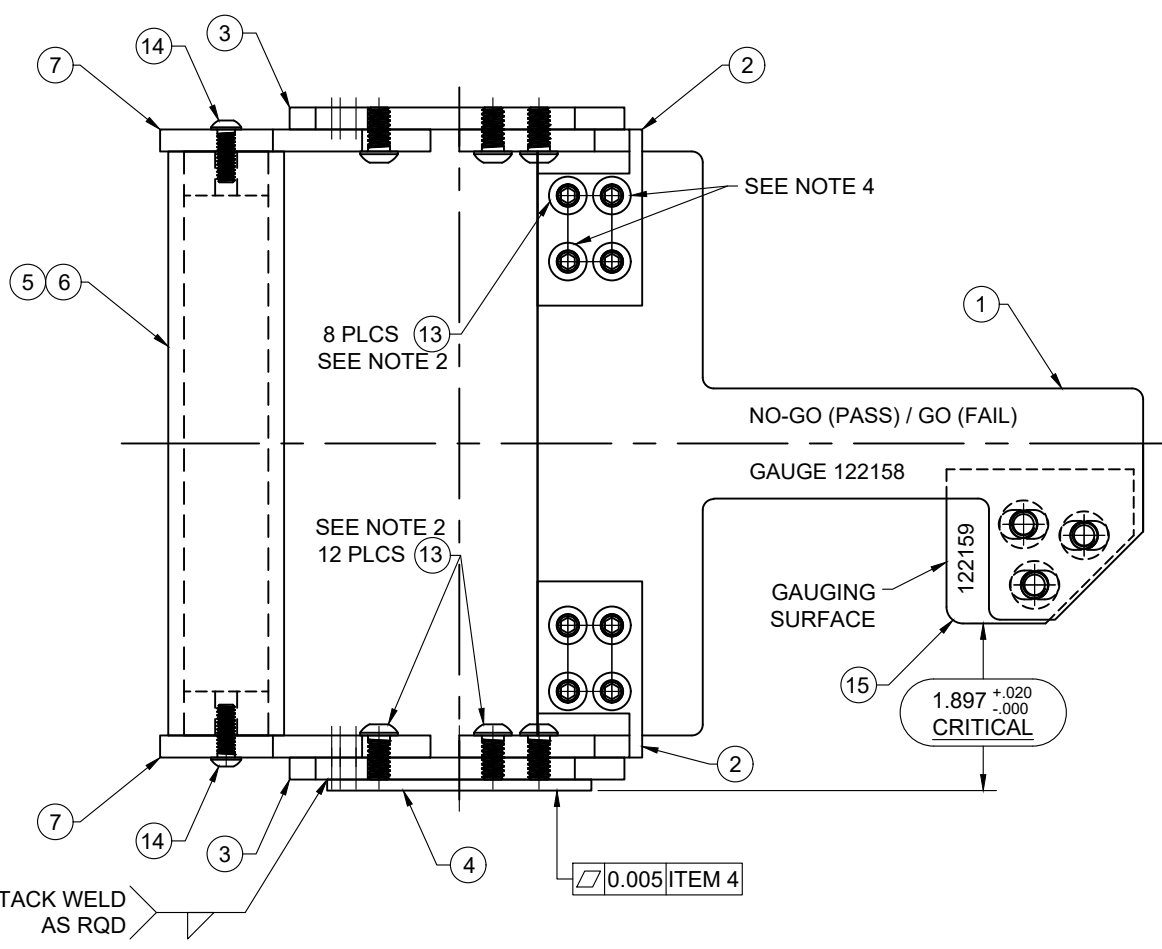
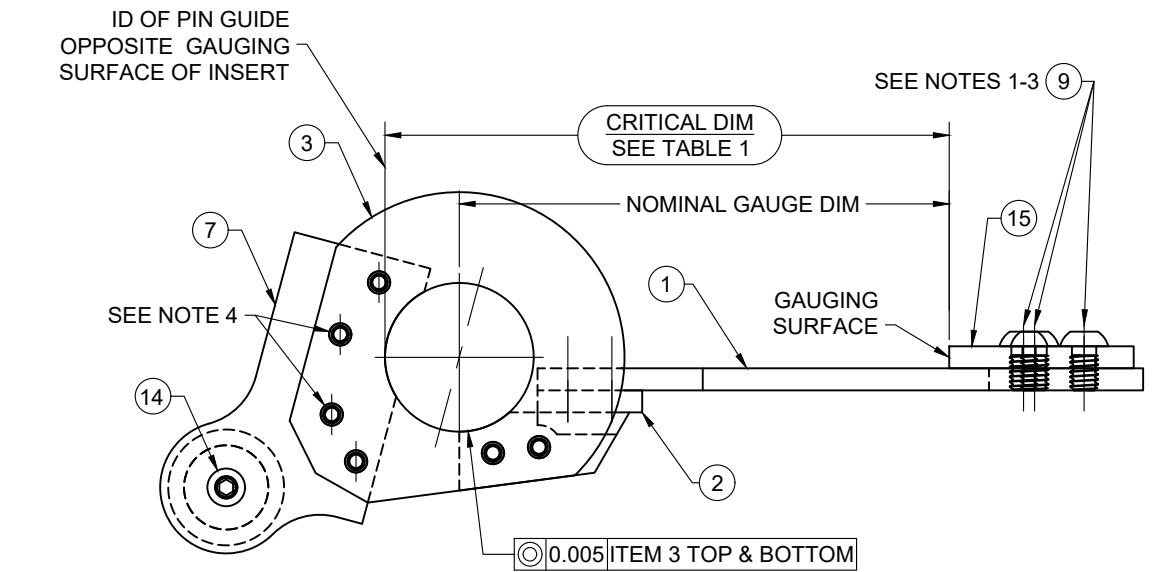
CRITICAL DIM	DIM "X"	NOM GAUGE DIM	WHERE USED	LINE
6.361"	4.701"	5-17/32"	E-TYPE / EF-TYPE COUPLER BODIES	-01
TBD	TBD	TBD	F-TYPE COUPLER BODIES	-02

