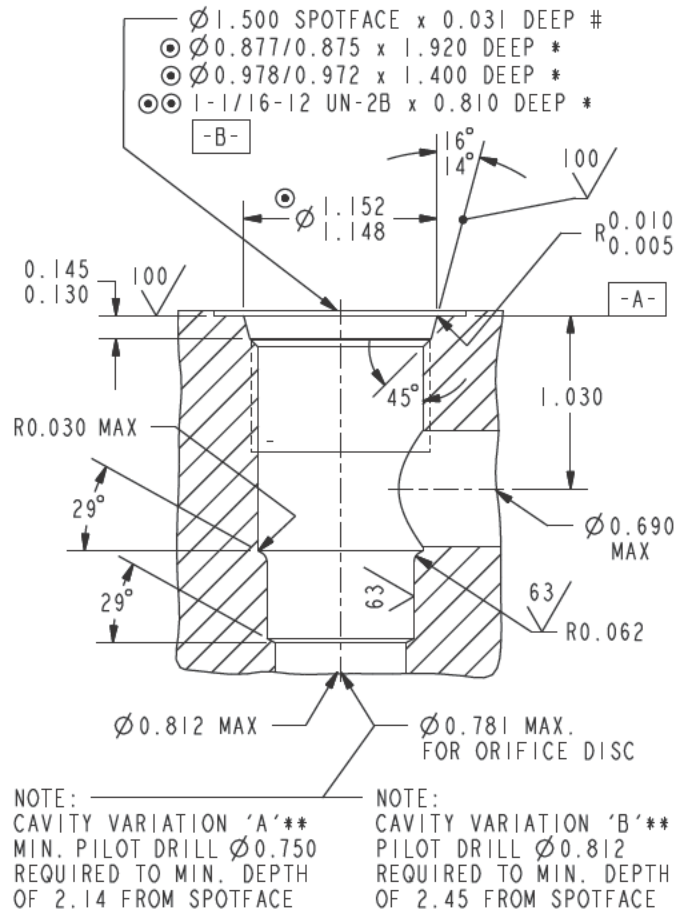


# Series 12 Cartridge Cavities

## VC12-2



### NOTES:

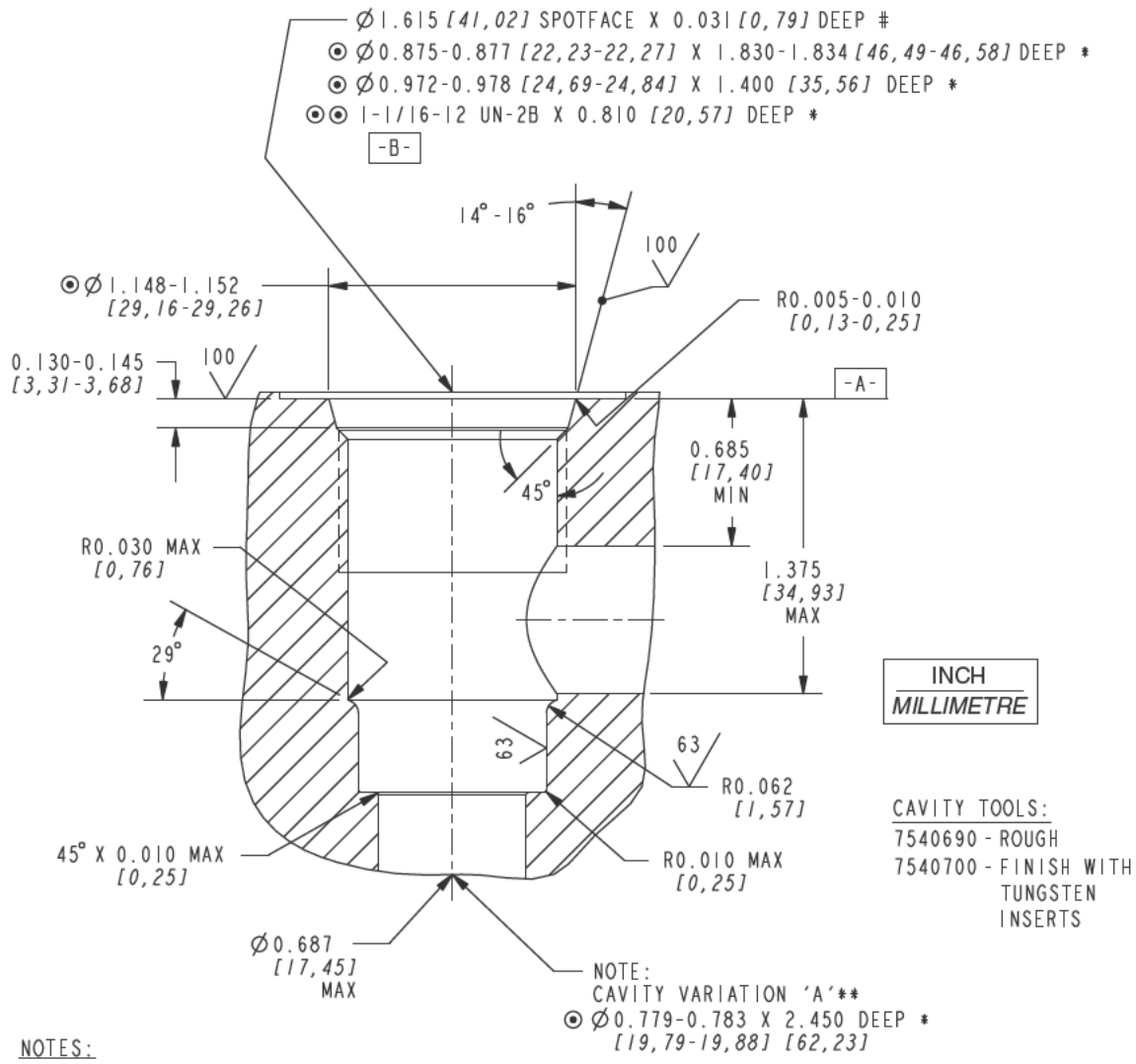
- THE ABOVE FEATURES (EXCEPT FOR PILOT DRILL AND CROSS DRILLS) CAN BE MACHINED SIMULTANEOUSLY USING HYDRAFORCE FORM TOOLS. CONSULT FACTORY.



