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Superseding AS39901

(R) Bearings, Roller, Needle, Airframe,
Antifriction, Inch

FSC 3110

1. SCOPE:

1.1 Scope:

This standard covers the requirements for non-separable, Airframe Anti-friction Needle Bearings, intended for use in flight vehicle control systems, with radial loads.

1.2 Classification:

Bearings shall be of the following types, as specified (see 6.2).

Type I Bearing, Roller, Needle, Single Row, Heavy Duty, Anti-friction, Inch (MS24461 and AS24461)

Type II Bearing, Roller, Needle, Single Row, Thin Shell, Anti-friction, Inch (MS24462)

Type III Bearing, Roller, Needle, Single Row, Heavy Duty, Self-Aligning, Anti-friction, Inch (AS24463)

Type IV Bearing, Roller, Needle, Double Row, Heavy Duty, Self-Aligning, Anti-friction, Inch (AS24464)

Type V Bearing, Roller, Needle, Single Row, Heavy Duty, Track Roller, Anti-friction, Inch (MS24465) (Inactive for new design) Bearing

Bearing, Roller, Needle, Single Row, Heavy Duty, Track Roller, Sealed, Anti-friction, Inch (AS21438)

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SAE AS39901 Revision A

1.2 (Continued):

- Type VI Bearing, Roller, Needle, Double Row, Heavy Duty, Track Roller, Anti-friction, Inch (MS24466) (Inactive for new design) Bearing
Bearing, Roller, Needle, Double Row, Heavy Duty, Track Roller, Sealed, Anti-friction, Inch (AS21439)
- Type VII Bearing Roller, Needle, Track Roller, Integral Stud, Anti-friction, Inch (MS21432) (Inactive for new design)
Bearing, Roller, Needle, Track Roller, Crown Radiused O.D., Integral Stud, Type VII, Anti-friction, Inch (AS21447)
- Type VIII Bearing, Roller, Needle, Track Roller, Integral Stud, Sealed, Anti-friction, Inch (MS21440)
- Type IX Bearing, Roller, Needle, Track Roller, Integral Heavy Stud, Sealed, Anti-friction, Inch (AS21441)
- Type X Bearing, Roller, Needle, Heavy Duty, Track Roller, Sealed, Anti-friction, Inch (AS21442)

2. APPLICABLE DOCUMENTS:

2.1 Issues of Documents:

The following documents, of the issue in effect on date of invitation for bids or request for proposal, form a part of this specification to the extent specified herein.

2.1.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AMS-QQ-C-320	Chromium Plating (Electrodeposited)
AMS-QQ-P-416	Plating, Cadmium (Electrodeposited)
AS8879	Screw Threads, Controlled Radius Root With Increased Minor Diameter, General Specification For
AS21438	Bearing, Roller, Needle, Double Row, Heavy Duty, Track Roller, Sealed, Anti-friction, Inch
AS21439	Bearing, Roller, Needle, Double Row, Heavy Duty, Track Roller, Sealed, Anti-friction, Inch
AS21440	Bearing, Roller, Needle, Track Roller, Integral Stud, Sealed, Type VIII, Antifriction, Inch
AS21441	Bearing, Roller, Needle, Track Roller, Integral Stud, Type IX, Sealed, Anti-friction, Inch
AS21442	Bearing, Roller, Needle, Track Roller, Type X, Sealed, Anti-friction, Inch

SAE AS39901 Revision A

2.1.1 (Continued):

AS21447	Bearing, Roller, Needle, Track Roller, Crown Radiused O.D., Integral Stud, Type VII, Anti-friction, Inch
AS24461	Bearing, Roller, Needle, Single Row, Heavy Duty, Type I, Anti-friction, Inch
AS24462	Bearing, Roller, Needle-Single Row, Thin Shell, Type II, Antifriction
AS24463	Bearing, Roller, Needle, Single Row, Heavy Duty, Self-Aligning, Type III, Anti-friction, Inch
AS24464	Bearing, Roller, Needle, Single Row, Heavy Duty, Self-Aligning, Type IV, Anti-friction, Inch

2.1.2 U.S. Government Publications: Available from DODSSP, Subscription Services Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19428-2959.

MIL-DTL-197	Bearing, Anti-friction, Associated Part and Subassemblies, Packaging of
MIL-DTL-13924	Coating, Oxide, Black, For Ferrous Metals
MIL-PRF-23827	Grease Aircraft and Instrument, Gear and Actuator Screw
MIL-PRF-81322	Grease, Aircraft, General Purpose, Wide Temperature Range
MIL-S-7742	Screw Threads, Standard Optimum Selected Series, General Specification For
MIL-STD-129	Standard Practice for Military Marking
MIL-STD-130	Identification Marking of US Military Property
MS21432	Bearings, Roller, Needle, Track Roller, Integral Stud, Type VII, Anti-friction, Inch

2.1.3 ASTM Publications: Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

ASTM E 18	Standard Test Methods for Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials
ASTM E 1444	Standard Practice for Magnetic Particle Inspection

2.1.4 ASME Publications: Available from ASME, 345 East 47th Street, New York, NY 10017.

ASME Y14.100	Engineering Drawing Practices
ANSI B46.1	Surface Texture
ANSI/ABMA STD 4	Gauging/Tolerancing Practices

2.1.5 ISO Publications: Available from ANSI, 25 West 43rd Street, New York, NY 10036-8002.

ISO 12103-1	Arizona Road Dust
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SAE AS39901 Revision A

3. REQUIREMENTS:

3.1 Qualification:

The bearings furnished under this standard shall be products which are qualified for listing on the applicable Qualified Products List (QPL) at the time set for opening of bids (see 4.3 and 6.2).

- 3.1.1 **Product Change:** Any change in product design, including raceway geometry or dimensions, rolling element dimensions, rolling element quantity, seals, materials or plant location shall be reported to the qualifying activity and will require re-qualification of the product to an extent determined by the qualifying activity. Any other specific changes which must be brought to the qualifying activity's attention will be identified in the qualification notification letter.
- 3.1.2 **Product Manufacture:** The bearing manufacturer shall be capable of performing the preponderance of manufacturing operations in-house, but may subcontract these operations at its option. Component inspection shall be performed at the plant listed on the Qualified Products List. If manufacturing operations are performed in more than one plant, the manufacturer's additional plant(s) shall be reported to the qualifying activity and will be listed accordingly on the QPL. The manufacturer is responsible for meeting all requirements of the standard and for the quality of the end product, whether it is manufactured totally in-house or some of the operations are performed by a subcontractor. Inherent in the responsibility for the end product is the responsibility to verify that the subcontractor's processes meet standard requirements. A change in subcontractor need not be reported to the qualifying activity unless specifically identified in the qualification notification letter. (NOTE: Bearings partly or completely manufactured in foreign countries shall be subject to the laws and procurement regulations pertaining to acquisition of foreign made products.)