INSTRUCTIONS FOR GAUGING COUPLER BODY:

- WITH KNUCKLE REMOVED, CHECK VERTICAL DISTANCE BETWEEN COUPLER PIVOT LUGS (PIN BOSSES) USING AAR M-212 GAUGE NO. 49354.
- IF COUPLER BODY PASSES STEP 1 (I.E. DOES NOT TAKE THE NO-GO GAUGE), NEXT PLACE THE PULLING LUG GAUGE BETWEEN THE PIVOT LUGS (PIN BOSSES) AND SECURE WITH THE GAUGE PIN ASSEMBLY.
- WITH THE PULLING LUG GAUGE RESTING ON THE BOTTOM PIN PROTECTOR BOSS, ROTATE THE GAUGE BY THE HANDLE IN A CCW DIRECTION (SIMILAR TO CLOSING A KNUCKLE). MAINTAIN INWARD PRESSURE THROUGH THE GAUGE ROTATION (DO NOT PULL ON THE GAUGE) AND ENSURE GAUGE REMAINS SEATED ON THE BOTTOM PIN BOSS.
- COUPLER BODY MAY CONTINUE CLASSIFICATION IF THE GAUGING SURFACE OF THE INSERT MAKES CONTACT (NO-GO) WITH BACKSIDE OF THE PULLING LUG DURING GAUGE ROTATION.
- COUPLER BODY IS SCRAP FOR EXCESSIVE PULLING LUG WEAR IF GAUGING SURFACE OF INSERT ROTATES COMPLETELY PAST THE BACKSIDE OF THE COUPLER PULLING LUG, WITH NO CONTACT.

INSTRUCTIONS FOR GAUGE CALIBRATION:

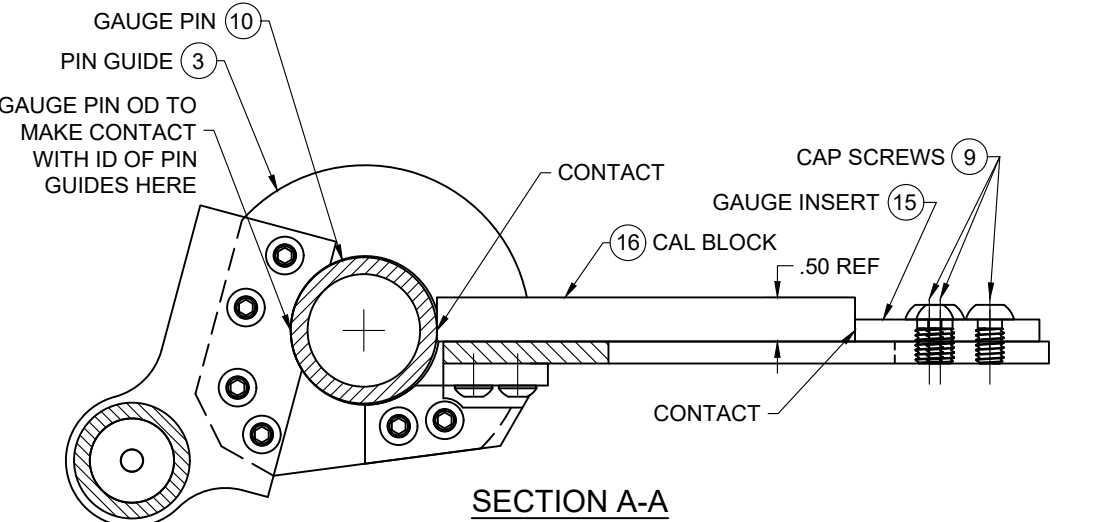
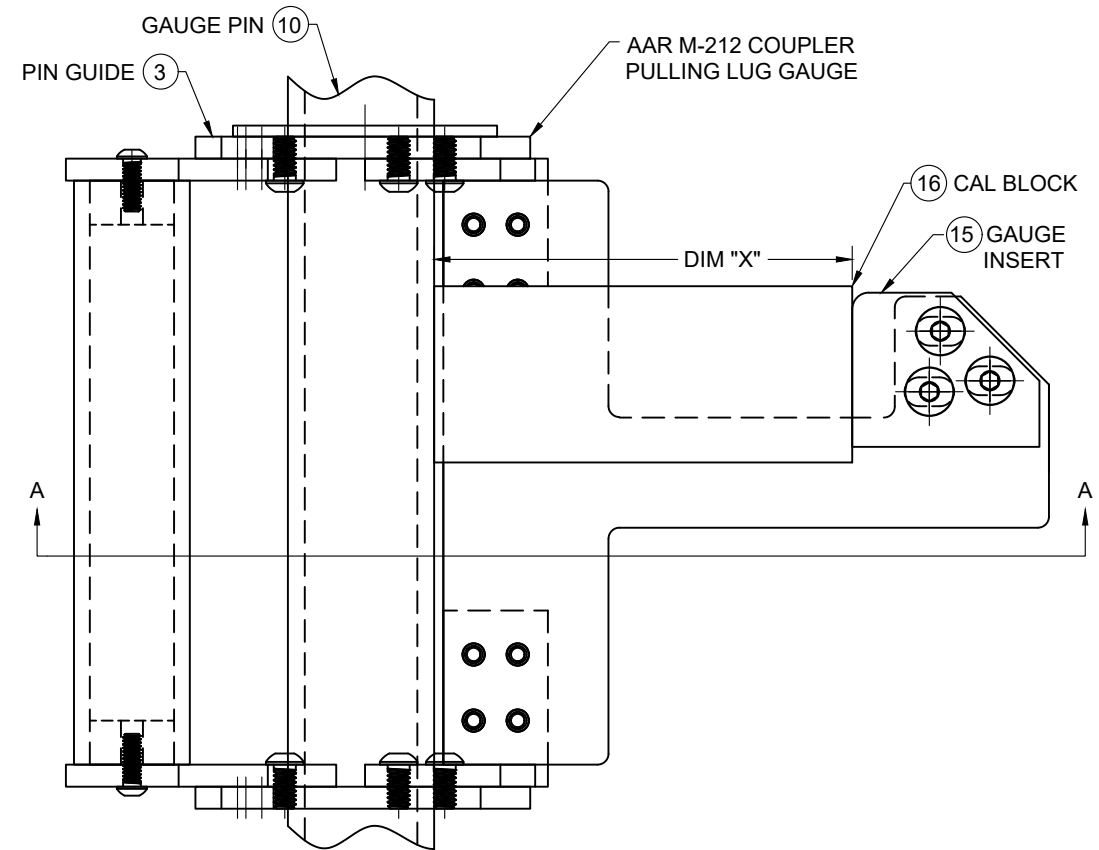
- INSTALL GAUGE PIN AND LOOSEN THREE CAP SCREWS SECURING THE GAUGE INSERT.
- PLACE CALIBRATION BLOCK BETWEEN GAUGE PIN AND ALIGN WITH INSERT AS SHOWN.
- PUSH INSERT AND CALIBRATION BLOCK TOWARD HANDLE UNTIL GAUGE PIN MAKES CONTACT WITH BOTH PIN GUIDES. CHECK FOR SQUARENESS.
- APPLY REMOVABLE STRENGTH THREADLOCKER AND TIGHTEN CAP SCREWS.