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

# Series 12 Cartridge Cavities

## HVC12-2



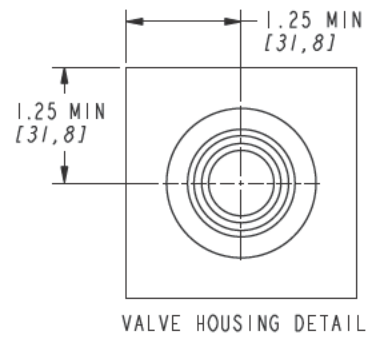
NOTES:

- $\odot$  - 

	0.001 [0,025]	A
↗	0.002 [0,05]	B
- $\odot \odot$  - 

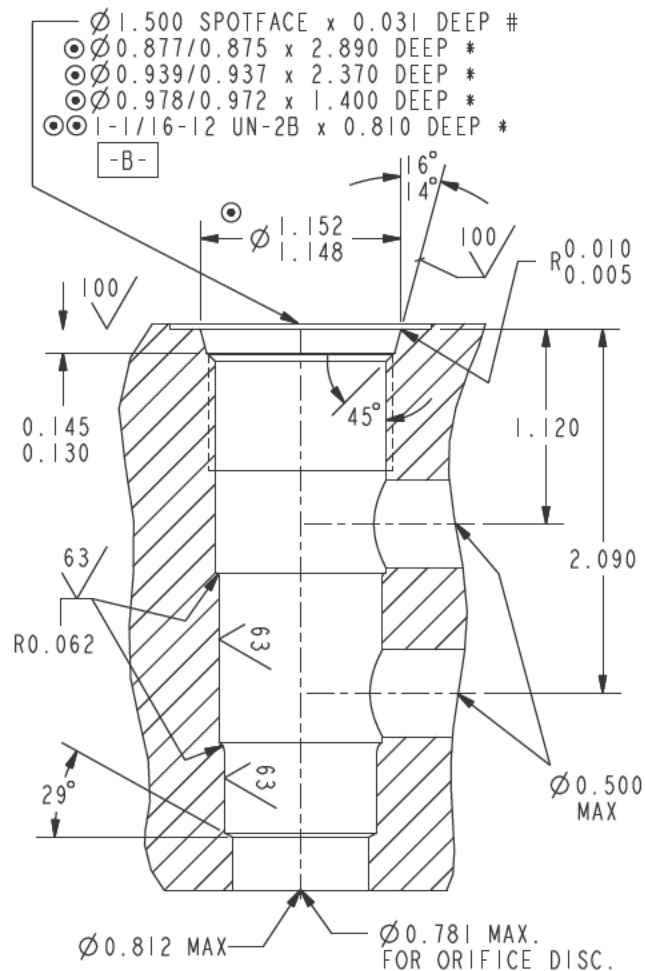
	0.001 [0,025]	A
○	0.0009 [0,023]	(PITCH DIA)

- \* - DEPTHS ARE FROM DATUM -A- .
- # - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.
- UNSPECIFIED TOLERANCES ARE  $\pm 0.005 [0,13]$ .
- UNSPECIFIED ANGULAR DIMENSIONS  $\pm 3^\circ$ .
- SURFACE FINISH SPECIFICATIONS ARE IN MICROINCHES [MICROMETERS].