3.2 Bearing Assembly:

The bearing assembly shall be as specified on MS21432, AS21438, AS21439, MS21440, AS21441, AS21442, AS21447, AS24461, MS24462, AS24463, AS24464, MS24465, and MS24466 standards, but the details that are not specified on the part standards shall be optional. Only factory-new bearings shall be furnished.

3.3 Material:

- 3.3.1 The bearing components shall be fabricated from material as specified on the applicable drawing standard. The lubricant used shall be qualified to the applicable grease specification for the drawing standard.

3.4 Design and Construction:

- 3.4.1 **Dimensions:** Dimensions, weights, and tolerances shall be as shown on the applicable drawing standards.

SAE AS39901 Revision A

- 3.4.2 Hardness: The hardness of the inner and outer self-aligning rings, inner studs, end washers and rollers as applicable, shall be tested in accordance to 4.5.2 and shall conform to the values defined on the applicable drawing standard.
- 3.4.3 Surface Finish: The surface finish shall be measured in accordance with 4.5.3 and shall conform to the values as defined on the applicable drawing standards.
- 3.4.4 Plating: All external surfaces, excluding the bores of Types I, II, III, IV, V, VI, and X bearings shall be plated. Plating shall be as specified on the applicable drawing standards. Black oxide coating per MIL-DTL-13924 is a permissible alternate on the AS21438, AS21439, and AS21442 inner ring external surfaces.
- 3.4.5 Lubrication Provisions: Holes and annular grooves shall be provided for lubrication as specified on the applicable drawing standards. Bearings shall have been lubricated within 36 months of delivery. Data to support this value shall be kept on file with the QPL custodian.
- 3.4.6 Lubrication: The bearings shall be filled with the grease qualified to MIL-PRF-81322 for -65 to 350 °F operating range, or MIL-PRF-23827 for -65 to 250 °F operating range, as specified in the drawing standard. At least 80% of the bearing void shall be filled with grease after the bearings have been thoroughly cleaned and dried. The external surfaces of all bearings shall be coated with the same grease that is packed in the bearing.
- 3.4.7 End Washers: Types I, II, III, IV, V, VI, and X bearings shall include end washers to limit axial play. Types VII, VIII, and IX bearings shall have an integral flange on the stud and an end washer to limit axial play.
- 3.4.8 Threads:
- 3.4.8.1 Type VII Bearings: Threads shall be fully formed and conform to AS8879.
- 3.4.8.2 Type VIII and IX Bearings: Threads shall be fully formed and shall conform to MIL-S-7742.
- 3.5 Performance:
- 3.5.1 Radial Runout: When tested as specified in 4.5.13, excepting Types III and IV bearings and inner raceway of Types VII, VIII, and IX bearings, shall show no radial runout greater than 0.0010 inch and 0.0016 inch for the inner and outer raceway, respectively.
- 3.5.2 Radial Internal Clearance: When tested as specified in 4.5.7, the radial internal clearance (total indicator reading) between inner and outer raceways shall be as specified on the applicable drawing standard.
- 3.5.2.1 Self-aligning Bearings: When tested as specified in 4.5.7.3 for Types III and IV bearings, the clearance between self-aligning members shall be from 0.0002 inch to 0.0007 inch.

SAE AS39901 Revision A

- 3.5.3 Axial Internal Clearance: When tested as specified in 4.5.8, the axial internal clearance (total indicator reading) of outer rings shall be 0.025 inch maximum. The minimum axial internal clearance shall be considered satisfactory if the bearing passes the test specified in 4.5.10.
- 3.5.4 Dimensional Stability: The bearing components shall be dimensionally stable over the temperature range of -65 to 250 °F, when tested as specified in 4.5.9. Any bearings that show a dimensional change of more than 0.0001 inch/inch of diameter shall be considered to have failed (see 4.5.9).
- 3.5.5 Axial Compression Load Test: When tested as specified in 4.5.10, the bearing outer ring shall be easily turned by hand.
- 3.5.6 End Washer Pushout: When tested as specified in 4.5.11, the force required to push out the end washer of Types I, III, IV, V, VI, and X bearings shall not be less than 100 pounds. For Types VII, VIII, and IX bearings the force shall not be less than 22 pounds. If the end washers fall off or smoothness of operation is lessened perceptibly, the bearings shall be considered to have failed.
- 3.5.7 Self-alignability: The self-aligning bearings shall be capable of the minimum misalignment with the minimum clamping diameters specified on the applicable drawing standard, when tested as specified in 4.5.12.
- 3.5.8 Seals: The seals shall retain the lubricant in the bearing, prevent the ingress of contaminants, and be capable of venting grease when the bearings are lubricated. Representative bearings from AS21438, AS21439, MS21432, AS21447, MS21440, AS21441, and AS21442 shall be subjected to the test requirements as specified in 4.5.13 and 4.5.14.
- 3.5.8.1 For grease retention, the tests shall be conducted as specified in 4.5.13. No less than 25% of the original grease by weight shall be retained in the bearing at the end of the test.
- 3.5.8.2 For the exclusion of contaminants, tests shall be conducted as specified in 4.5.14. The starting torque shall not have increased more than 100%, or 2.0 inch-oz over pre-test measurements, and the radial internal clearance shall not have increased more than 50%, or 0.0005 inch over the pre-test clearance for a minimum of four of six (4 of 6) bearings tested.
- 3.5.9 Radial Load Ratings:
- 3.5.9.1 Static Limit Load: The bearings shall meet the static limit loads specified on the applicable drawing standard when tested in accordance with 4.5.15. If friction torque has increased 100% or more of the pre-test value, the bearing shall be considered to have failed.
- 3.5.9.2 Static Ultimate Load: The minimum static ultimate loads shall not be less than 1.5 times the static limit loads specified in the applicable drawing standard when tested in accordance with 4.5.16. Any bearings that cannot be turned by hand, or that have fractured parts, shall be considered to have failed.

