

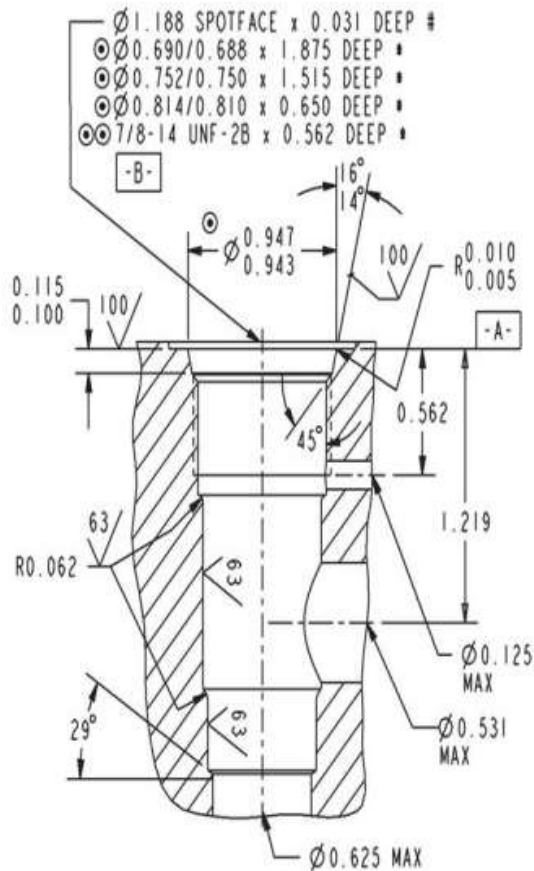
Series 10 Cartridge Cavities

Wednesday, August 08, 2007

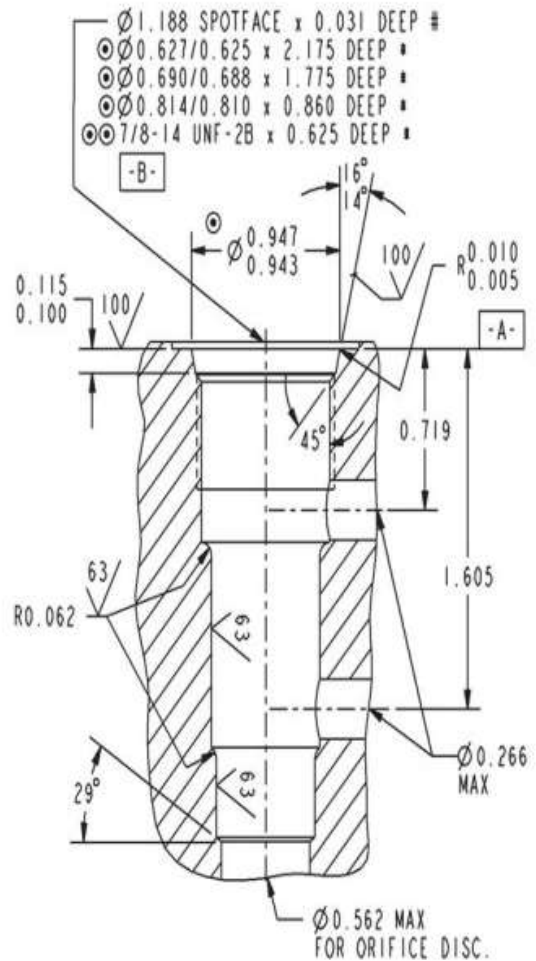
11:47

Series 10 Cartridge Cavities

VC10-S3



VC10-L3



NOTES:

- THE ABOVE FEATURES (EXCEPT FOR PILOT DRILL AND CROSS DRILLS) CAN BE MACHINED SIMULTANEOUSLY USING HYDRAFORCE FORM TOOLS. CONSULT FACTORY.