# Series 12 Cartridge Cavities

## VC12-3



### NOTES:

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

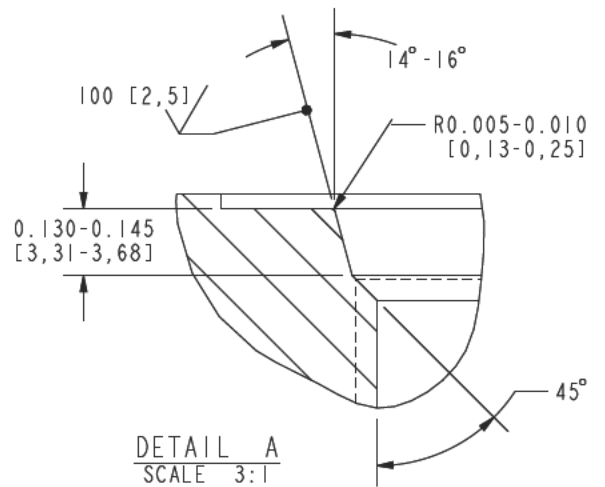
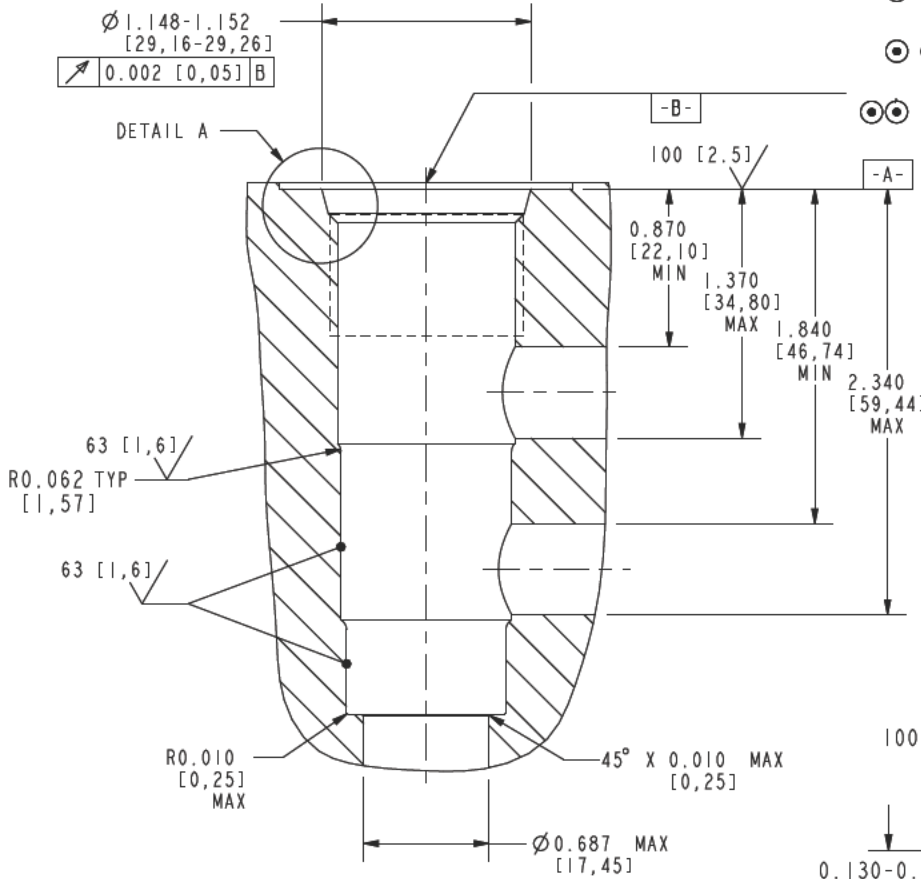
$\odot$	$\frac{\text{A}}{\text{B}}$	0.001	A	$\odot\odot$	$\frac{\text{A}}{\text{B}}$	0.001	A
	$\frac{\text{A}}{\text{B}}$	0.002	B		$\frac{\text{A}}{\text{B}}$	0.0009	(PITCH DIA)

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

# Series 12 Cartridge Cavities

## HVC12-3

- ∅ 1.615 SPOTFACE X 0.031 DEEP \*  
[41,02] [0,79]
- ⊙ ∅ 0.875-0.877 X 2.888-2.892 DEEP \*  
[22,23-22,27] [73,36-73,45]
- ⊙ ∅ 0.937-0.939 X 2.370 DEEP\*  
[23,80-23,85] [60,20]
- ⊙ ∅ 0.972-0.978 X 1.400 DEEP\*  
[24,69-24,84] [35,56]
- ⊙⊙ 1-1/16-12 UN-2B X 0.810 DEEP\*  
[20,57]