SAE AS39901 Revision A

3.5.9.3 Dynamic Load Rating as a Track Roller: The bearings shall have a dynamic load rating as a track roller of not less than the values specified in the applicable drawing standard when tested in accordance with 4.5.17. Any bearings that have seized or that have fractured parts shall be considered to have failed.

3.6 Identification of Product:

The bearings shall be permanently marked in accordance with MIL-STD-130, with the manufacturer's name or trademark and the complete MS part number, and lot control number, if space is available.

3.7 Interchangeability:

All bearings having the same part number shall be functionally and dimensionally interchangeable. The drawing number requirements of ASME Y14.100 shall govern changes in the manufacturer's part numbers.

3.8 Workmanship:

The workmanship shall be in accordance with airframe needle roller bearing manufacturing practice. Bearings shall be free from defects such as rust, dirt, and broken or cracked parts which may adversely affect performance of the bearing.

3.9 Drawing Standard:

The individual item requirements shall be as specified herein and in accordance with the applicable drawing standard. In the event of any conflict between the requirements of this document and the drawing standard, the latter shall govern.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

Unless otherwise specified in the contract or purchase order, the contractor is responsible for the performance of all inspection requirements (examinations and tests) as specified herein. Except as otherwise specified in the contract or purchase order, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the qualifying activity. The qualifying activity reserves the right to perform any of the inspections set forth in this standard where such inspections are deemed necessary to ensure supplies and services conform to prescribed requirements.

SAE AS39901 Revision A

4.1.1 Responsibility for Compliance: All items shall meet all requirements of Sections 3 and 5. The inspections set forth in this standard shall become a part of the suppliers' overall inspection system or quality program. The absence of any inspection requirements in the standard shall not relieve the suppliers of the responsibility of insuring that all products or supplies submitted for acceptance comply with all requirements of the contract. Sampling inspection, as part of manufacturing operations, is an acceptable practice to ascertain conformance to requirements, however, this does not authorize submission of known defective material, either indicated or actual, nor does it commit the customer to accept defective material.

4.2 Classification of Inspection:

The examination and testing of bearings shall be classified as follows:

- a. Qualification inspection (4.3)
- b. Quality conformance inspection (4.4)

Each bearing shall be inspected in accordance with ANSI/ABMA STD 4 Gauging/Tolerancing Practices.

4.3 Qualification Inspection:

Qualification inspection shall consist of all the tests specified under 4.5. The tests shall be conducted as specified in Table 1.

4.3.1 Qualification Test Samples: Twenty-five (25) bearings of each size indicated in Table 2 shall be tested to qualify each of the types. The bearing samples shall be manufactured with equipment and procedures used in production.

4.3.2 Data to Accompany Qualification Test Samples: Drawings, showing complete external dimensions, tolerances, construction, material, hardness, and date of latest revision, shall be submitted with the qualification test report and test samples.

4.3.3 Qualification Failure: Any failures during examinations or tests shall be reported to the qualifying activity before testing continues. Based on corrective action, authorization to complete the qualification test may be granted by the qualifying activity. Failure of any test shall be cause for refusal to grant qualification.

4.3.4 Retention of Qualification: For retention of qualification, one bearing size from each drawing standard shall be tested per Table 3 at 36 month intervals. The qualifying activity will select the dash number to be tested or an agreed upon dash number actively produced by the manufacturer. The manufacturer's products shall pass all of the retention of qualification tests. Failure to pass all of the tests may result in loss of qualification for that product. The retention of qualification tests may be performed in conjunction with conformance testing when approved by the qualifying activity.

SAE AS39901 Revision A

4.3.4.1 Failure of Retention of Qualification: Any failures during retention of qualification testing should be reported immediately to the qualifying activity. Authorization to continue retention of qualification testing will be based on corrective action acceptance by the qualifying activity.

4.3.5 Qualification by Similarity: Qualification by similarity to qualified products, or to products being submitted for qualification, is permissible when materials, designs, or manufacturing processes are identical. When materials, designs, or manufacturing process differ, sufficient testing of the affected characteristics will be required to obtain qualification by similarity. Full details of the similarity and differences, along with the proposed tests, shall be submitted to the qualifying activity or approval prior to the commencing of testing.

4.4 Conformance Inspection:

Conformance inspection shall consist of sampling tests specified in 4.4.2 on each lot of bearings.

4.4.1 Lot Control: The inspection lot shall consist of finished bearings having a single part number, manufactured by the procedures established for the originally qualified bearings. The inspection lot shall be produced as one continuous batch, which receives final inspection at the same location. The inspection lot shall be identified by a unique number (Manufacturer's Lot Control Number) to be included on the bearing, in the package marking and on the associated certification that accompanies the shipping paperwork. The manufacturer's lot control number shall be traceable to the finished bearing assembly and the quality conformance inspection or acceptance tests. The samples taken for acceptance testing shall be randomly selected to ensure that they are representative of the production run/lot.

The manufacturer shall have a quality control/assurance system in effect that ensures traceability of the rings/stud and rollers (main components) that make up the final bearing assembly, and documentation that provides objective evidence that the components meet the drawing standard requirements. Individual component lots shall keep the integrity through all the manufacturing, storage and process operations. The final bearing assembly that makes up the individual production run may have more than one component lot number as long as the traceability is maintained.

4.4.2 Conformance Tests: Samples shall be examined for conformance to the tests listed in Table 4. The sample bearings shall be selected in random from each inspection lot in accordance with Table 5. If no defect is found in the sample, the lot shall be accepted for these tests. If any defects are found in the sample, the entire lot shall be 100% inspected for each defective characteristic found, and all defective parts shall be removed from the lot.

4.5 Inspection Methods:

For Qualification, Retention of Qualification and Conformance Tests, as applicable per the attached tables.