\odot -

$\frac{1}{16}$	0.001	A
$\frac{1}{32}$	0.002	B

$\odot \odot$ -

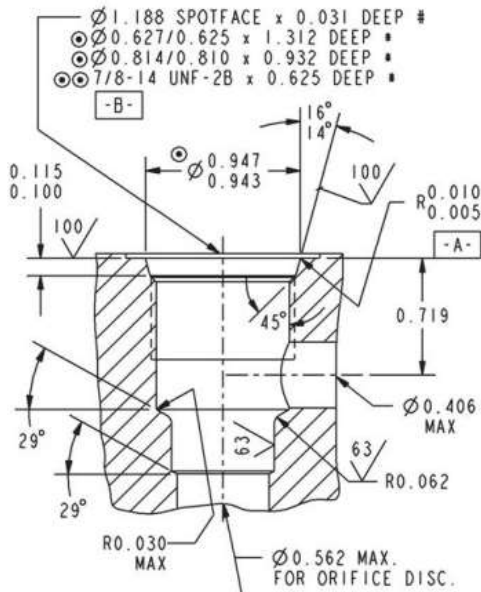
$\frac{1}{16}$	0.001	A
$\frac{1}{32}$	0.0009	(PITCH DIA)

- DEPTHS ARE FROM DATUM **-A-**.
- UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.
- UNSPECIFIED TOLERANCES ARE ± 0.005 .
- UNSPECIFIED ANGULAR DIMENSIONS $\pm 3^\circ$.

TECHNICAL REFERENCE

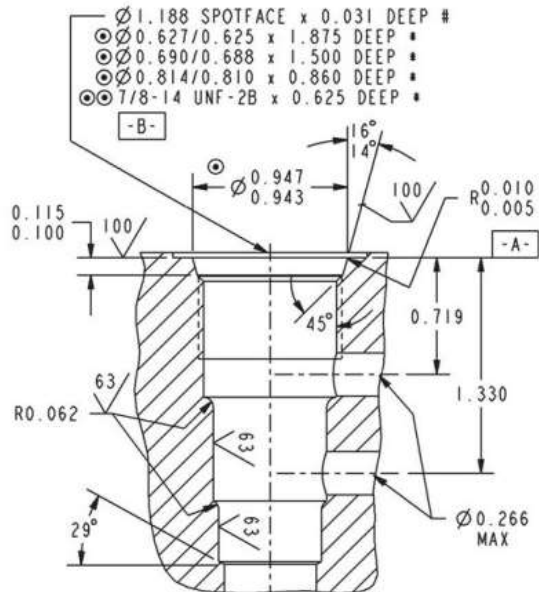
Series 10 Cartridge Cavities

VC10-2



NOTE:
CAVITY VARIATION 'A'**
PILOT DRILL $\varnothing 0.562$ MIN.
REQUIRED TO MIN. DEPTH
OF 1.50 FROM SPOTFACE

VC10-3



NOTE:
CAVITY VARIATION 'A'**
PILOT DRILL $\varnothing 0.562$ MIN.
REQUIRED TO MIN. DEPTH
OF 2.06 FROM SPOTFACE

NOTES:

- THE ABOVE FEATURES (EXCEPT FOR PILOT DRILL AND CROSS DRILLS) CAN BE MACHINED SIMULTANEOUSLY USING HYDRAFORCE FORM TOOLS. CONSULT FACTORY.

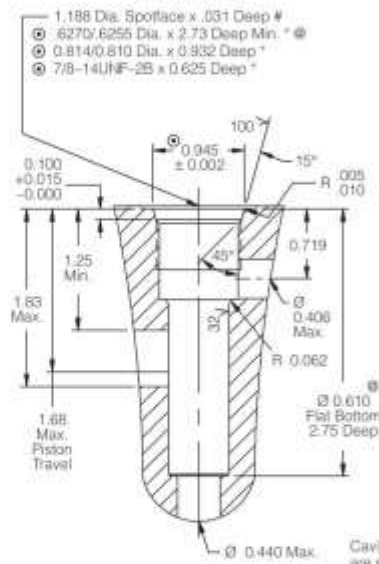


- * - DEPTHS ARE FROM DATUM -A-.
- # - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.
 - UNSPECIFIED TOLERANCES ARE ± 0.005 .
 - UNSPECIFIED ANGULAR DIMENSIONS $\pm 3^\circ$.
- ** - FEATURES OF VARIATION 'A' ARE ONLY REQUIRED IF NOTED ON A SPECIFIC PRODUCT CATALOG PAGE.

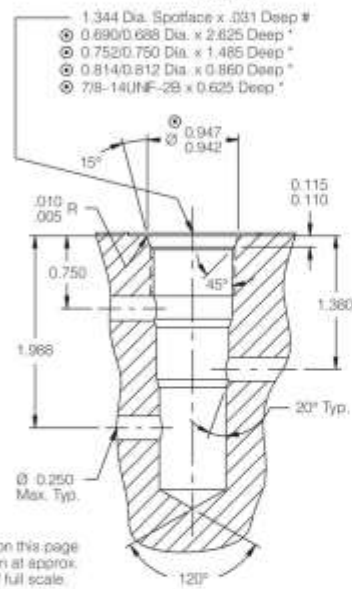
TECHNICAL REFERENCE

Series 10 Cartridge Cavities

VC10-PCV



VC98-3



Cavities on this page are shown at approx. 90% of full scale.