NOTES:

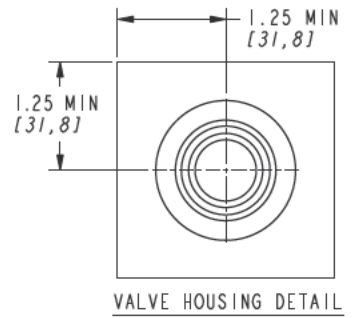
- ⊙ - 

0.001	[0,025]	A
0.002	[0,05]	B
- ⊙⊙ - 

0.001	[0,025]	A
0.0009	[0,023]	(PITCH DIA)

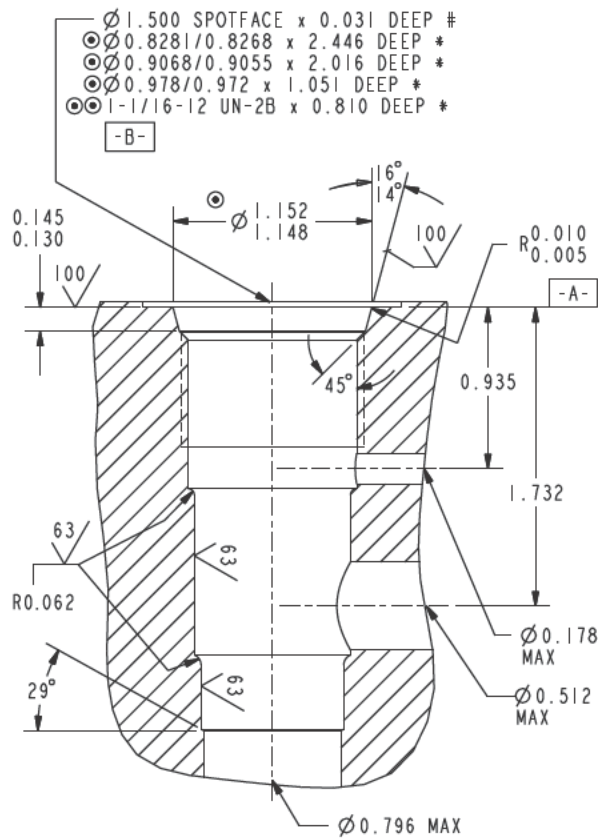
- \* - DEPTHS ARE FROM DATUM -A- .
- # - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.
- UNSPECIFIED TOLERANCES ARE ±0.005 [0,13].
- UNSPECIFIED ANGULAR DIMENSIONS ±3°.
- SURFACE FINISH SPECIFICATIONS ARE IN MICROINCHES [MICROMETERS].

CAVITY TOOLS:  
 7540850 - ROUGH  
 7540860 - FINISH WITH TUNGSTEN INSERTS  
 7540865 - FINISH

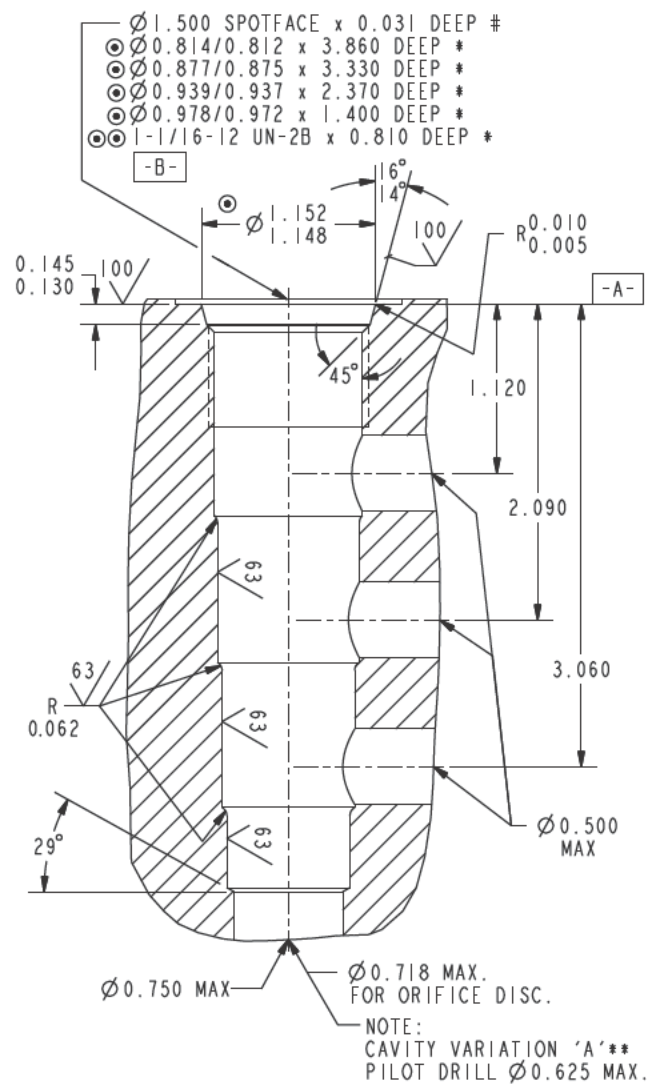


# Series 12 Cartridge Cavities

## VC12-S3



## VC12-4



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

$\varnothing$	0.001	A	$\varnothing$	0.001	A
$\nabla$	0.002	B	$\varnothing$	0.0009	(PITCH DIA)

\* - DEPTHS ARE FROM DATUM -A- .

