

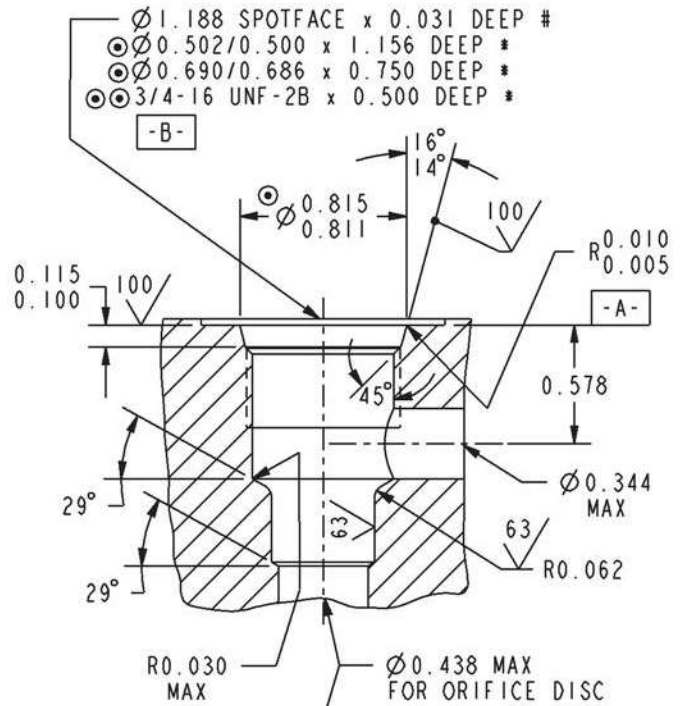
Series o8 cavities

Wednesday, August 08, 2007
11:29 PM

TECHNICAL REFERENCE

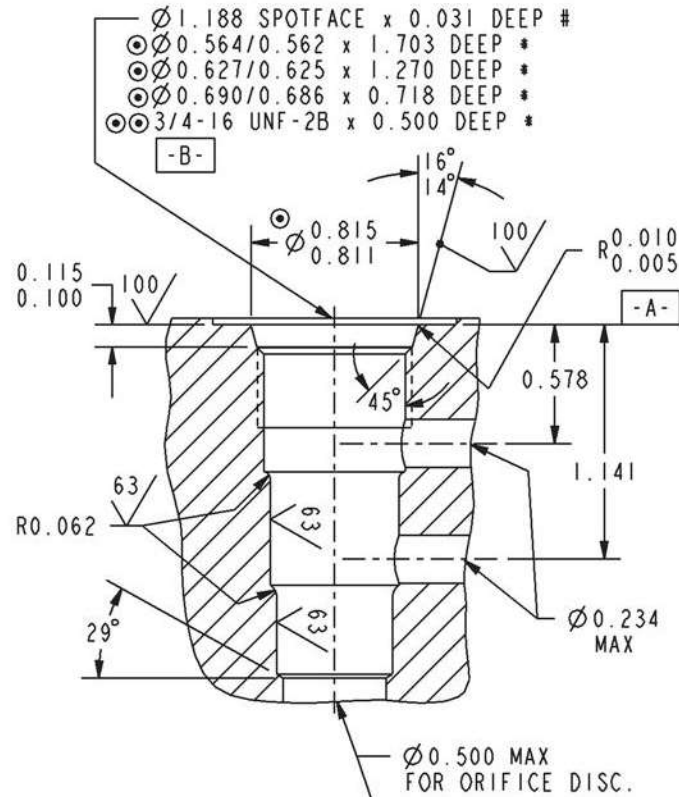
Series 08 Cartridge Cavities

VC08-2



NOTE:
 CAVITY VARIATION 'A' **
 PILOT DRILL $\varnothing 0.469$ MIN.
 REQUIRED TO MIN. DEPTH
 OF 1.32 FROM SPOTFACE

VC08-3



NOTE:
 CAVITY VARIATION 'A' **
 PILOT DRILL $\varnothing 0.500$ MIN.
 REQUIRED TO MIN. DEPTH
 OF 1.81 FROM SPOTFACE

NOTES:

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

\odot - <table border="1"> <tr><td>\perp</td><td>0.001</td><td>A</td></tr> <tr><td>∇</td><td>0.002</td><td>B</td></tr> </table>	\perp	0.001	A	∇	0.002	B	$\odot \odot$ - <table border="1"> <tr><td>\perp</td><td>0.001</td><td>A</td></tr> <tr><td>\bigcirc</td><td>0.0009</td><td>(PITCH DIA)</td></tr> </table>	\perp	0.001	A	\bigcirc	0.0009	(PITCH DIA)
	\perp	0.001	A										
∇	0.002	B											
\perp	0.001	A											
\bigcirc	0.0009	(PITCH DIA)											

* - DEPTHS ARE FROM DATUM -A- .

- UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.

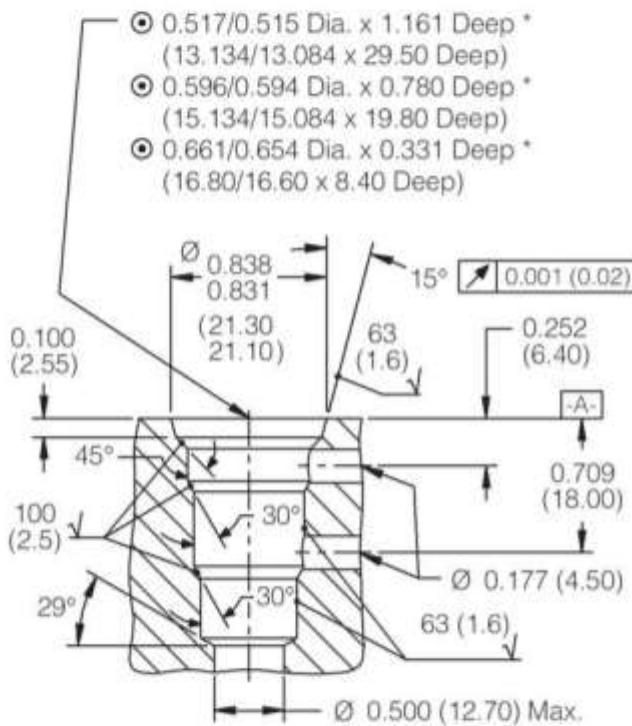
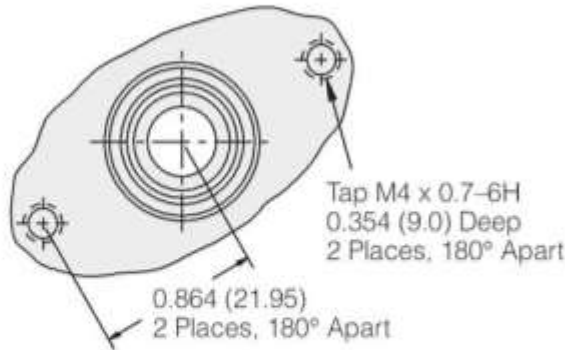
- UNSPECIFIED TOLERANCES ARE ± 0.005 .

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

** - FEATURES OF VARIATION 'A' ARE ONLY REQUIRED IF NOTED ON A SPECIFIC PRODUCT CATALOG PAGE.

Series 08 Cartridge Cavities

VC-T009



Inch (Millimeter)

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

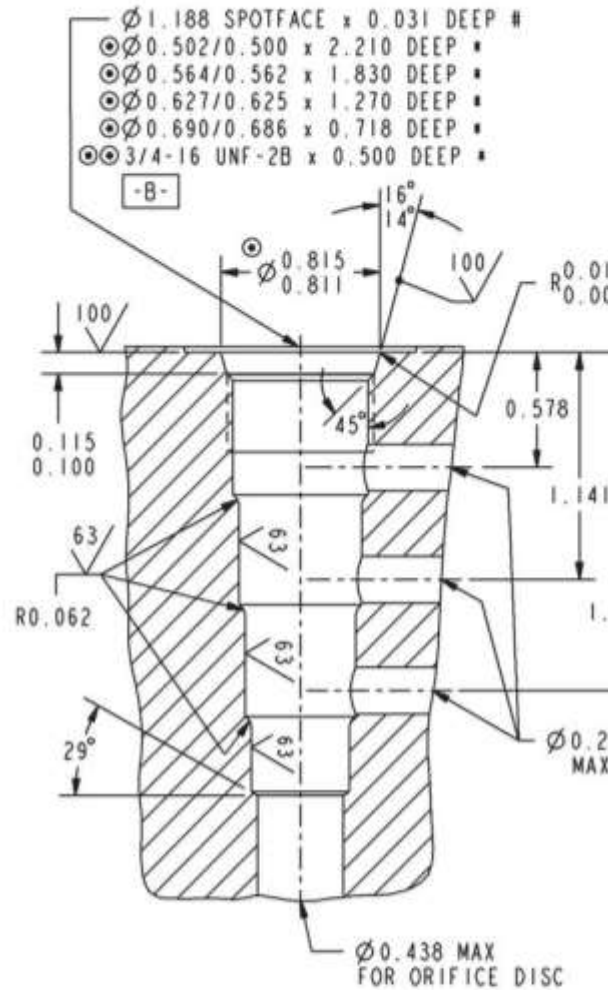
Cavity Tools: Rough: 7540420; Finish: 7540430; Finish with Tungsten Carbide Inserts: 7540435