SAE AS39901 Revision A

- 4.5.1 Examination of Product: All of the bearings shall be examined for conformance to this specification and applicable standards as to:
- a. Dimensions 3.4.1
 - b. Lubrication provisions 3.4.5
 - c. Lubrication 3.4.6
 - d. End washers 3.4.7
 - e. Identification of product 3.6
 - f. Workmanship 3.9
 - g. Threads (Types VII, VIII and IX bearings only) 3.4.8
- 4.5.2 Hardness: The hardness shall be measured in accordance with ASTM E 18 on the applicable rings, stud, end washers and three (3) rollers from each of the bearings tested (see 3.4.2).
- 4.5.3 Surface Finish: The surface finish shall be measured in accordance with ANSI B146.1 on the inner and outer raceways, the inside contact surface of the end washers, the self-aligning surfaces (if applicable), and three (3) rollers from each of the bearings tested (see 3.4.3).
- 4.5.4 Plating: Cadmium and chromium plating shall be tested for conformance with AMS-QQ-P-416 or AMS-QQ-C-320, as applicable, to comply with the type and class specified on the drawing standard.
- 4.5.5 Lubrication: The lubrication shall be inspected for quantity and cleanliness and be in accordance with the type of grease specified on the QPL and applicable drawing standard.
- 4.5.6 Radial Runout: Bearings shall be tested for radial runout. Type I bearings shall be mounted as shown on Figure 4a. Types V, VI, and X bearings shall be hand pushed on a tapered horizontal arbor and the arbor supported on a V-block or on centers (see Figure 4c). Types VII, VIII, and IX bearings shall be mounted as shown Figure 4d. Types III and IV bearings shall not be tested for radial runout. A dial indicator placed against the outer ring shall be used to indicate radial runout. Outer ring radial runout shall be measured by rotating the outer ring while holding the stud or inner ring. Inner ring radial runout shall be measured by rotating the inner ring while holding the outer ring (see 3.5.1).
- 4.5.7 Radial Internal Clearance: Bearings shall be measured for radial internal clearance under a 5 lb \pm 10% reversing radial load. The inner ring or stud shall be held rigidly and the radial load applied alternately in opposite directions to the outer ring. A dial indicator shall be used to indicate this movement. The radial clearance shall not exceed the amount specified on the applicable drawing standard (see Figures 1A, 1B, 1C, and 1D).
- 4.5.7.1 Types I, V, VI, VII, VIII, IX, and X Bearings: Radial internal clearance shall not exceed the amount specified on the applicable drawing standard (see Figure 1A for Type I bearings, Figure 1C for Types V, VI, and X bearings, and Figure 1D for Types VII, VIII, and IX bearings).

SAE AS39901 Revision A

- 4.5.7.2 Type II Bearings: This type shall be measured while pressed into a housing gage as shown on Figure 1A. The bearing shall not lock up when pressed into the low limit gage. Maximum radial clearance shall not exceed the amount specified on the applicable drawing standard while the bearing is pressed into the low limit gage. High and low limit gage sizes are the high and low limit housing bore sizes indicated in tolerance tables of the appropriate drawing standard.
- 4.5.7.3 Types III and IV Bearings: Total radial clearance in the bearing shall be measured in the same manner as for other types. Radial clearance shall not exceed the amount specified on the applicable drawing standard (see Figure 1B). A complete bearing shall be used for this test. These types shall also be tested for radial clearance between the self-aligning members while pressed into a low limit gage and mounted snugly on a tapered arbor. Rollers and inner ring shall be removed and the outer ring mounted on the arbor. The radial clearance shall not exceed the amount specified in 3.5.2.1.
- 4.5.8 Axial Internal Clearance: Bearings shall be measured for axial internal clearance under a 5 lb \pm 10% reversing axial load. The outer ring shall be held rigidly and an axial load applied alternately in opposite directions to the inner ring or stud. A dial indicator shall be used to indicate this movement (see Figures 2A and 2B). The axial clearance shall not exceed the maximum specified in 3.5.3.
- 4.5.9 Dimensional Stability: The outside diameter of three (3) bearings of each drawing size submitted for qualification shall be measured at room temperature and recorded. The test shall be as follows:
- The bearings shall be heated to 250 °F \pm 10 °F and held for 96 hours minimum, allowed to cool to room temperature, measured, and recorded.
 - The bearings shall then be cooled to -65 °F \pm 10 °F and held for 96 hours minimum, allowed to warm to room temperature, measured and recorded.
 - The measurements shall be made at the same location for each bearing measurement (see 3.5.4).
- 4.5.10 Axial Compression Load Test: Bearings shall be tested for freedom of rotation while under an axial load. Types I, II, III, IV, V, VI, and X bearings shall be mounted and the load applied as shown on Figure 3A. Loads applied shall be in accordance with Table 7. Types VII, VIII, and IX bearings shall be mounted as shown on Figure 3B. The nut shall be torqued to value shown on the appropriate drawing standard (see 3.5.5).
- 4.5.11 End Washer Pushout: Bearings shall be placed in a bearing housing, as shown on Figures 4A and 4B. The appropriate end washer pushout load specified in 3.5.6 shall be applied for one minute. Position of all types with exception of Types VII, VIII, and IX bearings shall be reversed and the test repeated (see 3.5.6).

SAE AS39901 Revision A

- 4.5.12 Self-alignability: Bearings of Types III and IV shall be tested for self-alignability while clamped with maximum clamping (d_a) diameters specified in the drawing standard (see Figure 1E and 3.5.7).
- 4.5.13 Seal Test (Grease Retention): The bearings of each representative size shall be filled at least 80% full by volume with MIL-PRF-81322 grease. Prior to testing the dry bearing weights and greased weights shall be recorded. The bearings shall be wiped free of external grease and weighed. The bearings shall be mounted on a horizontal shaft in the test chamber, with no applied load, at 3 rpm, with the outer rings held stationary. The chamber temperature shall be maintained at a minimum of 250 °F for 100 hours. After testing they shall again be wiped free of grease and weighed (see 3.5.8.1).

$$\% \text{ grease retained} = 100(W_{pt} - W_d) / (W - W_d) \quad (\text{Eq. 1})$$

where:

W = Weight of the greased bearing with grease wiped off external surfaces

W_d = Dry weight of the bearing components (alternate method of weighing bearing components after cleaning is acceptable)

W_{pt} = Weight of bearing after testing with grease wiped off external surfaces

- 4.5.14 Seal Test (Dust Contamination): Bearings as specified in 3.5.8 shall be tested for dust contamination in an enclosed chamber as described in 4.5.14.2. The bearings of each size tested shall be mounted on a horizontal shaft in the test chamber, with no applied load, at 3 rpm, with the outer rings held stationary. The bearings shall be tested for a duration of 48 hours minimum at an ambient temperature of 77 °F ± 5 °F. The test media shall be SAE Coarse Grade Arizona Road Dust in accordance with ISO 12103.1 (see 4.5.14.1). Pre-test measurements of the starting torque and radial internal clearance shall be made and recorded for each bearing. Post-test measurements for starting torque shall be made in the "as tested" condition. Before post-test measurement of the radial internal clearance, the bearings shall be disassembled, thoroughly cleaned, re-assembled and re-lubricated with MIL-PRF-81322 grease.
- 4.5.14.1 Test Media (Dust): The test media shall be Arizona Road Dust in accordance with ISO 12103-1 supplied to SAE coarse grade (see 6.4). The coarse mixture shall be in accordance with Table 6.
- 4.5.14.2 Dust Test Chamber: The dust test chamber shall be cubic, approximately 2 feet per side, with viewing ports for test observation. A minimum layer of 1 inch test media (see 4.5.14.1) shall be maintained on the chamber floor. Test chamber actuation shall provide a continuous movement of dust, creating a uniform cloud which shall render the test bearings difficult to see through the viewing ports. Test bearings shall have a minimum spacing of 3 inches from each other and the chamber walls. The mounting shaft shall be 8 to 16 inches above the chamber floor.