The above features (except for pilot drill & cross drills) can be machined simultaneously with a form tool.

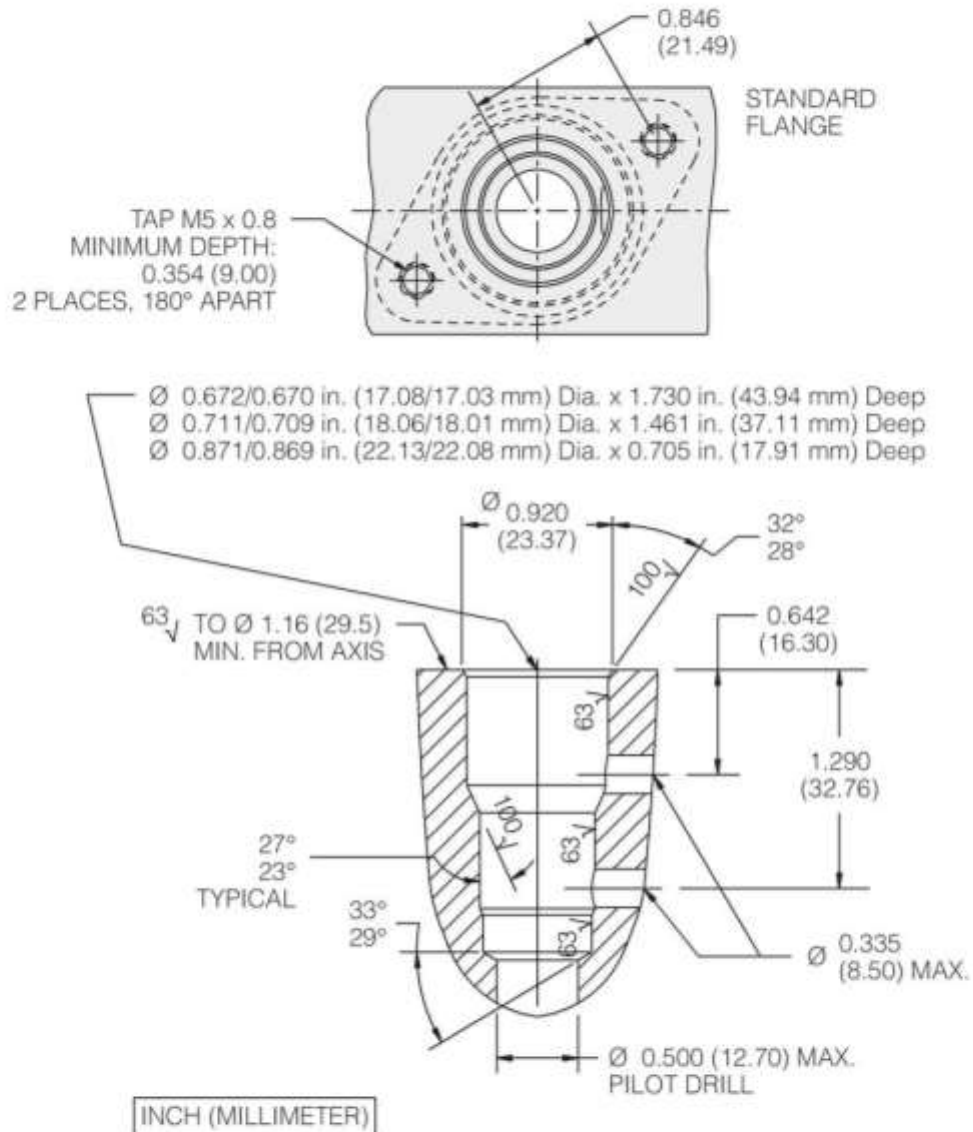
- Ⓢ — These diameters to be concentric within 0.002 T.I.R. and perpendicular to spotface within 0.001 T.I.R.
- * — Depths are from spotface.
- # — Unless otherwise specified on machining drawing Unspecified tolerances are ±0.005.
- Ⓢ — Flat bottom diameter is used as PCV piston stop. If alternate stop or if 0.626 diameter is deeper than min. shown above, then the piston stop must be within 0.025" max. of the depth of the 0.626 diameter.