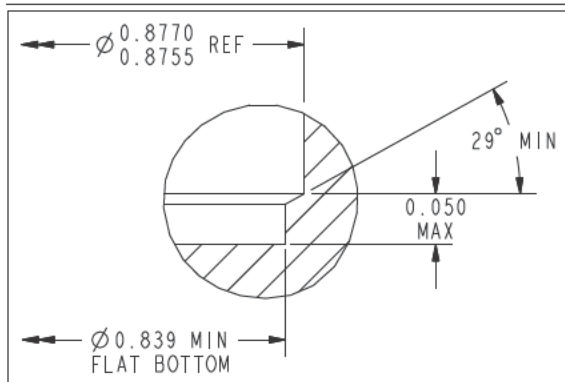
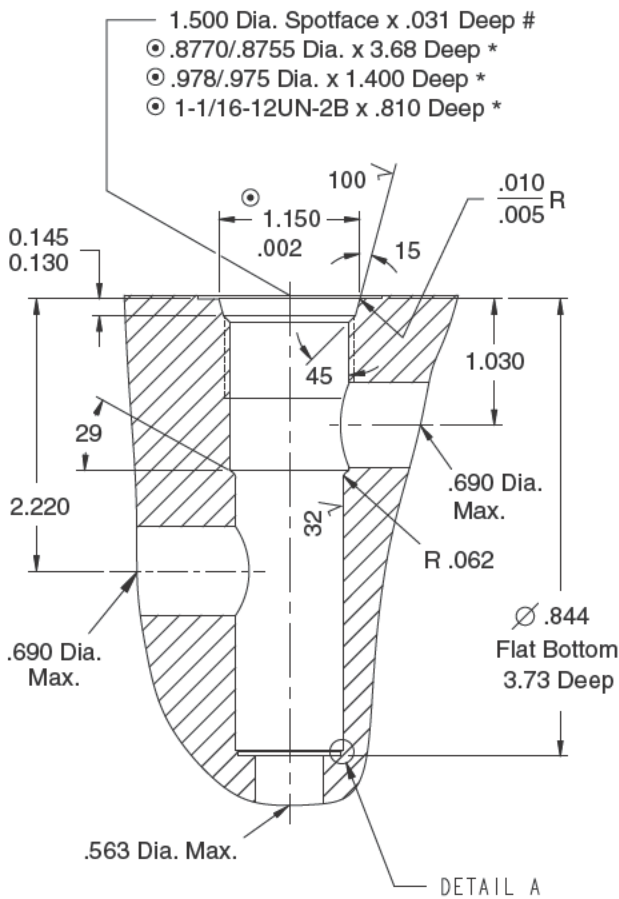
# - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.

- UNSPECIFIED TOLERANCES ARE  $\pm 0.005$ . - UNSPECIFIED ANGULAR DIMENSIONS  $\pm 3^\circ$ .