SAE AS39901 Revision A

4.5.15 Static Limit Load Rating: Types I, II, III, and IV bearings shall be mounted in a rigid support as shown on Figure 5A, Types V, VI, and X bearings shall be mounted in rigid support as shown on Figure 5B, Types VII, VIII, and IX bearings shall be mounted in a rigid support as shown on Figure 5C. The bearings shall be tested according to the following procedure and sequence:

- a. Step 1: Rotate the bearing manually to determine operational smoothness.
- b. Step 2: Measure the frictional starting torque.
- c. Step 3: Apply load equal to the appropriate "Static Limit Load Rating" specified on the applicable drawing standard for 1 minute.
- d. Step 4: Remove load and inspect for evidence of failure.
- e. Step 5: Measure frictional starting torque (see 3.5.9.1).

4.5.16 Static Ultimate Load Rating: A load equal to the Static Ultimate Load Rating (1.5 times the Static Limit Load) specified on the applicable drawing standard shall be applied for 1 minute (see Figure 5A for Types I, II, III, and IV, Figure 5B for Types V, VI, and X, and Figure 5C for Type VII, VIII, and IX. After removal of this load, the bearings shall be examined for rotation by hand. The bearings shall be disassembled and the inner and outer rings and the rollers shall be magnetic particle inspected in accordance with ASTM E 1444 (see 3.5.9.2).

4.5.17 Dynamic Load Rating as a Track Roller: Bearings shall be tested under a load equal to the load rating as a track roller. The tests shall be performed at speeds of 10 to 100 revolutions per minute until 20,000 revolutions have been completed. The bearings may be relubricated during the test. The test shall be performed on a test support similar to the illustrations on Figure 5C for Types VII, VIII, and IX bearings and Figure 5B for Types V, VI, and X bearings (see 3.5.9.3).

4.6 Inspection of Packaging:

4.6.1 Packaging shall be examined for conformance with Section 5 of this specification.

5. PACKAGING:

5.1 Preservation:

Packaging, packing, and marking shall be in accordance with MIL-DTL-197 for levels and packaging method as specified in the contract or order.

SAE AS39901 Revision A

- 5.1.1 Marking for Shipment and Storage: Nomenclature marking for interior and exterior containers shall conform to the following in lieu of the item description requirements of MIL-STD-129.

BEARINGS, ROLLER, NEEDLE, (SINGLE ROW, HEAVY DUTY), (SINGLE ROW, THIN SHELL), (SINGLE ROW, HEAVY DUTY, SELF-ALIGNING), (DOUBLE ROW, HEAVY DUTY, SELF-ALIGNING), (SINGLE ROW, HEAVY DUTY, TRACK ROLLER), (SINGLE ROW, HEAVY DUTY, TRACK ROLLER, SEALED), (DOUBLE ROW, HEAVY DUTY, TRACK ROLLER), (DOUBLE ROW, HEAVY DUTY TRACK ROLLER, SEALED), (TRACK ROLLER, INTEGRAL STUD), (TRACK ROLLER, CROWN RADIUSED O.D., INTEGRAL STUD, TYPE VII), (TRACK ROLLER, INTEGRAL STUD, SEALED), (TRACK ROLLER, INTEGRAL HEAVY STUD, SEALED), OR (HEAVY DUTY, TRACK ROLLER, SEALED), ANTIFRICTION, INCH.

6. NOTES:

6.1 Intended Use:

Airframe anti-friction needle roller bearings are intended primarily for use in flight vehicle control systems in which the load is radial.

6.2 Ordering Data:

Procurement documents should specify the following:

- a. Title number, and date of this specification
- b. Complete MS part number (see 1.2 for type and associated standard)
- c. Quantity
- d. Applicable level of preservation, packaging and packing (see 5.1)

6.3 Qualification of Product:

With respect to products requiring qualification, awards will be made only for products which are, at the time set for opening of bids, qualified for inclusion in the applicable Qualified Products List (SAE-QPL-AS39901), whether or not such products have actually been so listed by that date. The attention of the contractors is called to this requirement, and manufacturers are urged to arrange to have the products that they propose to offer to the Federal Government tested for qualification in order that they may be eligible to be awarded contracts or orders for the products covered by this specification. The qualifying activity is the Naval Air Systems Command, Code 4.3.5.4. Information pertaining to qualification of products may be obtained from the qualifying activity, Commander, Naval Air Systems Command, Code 4.3.5.4, Building 2187, 48110 Shaw Road, Patuxent River, MD 20670-1906.

- 6.3.1 Qualification of a Bearing Distributor: Department of Defense (DoD) standardization regulations have specific requirements covering qualification approval of a distributor. Details of these requirements may be obtained from the qualifying activity (see 6.3).

SAE AS39901 Revision A

6.3.2 Procurement of Bearings from a Distributor not Listed on the QPL: Government contractors and subcontractors who plan to acquire a qualified bearing from a distributor not listed on the QPL should be aware that distributors frequently stock bearings which were manufactured several years earlier. Since document requirements are occasionally changed without a corresponding change in part marking, the parts offered for sale by the distributor may not meet current document requirements. To assure that parts meet current document requirements, the contractor should require the following information from the distributor:

- (1) Certification that the bearings have been inspected for compliance to the current document requirements.
- (2) Certification of the original manufacturer's name, part number and date of lubrication on the outside of each unit package.

(NOTE: DoD regulations state that only distributors who have been approved by the qualifying activity for listing on a QPL may re-brand a QPL listed item.)