The above features (except for pilot drill & cross drills) can be machined simultaneously with a form tool.

- All machined cavity surfaces \sqrt{R} maximum.
- Ⓢ — These diameters to be concentric within 0.002 T.I.R. and perpendicular to spotface within 0.001 T.I.R.
- * — Depths are from spotface.
- # — Unless otherwise specified on machining drawing Unspecified tolerances are ±0.005.

Series 10 Cartridge Cavities

VC-T001



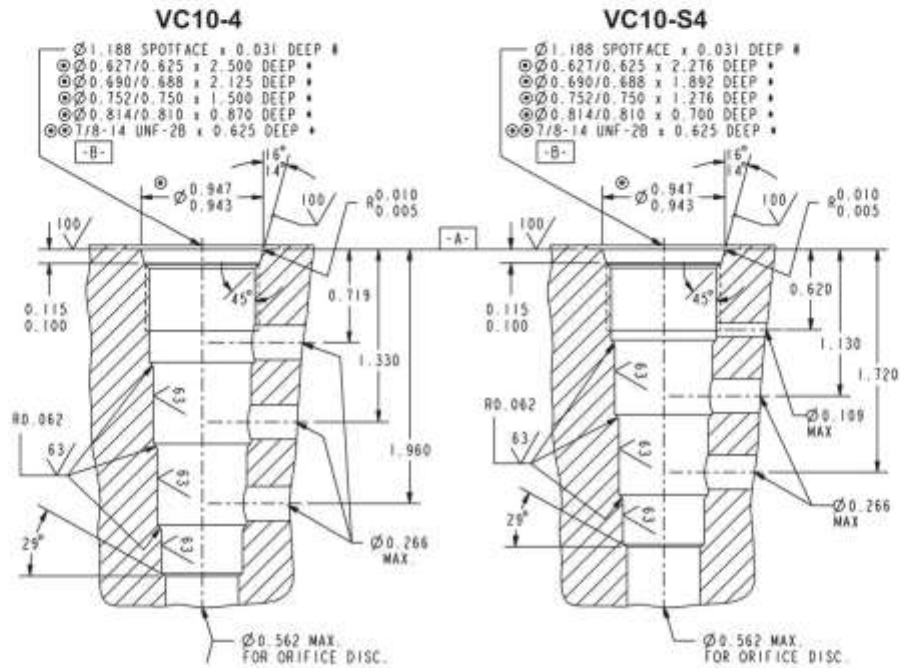
The above features (except for pilot drill & cross drills) can be machined simultaneously with a form tool.

All diameters, with exception of 0.500 in. (12.7 mm) Pilot Drill to be concentric within 0.002 in. (0.05 mm) T.I.R. and perpendicular to face within 0.002 in. (0.05 mm) T.I.R.

Unspecified tolerances are ±0.005 in. (0.13 mm).

TECHNICAL REFERENCE

Series 10 Cartridge Cavities



NOTES:

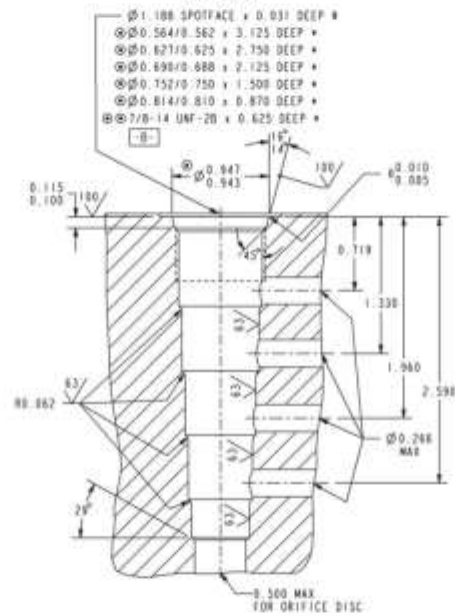
- THE ABOVE FEATURES (EXCEPT FOR PILOT DRILL AND CROSS DRILLS) CAN BE MACHINED SIMULTANEOUSLY USING HYDRAFORCE FORM TOOLS. CONSULT FACTORY.