- ⊙ — These diameters to be concentric within 0.002 T.I.R. and perpendicular to spotface within 0.001 T.I.R.

• — Depths are from datum **-A-**

Unspecified tolerances are ± 0.005

VC08-4



NOTES:

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

- ⊙ -

	0.001	A
	0.002	B
- ⊙⊙ -

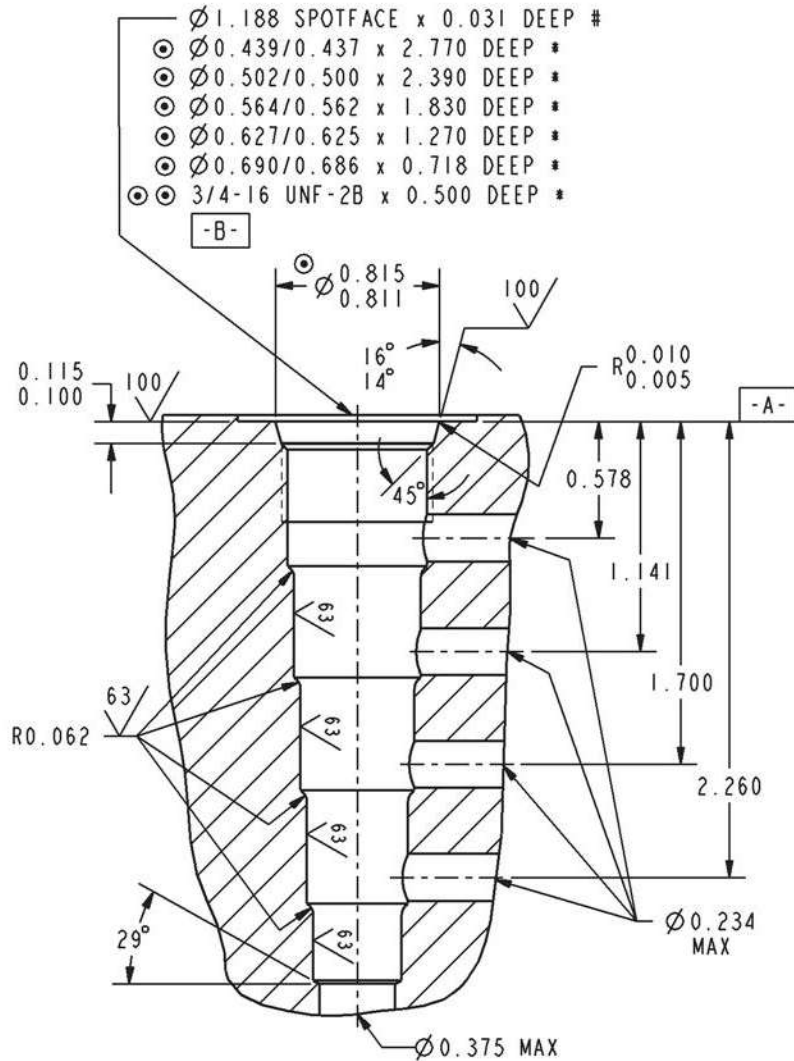
	0.001	A
	0.0009	(PITCH)

- - 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 AS NOTED ON A SPECIFIC PRODUCT CATALOG PAGE.

TECHNICAL REFERENCE

Series 08 Cartridge Cavities

VC08-5



NOTES:

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

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

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