6.4 Dust Test Media:

The dust test media may be purchased from Powder Technologies Inc., P.O. Box 1464, Burnsville, MN 55337, or from other sources.

6.5 Subject Term (Keyword) Listing:

Anti-friction
Bearing
Cadmium plating
Chrome plating
Lubricated
Needle roller

6.6 The change bar (I) located in the left margin is for the convenience of the user in locating areas where technical revisions, not editorial changes, have been made to the previous issue of this document. An (R) symbol to the left of the document indicates a complete revision of the document.

PREPARED BY THE AIRFRAME CONTROL BEARINGS GROUP

SAE AS39901 Revision A

TABLE 1 - Qualification Examinations and Test Samples

Examination or Test	Sample Number																		Requirement Paragraph	Test Method Paragraph
	1	2	3	4	5	6	7	8	9	10	11	12	13-18	19-28						
Examination of Product	X	X	X	X	X	X	X	X	X	X	X	X	X-X	X-X	3.4.1, 3.4.8, 3.6, 3.8	4.5.1				
Hardness	X	X	X												3.4.2	4.5.2				
Plating	X	X	X												3.4.4	4.5.4				
Surface Finish	X	X	X												3.4.3	4.5.3				
Lubrication	X	X	X												3.4.5	4.5.5				
Radial Runout				X	X	X	X	X	X	X	X	X			3.5.1	4.5.6				
Radial Internal Clearance				X	X	X	X	X	X	X	X	X			3.5.2	4.5.7				
Axial Internal Clearance				X	X	X	X	X	X	X	X	X			3.5.3	4.5.8				
Dimensional Stability				X	X										3.5.4	4.5.9				
Axial Compression							X	X	X						3.5.3	4.5.10				
End Washer Pushout	X	X													3.5.6	4.5.11				
Self-Alignability									X	X	X	X			3.5.7	4.5.12				
Seals - Grease Retention									X	X	X	X			3.5.8, 3.5.8.1	4.5.13				
Seals - Dust Test													X-X		3.5.8, 3.5.8.2	4.5.14				
Radial Static Limit Load				X	X										3.5.9.1	4.5.15				
Radial Static Ultimate Load							X	X	X						3.5.9.2	4.5.16				
Dynamic Load Rating as a Track Roller														X-X	3.5.9.3	4.5.17				

SAE AS39901 Revision A

TABLE 2 - Qualification Test Samples

Type	MS Dash Number		
	Small	Medium	Large
I	-6	-20	
II	-4	-8	-16
III	n/a	-5	n/a
IV	-6	-10	-20
V	-6	-14	-24
	-106	-114	-124
VI	-6	-14	-24
	-106	-114	-124
VII	-2	-4	-6
VIII	-101	-281	-481
IX	-101	-281	-481
X	-121	-281	-481

TABLE 3 - Retention of Qualification Examinations and Test Samples

Examination or Test	Sample Number													Requirement Paragraph	Test Method Paragraph
	1	2	3	4	5	6	7	8	9	10	11	12	13		
Examination of Product	X	X	X	X	X	X	X	X	X	X	X	X	X	3.4.1, 3.4.8, 3.6, 3.8	4.5.1
Radial Internal Clearance				X	X	X	X	X	X	X	X	X	X	3.5.2	4.5.7
Axial Internal Clearance				X	X	X	X	X	X	X	X	X	X	3.5.3	4.5.8
Radial Runout				X	X	X	X	X	X	X	X	X	X	3.5.1	4.5.6
End Washer Pushout	X	X	X											3.5.6	4.5.11
Hardness	X	X	X											3.4.2	4.5.2
Plating	X	X	X											3.4.4	4.5.4
Surface Finish	X	X	X											3.4.3	4.5.3
Lubrication	X	X	X											3.4.5	4.5.5

SAE AS39901 Revision A

TABLE 4 - Conformance Tests

Examination or Test	Major Characteristic	Minor Characteristic	Requirement Paragraph	Test Paragraph
Dimensions			3.4.1	4.5.1
Bore/Stud Dia.	X		3.4.1	4.5.1
O.D.	X		3.4.1	4.5.1
Inner Ring Width/Stud Length (Type VII, VIII, & IX)	X		3.4.1	4.5.1
Outer Ring Width	X		3.4.1	4.5.1
Track Contact Width (If Applicable)		X	3.4.1	4.5.1
Inner Ring/Stud Chamfer/Raduis		X	3.4.1	4.5.1
Outer Ring Chamfer/Radius		X	3.4.1	4.5.1
Thread Size (Type VII, VIII, & IX)	X		3.4.1	4.5.1
Thread Length (Type VII, VIII, & IX)		X	3.4.1	4.5.1
Cotter Pin Hole Dia. (If Applicable)		X	3.4.1	4.5.1
Cotter Pin Hole Locations (If Applicable)		X	3.4.1	4.5.1
End Washer Dia.		X	3.4.1	4.5.1
Annular Groove Width		X	3.4.1	4.5.1
Lubrication Provisions		X	3.4.5	4.5.1
Workmanship		X	3.8	4.5.1
Marking		X	3.6	4.5.1
Hardness		X	3.4.2	4.5.2
Surface Finish		X	3.4.3	4.5.3
Lubrication		X	3.4.5	4.5.5
Radial Internal Clearance	X		3.5.2	4.5.7
Axial Internal Clearance	X		3.5.3	4.5.8
Plating		X	3.4.4	4.5.4

SAE AS39901 Revision A

TABLE 5 - Sampling Plan for Quality Conformance Tests

LOT SIZE	SAMPLE SIZE "A" indicates the entire lot must be inspected.	
	Major Characteristics	Minor Characteristics
1-2	A	A
3-8	A	3
9-12	A	3
13-15	13	3
16-25	13	3
26-50	13	5
51-90	13	6
91-150	13	7
151-280	20	10
281-500	29	11
501-1200	34	15
1201-1249	42	18
1250-3200	42	18
3201-10,000	50	22

TABLE 6 - Dust Test Media

Particle Size	Percent (%)
0>=<5 microns	12%
5>=<10"	12
10>=<20"	14
20>=<40 "	23
40>=<80 "	30
80>=<200 "	9
	100%

TABLE 7 - Axial Compression Load

Bearing Bore Dia. or Stem Dia. -Inch	.1875	.250	.3125	.375	.4375	.500
Axial Load - lbf.	480	870	1,400	2,100	2,850	3,800
Bearing Bore Dia. or Stem Dia. -Inch	.5625	.625	.750	.875	1.000	1.250
Axial Load - lbf.	4,870	6,150	8,950	12,200	16,300	25,800