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

- * - DEPTHS ARE FROM DATUM -A-
- # - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.
- UNSPECIFIED TOLERANCES ARE ±0.005.
- UNSPECIFIED ANGULAR DIMENSIONS ±3°.
- ** - FEATURES OF VARIATION 'A' ARE ONLY REQUIRED IF NOTED ON A SPECIFIC PRODUCT CATALOG PAGE.

Series 10 Cartridge Cavities

VC10-5



NOTES: - THE ABOVE FEATURES (EXCEPT FOR PILOT DRILL AND CROSS DRILLS) CAN BE MACHINED SIMULTANEOUSLY USING HYDRAFORCE FORM TOOLS. CONSULT FACTORY.

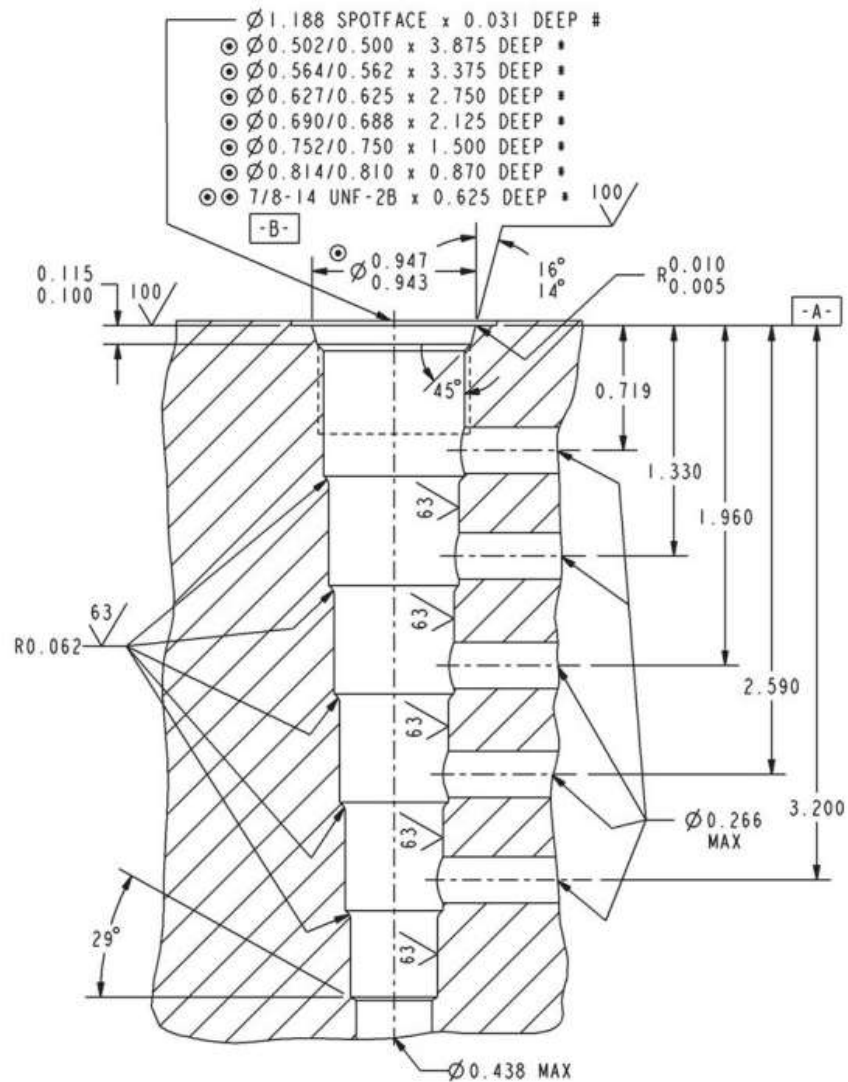
\varnothing - $\frac{0.001}{0.002}$ A B \varnothing - $\frac{0.001}{0.0009}$ A B (PITCH DIA)

- * - DEPTHS ARE FROM DATUM -A-
- * - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.
- UNSPECIFIED TOLERANCES ARE ± 0.005 .
- UNSPECIFIED ANGULAR DIMENSIONS $\pm 3^\circ$.