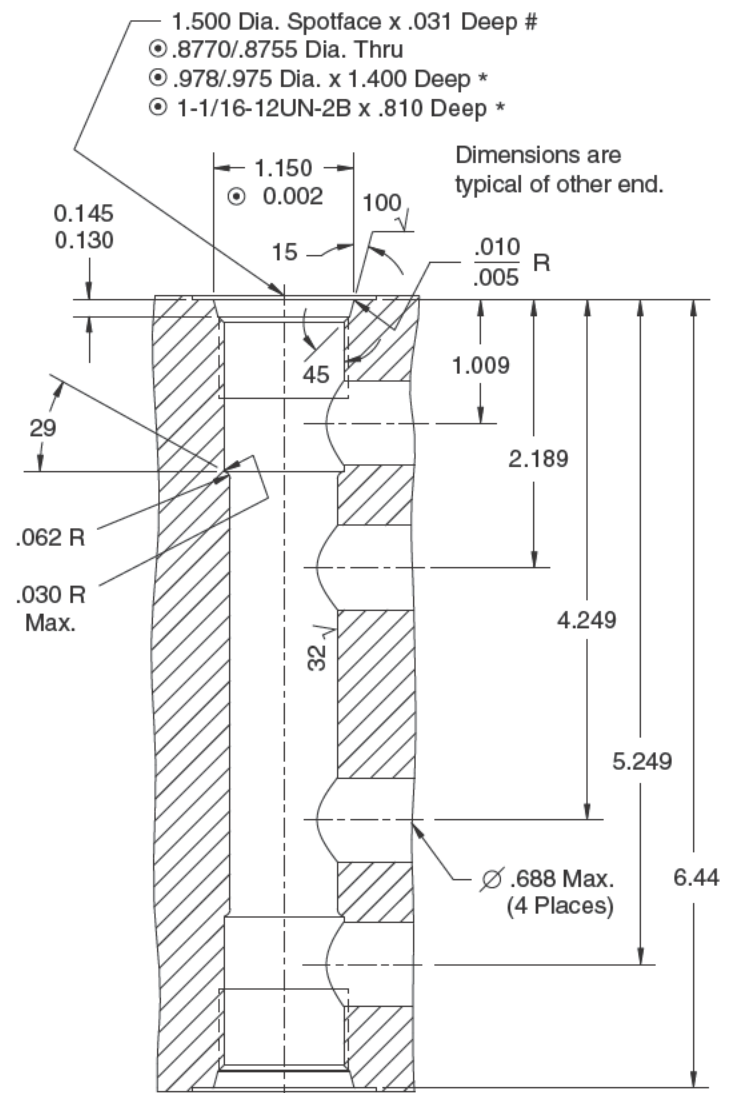
\*\* - FEATURES OF VARIATION 'A' ARE ONLY REQUIRED IF NOTED ON A SPECIFIC PRODUCT CATALOG PAGE.