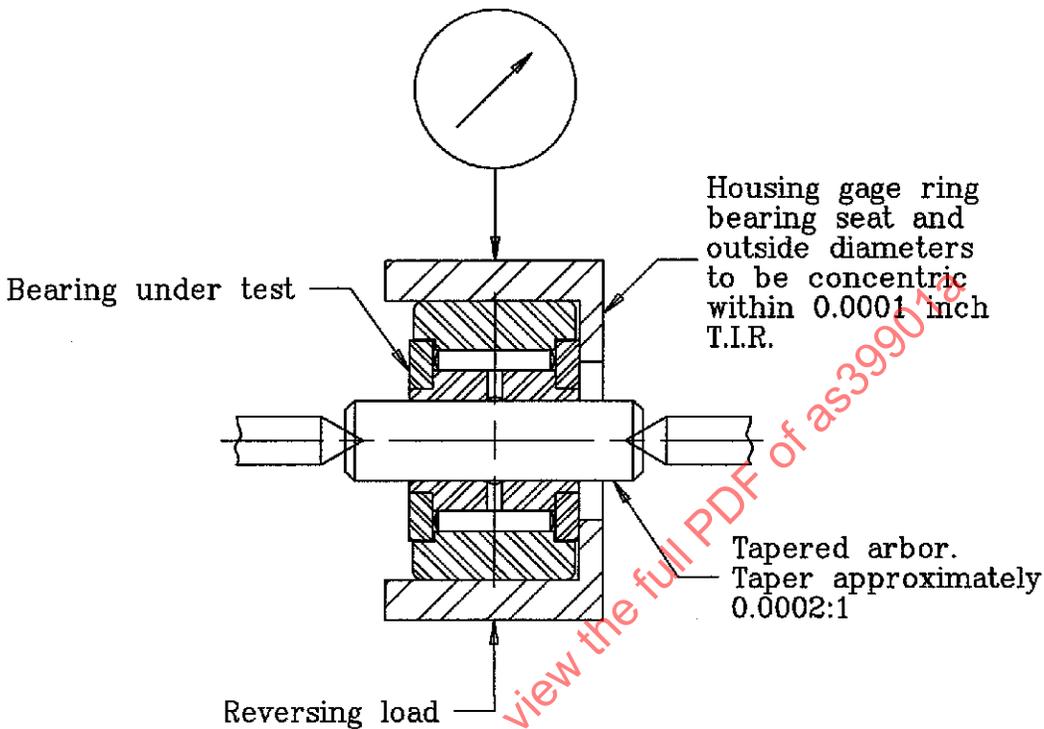


FIGURE 1A - Radial Internal Clearance and Radial Runout Test for Type I Bearings

SAE AS39901 Revision A

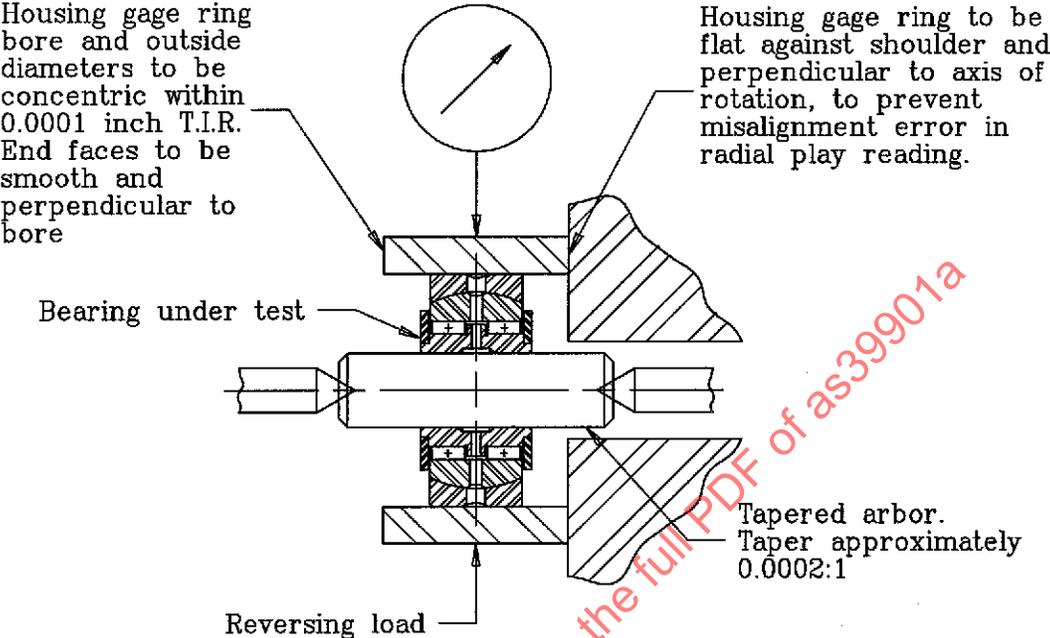


FIGURE 1B - Radial Internal Clearance Test for Type III and IV Bearings

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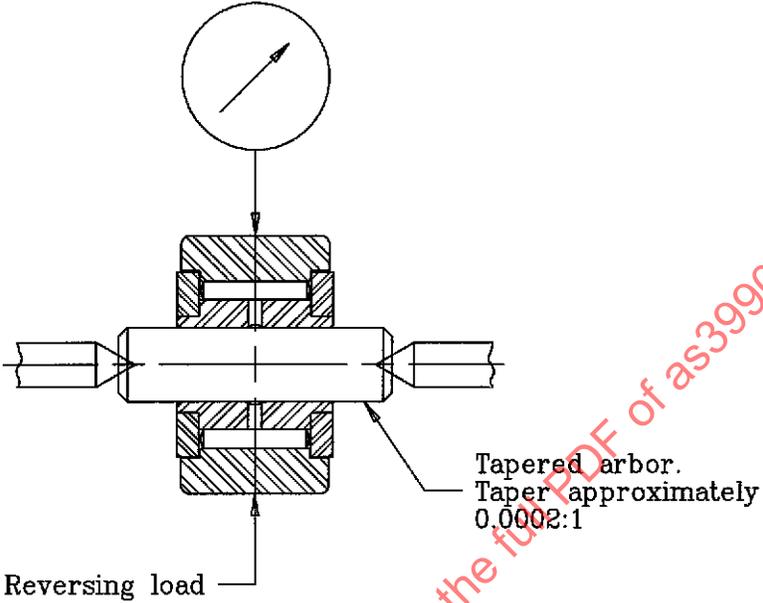