TECHNICAL REFERENCE

Series 10 Cartridge Cavities

VC10-6



- $\phi 1.188$ SPOTFACE x 0.031 DEEP #
- $\odot \phi 0.502/0.500$ x 3.875 DEEP *
- $\odot \phi 0.564/0.562$ x 3.375 DEEP *
- $\odot \phi 0.627/0.625$ x 2.750 DEEP *
- $\odot \phi 0.690/0.688$ x 2.125 DEEP *
- $\odot \phi 0.752/0.750$ x 1.500 DEEP *
- $\odot \phi 0.814/0.810$ x 0.870 DEEP *
- $\odot \odot 7/8-14$ UNF-2B x 0.625 DEEP * 100/

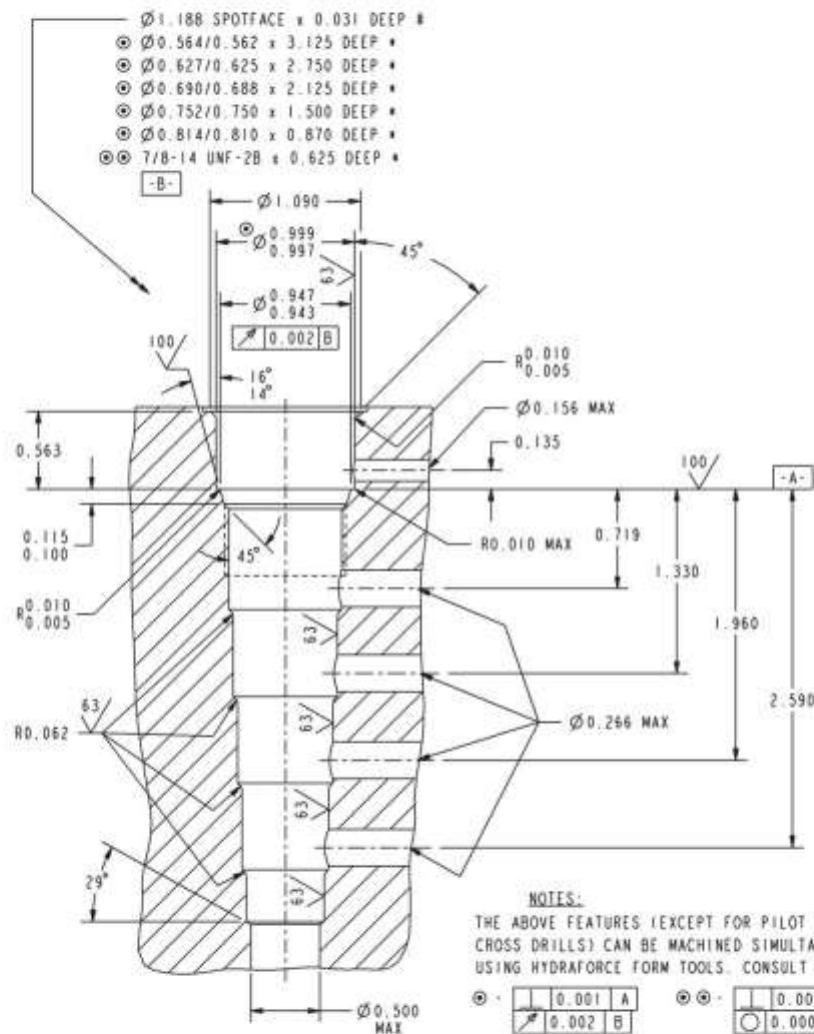
NOTES: - THE ABOVE FEATURES (EXCEPT FOR PILOT DRILL AND CROSS DRILLS) CAN BE MACHINED SIMULTANEOUSLY USING HYDRAFORCE FORM TOOLS. CONSULT FACTORY.

\odot	0.001	A	$\odot \odot$	0.001	A
\odot	0.002	B	\odot	0.0009	(PITCH DIA)

- * - DEPTHS ARE FROM DATUM **-A-**.
- # - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.
- UNSPECIFIED TOLERANCES ARE ± 0.005 . - UNSPECIFIED ANGULAR DIMENSIONS $\pm 3^\circ$.

Series 10 Cartridge Cavities

VC10-S6



- NOTES:**
- THE ABOVE FEATURES (EXCEPT FOR PILOT DRILL AND CROSS DRILLS) CAN BE MACHINED SIMULTANEOUSLY USING HYDRAFORCE FORM TOOLS. CONSULT FACTORY.
- ⊙ -

0.001	A
0.002	B

 ⊙ ⊙ -

0.001	A
0.0009	(PITCH DIA)
 - * - DEPTHS ARE FROM DATUM $-A-$.
 - # - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.
 - UNSPECIFIED TOLERANCES ARE ± 0.005 .
 - UNSPECIFIED ANGULAR DIMENSIONS $\pm 3^\circ$.