GAUGE ASSEMBLY

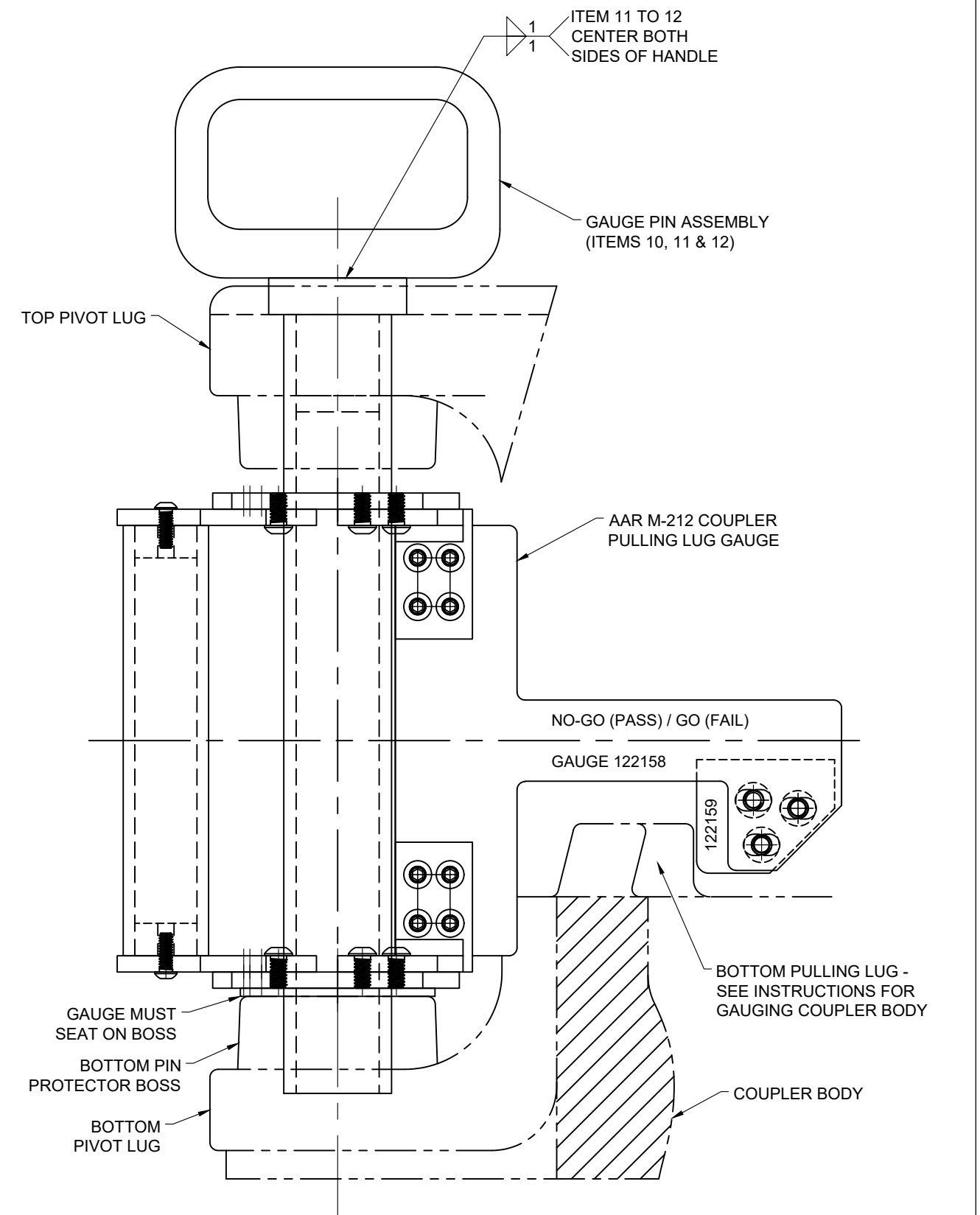
ASSEMBLY NOTES:

- ITEM (15) GAUGE INSERT TO BE APPLIED TO THE LEADING SIDE OF ITEM (1) GAUGE ARM.
- APPLY REMOVABLE STRENGTH THREAD LOCKER TO ITEMS (9), (13), AND (14) UPON ASSEMBLY.
- VERIFY ALL DIMENSIONS SPECIFIED AS CRITICAL USING EQUIPMENT TRACEABLE TO A NATIONALLY RECOGNIZED STANDARD. SEE INSTRUCTIONS FOR GAUGE CALIBRATION.
- AT GAUGE MFG DISCRETION, ITEM 13 (CAP SCREW) MAY BE SUBSTITUTED WITH ITEM 8 (DOWEL PIN) WHEN A MECHANICALLY FASTENED CONNECTION BETWEEN TWO PARTS HAS MORE THAN TWO CAP SCREWS (SEE ITEMS 1-TO-2 AND 3-TO-7). PINS TO BE PRESS FIT INTO THE PART HAVING THREADS.



GAUGE CALIBRATION

TOLERANCES:
UNLESS OTHERWISE NOTED
DECIMALS: ± 0.010 "
FRACTIONS: $\pm 1/32$ "
ANGLES: $\pm 0.5^\circ$
HOLE DIAMETERS: ± 0.005 "



GAUGE APPLICATION

DRAFT	3/4/22	SOLICITATION OF COMMENTS CIRCULAR	APPROVED: CSTCC	AAR M-212 COUPLER PULLING LUG GAUGE				
REV	DATE	DESCRIPTION OF REVISION	DATE: 11/12/21	NEXT ASSEMBLY NO. AAR M-212	SIZE C	SCALE: DO NOT SCALE	SHT. 1 of 2	DRAWING NO. 122158