FIGURE 1C - Radial Internal Clearance and Radial Runout Test for Type V, VI, and X Bearings

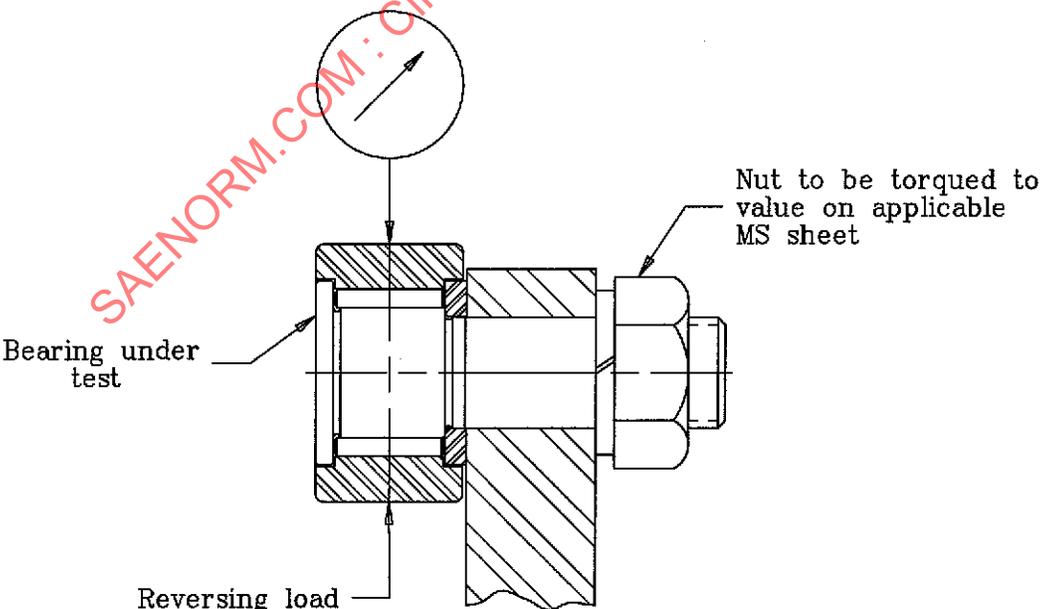


FIGURE 1D - Radial Internal Clearance and Radial Runout Test for Type VII, VIII, and IX Bearings

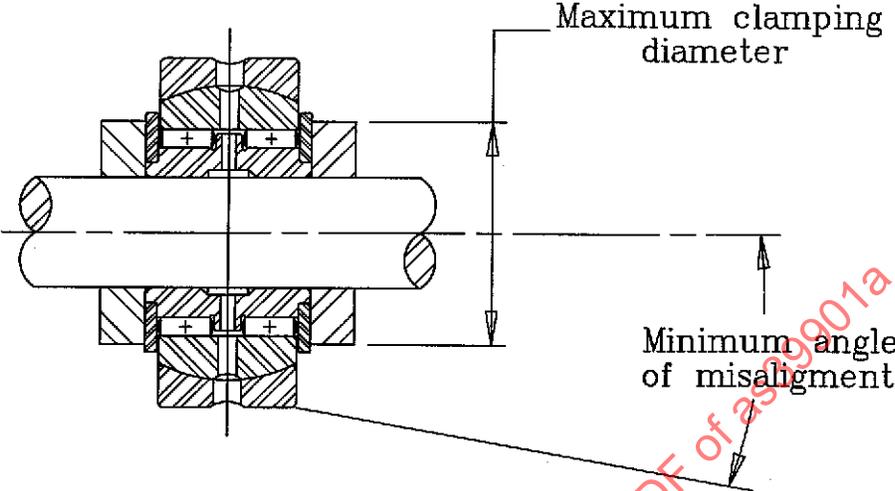


FIGURE 1E - Self-aligning Test for Type III and IV Bearings

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SAE AS39901 Revision A

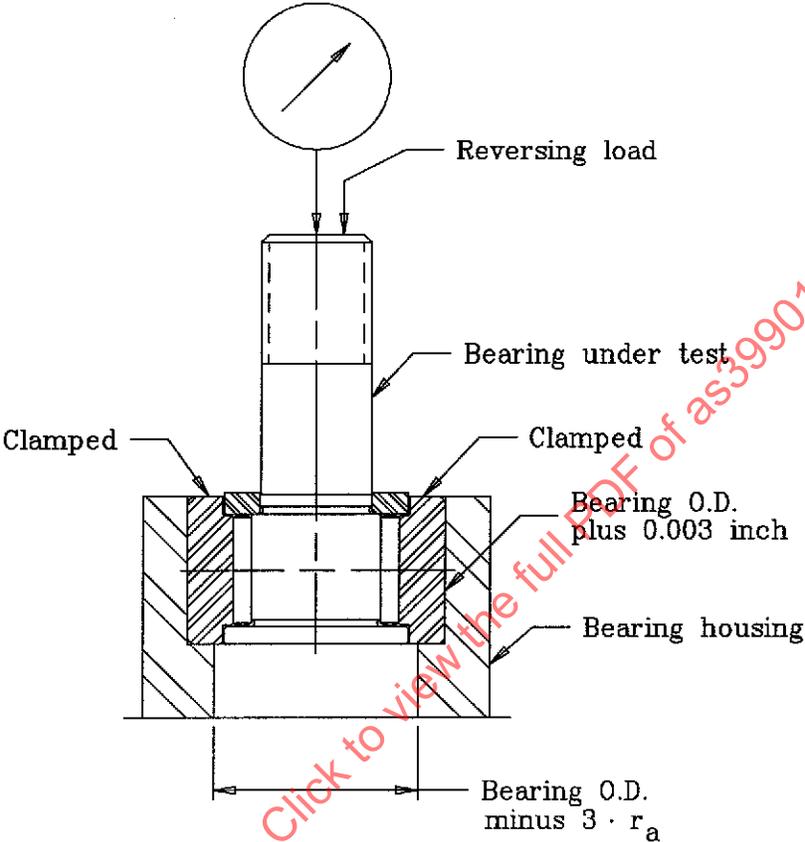


FIGURE 2A - Axial Internal Clearance Test for Type VII, VIII, and IX Bearings