# Series 12 Cartridge Cavities

## VC12-PCV



## VC12-DCV



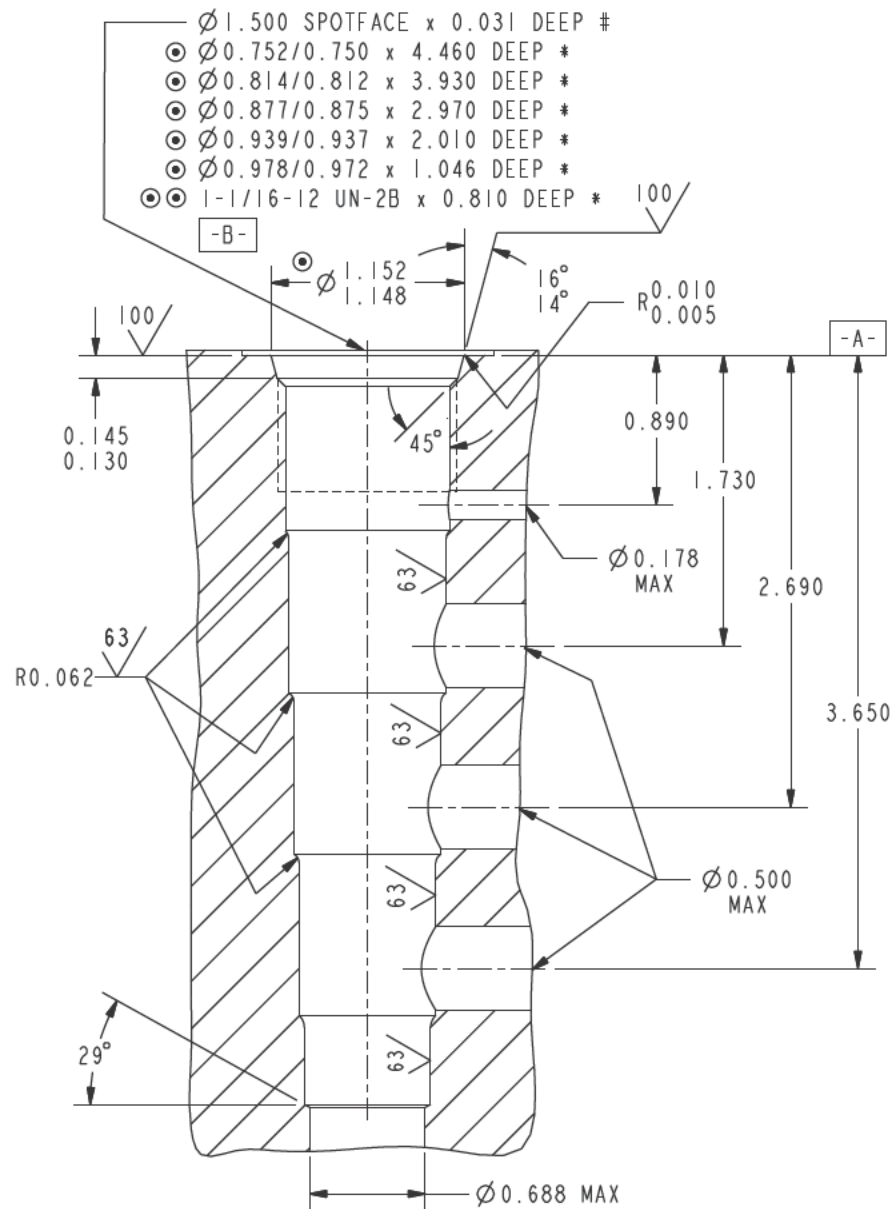
**Notes:**

- ◎ 1. These Diameters to be Concentric within .002 T.I.R. and Perpendicular to Spotface within .001 T.I.R.
- \* 2. Depths are from Spotface.
- 3. Unspecified Tolerances are .005.
- # 4. Unless Otherwise Specified on Machining Drawing
- 5. All Dimensions shown in inches unless otherwise noted.

Cavity features (except for pilot drill and cross drills) can be machined simultaneously using HydraForce form tools. Consult factory.

# Series 12 Cartridge Cavities

## VC12-S5



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

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

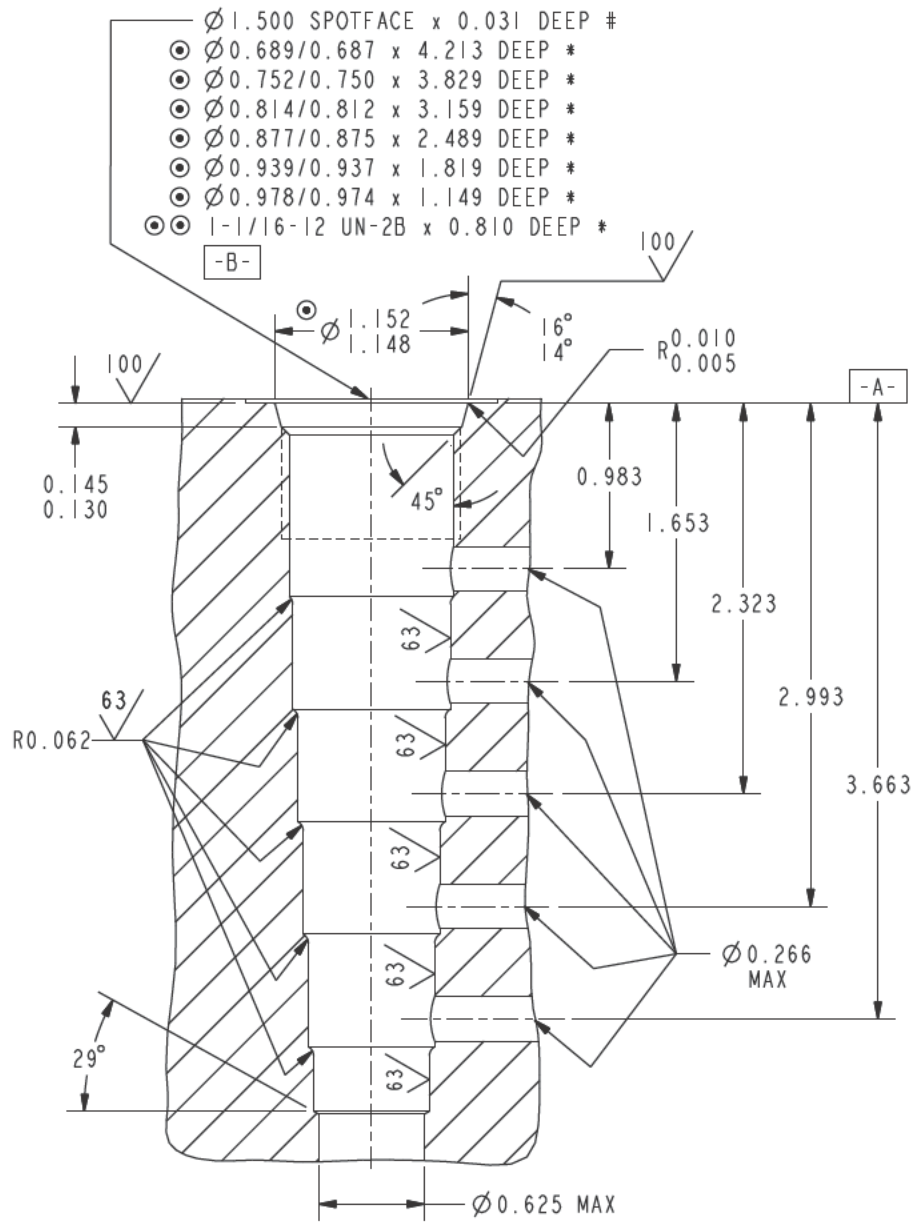
\* - DEPTHS ARE FROM DATUM -A- .

# - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.

- UNSPECIFIED TOLERANCES ARE  $\pm 0.005$ . - UNSPECIFIED ANGULAR DIMENSIONS  $\pm 3^\circ$ .

# Series 12 Cartridge Cavities

## VC12-6



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
↗	0.002	B

 $\odot \odot$  - 

	0.001	A
○	0.0009	

 (PITCH DIA)

\* - DEPTHS ARE FROM DATUM -A- .

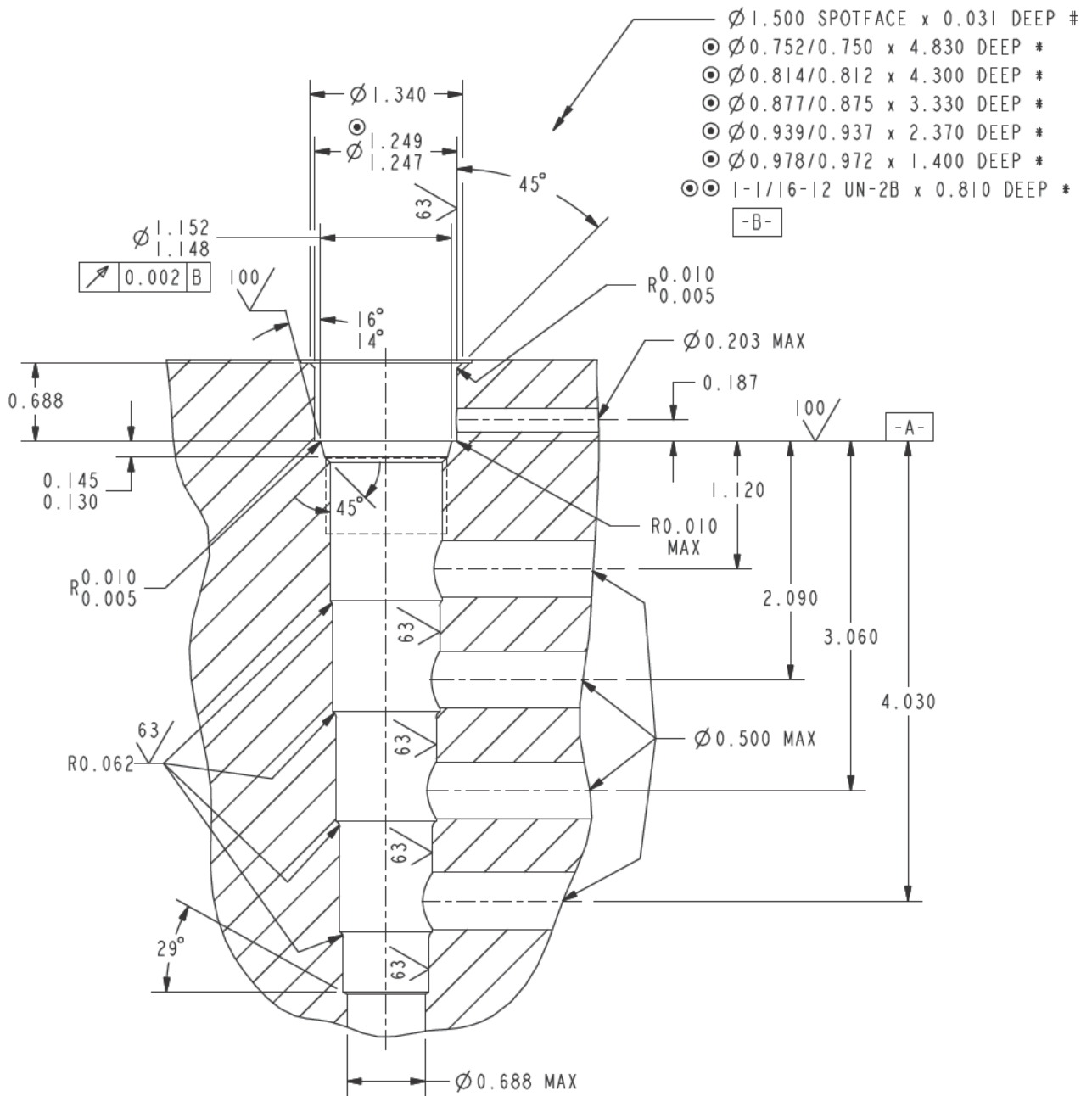
# - UNLESS OTHERWISE SPECIFIED ON MACHINING DRAWING.

- UNSPECIFIED TOLERANCES ARE  $\pm 0.005$ . - UNSPECIFIED ANGULAR DIMENSIONS  $\pm 3^\circ$ .



# Series 12 Cartridge Cavities

## VC12-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 ±3° .