

Series 04 Cartridge Cavities

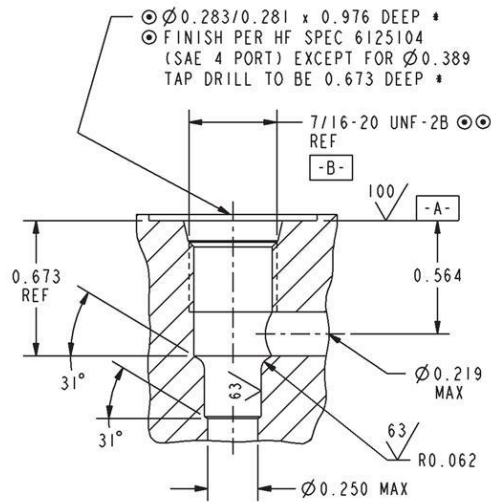
Friday, August 10, 2007

11:57 PM

TECHNICAL REFERENCE

Series 04 Cartridge Cavities

VC04-2



NOTES:

- FEATURES (EXCEPT FOR PILOT DRILL, CROSS DRILL AND SAE 4 PORT) CAN BE MACHINED SIMULTANEOUSLY USING HYDRAFORCE FORM TOOLS. CONSULT FACTORY.

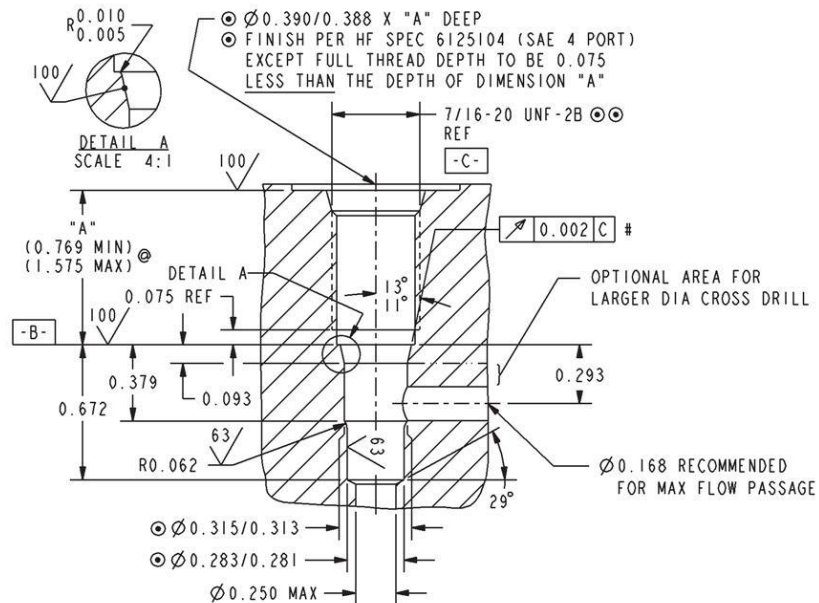
Ⓞ	0.001	A	ⓄⓄ	0.001	A
Ⓞ	0.002	B	Ⓞ	0.0009	(PITCH DIA)

* - DEPTHS ARE FROM DATUM -A- .

- UNSPECIFIED TOLERANCES ARE ± 0.005 .

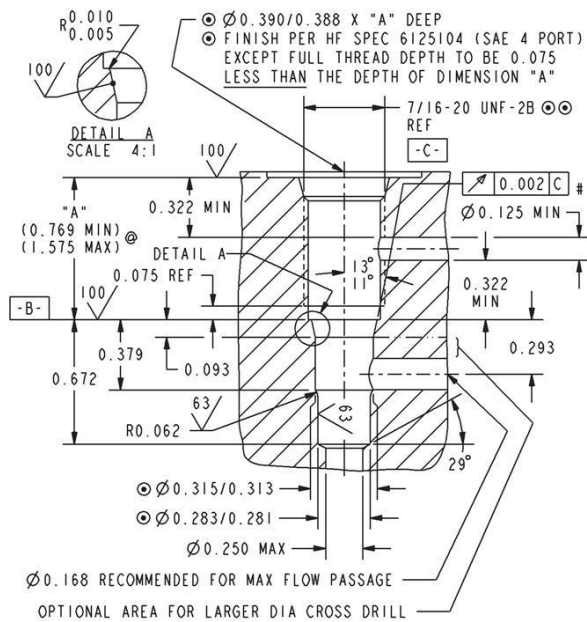
- UNSPECIFIED ANGULAR DIMENSIONS $\pm 3^\circ$.

VC04-B2



Series 04 Cartridge Cavities

VC04-B3



NOTES:

- THE ABOVE FEATURES (EXCEPT FOR PILOT DRILL, CROSS DRILLS AND SAE 4 PORT) CAN BE MACHINED SIMULTANEOUSLY USING HYDRAFORCE FORM TOOLS. CONSULT FACTORY.
- | | | |
|--|-------|---|
| | 0.001 | B |
| | 0.002 | C |

	0.001	B
	0.0009	(PITCH DIA)
- UNSPECIFIED TOLERANCES ARE ± 0.005 .
 - UNSPECIFIED ANGULAR DIMENSIONS $\pm 3^\circ$.
 - @ - WITH HF FORM TOOLS AND USING 0.020/0.010 SPOTFACE DEPTH.
 - # - THIS SURFACE IS A VALVE SEAT, IT MUST BE FREE OF NICKS AND TOOL MARKS.